

Garant
Thread milling insert for internal threads 60°, HB7720, Pitch: 1,5mm

Order data

Order number	218009 1,5
GTIN	4045197412102
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 metric internal threads to DIN / ISO (DIN 13) tolerance class 6H.

Technical description

Internal/external application	Internal
Full profile	yes
Thread pitch	1.5 mm
Number of cutting edges Z	17
Grade	HB7720
Tool material	Carbide
Thread type	M-LH
Thread type	M
Thread type	MF-LH

Thread type	MF
Flank angle	60 degrees
Insert size	27 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		

