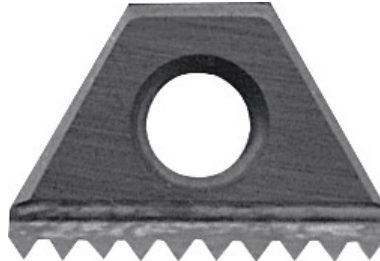


Garant**Thread milling insert for internal and external threads 55°, HB7720, Threads per inch: 14****Order data**

Order number	218020 14
GTIN	4045197412300
Item class	21D

Description**Version:**

Sturdy inserts. **Two usable edges.**

- **Wide range of applications thanks to universal chip breaker geometry.**
- **High repetition accuracy.**

Application:

For internal and external threads 55° to standard BS 84: 1956, DIN 259, ISO 228/1:1982.
Tolerance medium, class A.</crf>

Technical description

Internal/external application	Internal
Internal/external application	External
Threads per inch	14
Thread pitch	1.814 mm
Number of cutting edges Z	5
Grade	HB7720
Tool material	Carbide

Thread type	BSP-LH
Thread type	BSP
Thread type	BSW
Thread type	BSW-LH
Thread type	G
Thread type	G-LH
Flank angle	55 °
Insert size	11 mm
Feed f_z in steel < 1100 N/mm ²	0.1 mm
Feed f_z in INOX < 900 N/mm ²	0.05 mm
Cutting direction	right-hand and left-hand
Type of product	Cutter insert for milling

User data

	Suitability	V_c	ISO code
Alu plastics	suitable only under restricted conditions	140 m/min	N
Aluminium (short chipping)	suitable	120 m/min	N
Alu > 10% Si	suitable	80 m/min	N
Steel < 500 N/mm ²	suitable	120 m/min	P
Steel < 750 N/mm ²	suitable	110 m/min	P
Steel < 900 N/mm ²	suitable	100 m/min	P
Steel < 1100 N/mm ²	suitable	80 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	60 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	80 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	70 m/min	M

GG(G)	suitable only under restricted conditions	70 m/min	K
CuZn	suitable	120 m/min	N
Uni	suitable		
wet maximum	suitable		