

Garant
Milling insert for internal threads 60°, HB7735, Pitch: 3mm

Order data

| | |
|--------------|---------------|
| Order number | 218061 3 |
| GTIN | 4045197412638 |
| Item class | 21D |

Description
Version:

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

Double-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 |
| Coating | TiAlN |
| Thread pitch | 3 mm |

| | |
|---------------------------|---------------------------|
| suitable for threads | M24; M27 |
| Number of cutting edges Z | 10 |
| Grade | HB7735 |
| Tool material | Carbide |
| Thread type | M |
| Thread type | M-LH |
| Thread type | MF |
| Thread type | MF-LH |
| Flank angle | 60 degrees |
| Insert size | 25 mm |
| Cutting direction | right-hand and left-hand |
| Type of product | Cutter insert for milling |

User data

| | Suitability | V _c | ISO code |
|--------------------------------|-------------------------------------------|----------------|----------|
| Steel < 500 N/mm ² | suitable only under restricted conditions | 120 m/min | P |
| Steel < 750 N/mm ² | suitable only under restricted conditions | 110 m/min | P |
| Steel < 900 N/mm ² | suitable only under restricted conditions | 100 m/min | P |
| Steel < 1100 N/mm ² | suitable | 80 m/min | P |
| Steel < 1400 N/mm ² | suitable | 60 m/min | P |
| Steel < 55 HRC | suitable only under restricted conditions | 25 m/min | H |
| Steel < 60 HRC | suitable only under restricted conditions | 20 m/min | H |
| INOX < 900 N/mm ² | suitable | 80 m/min | M |
| INOX > 900 N/mm ² | suitable | 70 m/min | M |
| GG(G) | suitable | 70 m/min | K |

| | | | |
|-------------|-------------------------------------------|-----------|---|
| CuZn | suitable only under restricted conditions | 120 m/min | N |
| Oil | suitable only under restricted conditions | | |
| wet maximum | suitable | | |
| wet minimum | suitable | | |
| dry | suitable only under restricted conditions | | |
| Air | suitable only under restricted conditions | | |