

Garant
**Carbide inserts for axial grooving left-hand, TiAlN-PVD, Ø Dmin groove D1/
D2: 12/20mm**

Order data

Order number	274063 12/20
GTIN	4067263558798
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

maximum cutting depth t_{max}	43 mm
Feed f	0.01 - 0.03 mm
Overall length L	80 mm
Tip centre offset L_3	1.6 mm
Groove width w	4 mm
Shank Ø D_s	8 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 ²	suitable	55 m/min	P
Steel < 750 N/mm ²	suitable	55 m/min	P
Steel < 900 N/mm ²	suitable	50 m/min	P
Steel < 1100 N/mm ²	suitable	40 m/min	P
Steel < 1400 N/mm ²	suitable	35 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	45 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	45 m/min	M
Ti > 850 N/mm ²	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		