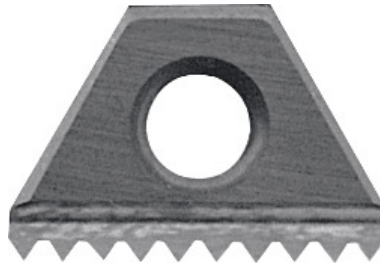


**Garant**
**Thread milling insert for internal threads 60°, HB7720, Pitch: 4mm**

**Order data**

Order number	218009 4
GTIN	4045197412201
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	4 mm
Number of cutting edges Z	6
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 <sup>2</sup>	0.1 mm
Feed $f_z$ in INOX < 900 N/mm <sup>2</sup>	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 <sup>2</sup>	suitable	120 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	110 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	100 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	60 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	80 m/min	M
INOX > 900 N/mm <sup>2</sup>	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		

