

**Garant**
**Milling insert for internal and external threads 55°, HB7720, Threads per inch: 14**

**Order data**

Order number	218077 14
GTIN	4045197447654
Item class	21D

**Description**
**Version:**

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

Single-edged.

**Application:**

**For internal and external threads 55°** to standard BS 84: 1956, DIN 259, ISO 228/1: 1982.

Tolerance class Medium Class A.

**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
Internal/external application	External

Threads per inch	14
Coating	TiAlN
Thread pitch	1,814 mm
Number of cutting edges Z	13
Grade	HB7720
Tool material	Carbide
Thread type	BSP
Thread type	G
Thread type	BSW
Thread type	BSP-LH
Thread type	G-LH
Thread type	BSW-LH
Flank angle	55 °
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		