

Garant
Milling insert for internal and external threads 55°, HB7720, Threads per inch: 19

Order data

| | |
|--------------|---------------|
| Order number | 218077 19 |
| GTIN | 4045197447661 |
| 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 | 19 |
| Coating | TiAlN |
| Thread pitch | 1.336 mm |
| Number of cutting edges Z | 18 |
| 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 _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 | 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 |
| Ti > 850 N/mm ² | 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 | | |