

Garant
Milling insert 60°, HB7720, Pitch: M20X2,5mm

Order data

Order number	217505 M20X2,5
GTIN	4045197284785
Item class	21C

Description
Note:

55° inserts on request. Corrected profile threading inserts eliminate the need to program a correction to the diameter. (See cutting data and notes in the machining handbook). This means that these inserts can be used only for the specified thread.

Technical description

for threads \geq	only M20×2.5 corrected profile
Insert thickness E	3.5 mm
Depth t	1.444 mm
Insert geometry	Full profile
External \varnothing D	16 mm
Number of clamping slots	3
Thread pitch	2.5 mm
Application	Internal
Grade	HB7720

Tool material	Carbide
Thread type	M
Thread type	MF
Thread type	MF-LH
Thread type	M-LH
Flank angle	60 degrees
Type	02
Number of cutting edges Z	3
Cutting direction	right-hand and left-hand
Type of product	Cutter insert for circular milling

User data

	Suitability	V _c	ISO code
Alu plastics	suitable	600 m/min	N
Aluminium (short chipping)	suitable	500 m/min	N
Alu > 10% Si	suitable	400 m/min	N
Steel < 500 N/mm ²	suitable	260 m/min	P
Steel < 750 N/mm ²	suitable	220 m/min	P
Steel < 900 N/mm ²	suitable	180 m/min	P
Steel < 1100 N/mm ²	suitable	100 m/min	P
Steel < 1400 N/mm ²	suitable	80 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	60 m/min	H
Steel < 60 HRC	suitable only under restricted conditions	45 m/min	H
Steel < 65 HRC	suitable only under restricted conditions	35 m/min	H
Steel < 67 HRC	suitable only under restricted conditions	30 m/min	H

INOX < 900 N/mm ²	suitable only under restricted conditions	130 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	120 m/min	M
Ti > 850 N/mm ²	suitable	100 m/min	S
GG(G)	suitable only under restricted conditions	120 m/min	K
Uni	suitable		
wet maximum	suitable		
dry	suitable only under restricted conditions		