

Garant

Milling insert for internal and external threads 55°, HB7735, Threads per inch: 14



Order data

Order number	218078 14
GTIN	4045197447678
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	HB7735
Tool material	Carbide
Thread type	BSP-LH
Thread type	BSW-LH
Thread type	G-LH
Thread type	BSP
Thread type	G
Thread type	BSW
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
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		