

## Garant

### Carbide inserts for axial grooving right-hand, TiAlN-PVD, Ø Dmin groove D1/ D2: 8/12Lmm



#### Order data

Order number	274061 8/12L
GTIN	4067263355496
Item class	21L

#### Description

##### Version:

With through-coolant and additional flank face cooling.

##### Attention:

Order size = minimum groove Ø.

Larger groove diameters can be achieved without modification.

$D_1 = D_{min}$  internal diameter.

$D_2 = D_{min}$  external diameter.

L version with greater grooving depth  $t_{max}$ .

#### Technical description

Shank Ø $D_s$	6 mm
Groove width $w$	2 mm
Feed $f$	0.01 - 0.03 mm
maximum cutting depth $t_{max}$	22 mm
Tip centre offset $L_3$	1.7 mm
Overall length $L$	64 mm
Through-coolant	yes
Coating	TiAlN-PVD
Type of product	Cutter insert for turning

## User data

	Suitability	$V_c$	ISO code
Alu plastics	suitable	50 m/min	N
Aluminium (short chipping)	suitable	90 m/min	N
Alu > 10% Si	suitable	70 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	55 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	55 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	50 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	40 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	35 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	45 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	45 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable only under restricted conditions	25 m/min	S
GG(G)	suitable only under restricted conditions	55 m/min	K
CuZn	suitable only under restricted conditions	50 m/min	N
continuous	suitable		
wet maximum	suitable		