

**Garant**
**Milling insert for internal threads 60°, HB7720, Pitch: 2,5mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 218057 2,5    |
| GTIN         | 4045197447289 |
| Item class   | 21D           |

**Description**
**Version:**

**Sturdy** milling inserts for **high feed rates** and **high productivity**.

Single-edged.

**Application:**

**For metric internal threads 60°** to DIN / ISO R 262 (DIN 13) tolerance class 6g.

**Note:**

Always fit the thread milling inserts with the marks matching, otherwise the thread will be distorted! (Sides have either a mark or no mark).

Feed  $f_z = \text{HB 7720 in steel} < 750 \text{ N/mm}^2 = 0.25 \text{ mm / tooth}$ .

Feed  $f_z = \text{HB 7735 in INOX} > 900 \text{ N/mm}^2 = 0.15 \text{ mm / tooth}$ .

**Technical description**

|                               |               |
|-------------------------------|---------------|
| Internal/external application | Internal      |
| Full profile                  | yes           |
| Thread pitch                  | 2.5 mm        |
| suitable for threads          | M18; M20; M22 |

|                           |                           |
|---------------------------|---------------------------|
| Number of cutting edges Z | 10                        |
| Grade                     | HB7720                    |
| Tool material             | Carbide                   |
| Thread type               | M                         |
| Thread type               | M-LH                      |
| Thread type               | MF                        |
| Thread type               | MF-LH                     |
| Flank angle               | 60 degrees                |
| Insert size               | 24 mm                     |
| Cutting direction         | right-hand and left-hand  |
| Type of product           | Cutter insert for milling |

## User data

|                                | Suitability                               | V <sub>c</sub> | 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                                  | 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        |
| Ti > 850 N/mm <sup>2</sup>     | suitable                                  | 40 m/min       | S        |

|                    |   |           |   |
|--------------------|---|-----------|---|
| GG(G)              | suitable only under restricted conditions | 70 m/min  | K |
| CuZn               | suitable                                  | 120 m/min | N |
| Graphite, GRP, CRP | suitable                                  | 120 m/min | N |
| Uni                | suitable                                  |           |   |
| wet maximum        | suitable                                  |           |   |