

Garant**Mini insert for internal threading right-hand, HB720, Pitch: 1,25mm****Order data**

Order number	270140 1,25
GTIN	4045197560537
Item class	21I

Technical description

Insert size $\varnothing d$	6 mm
Pitch	1.25 mm
Pitch angle	2.5 degrees
Insert thickness T	3.8 mm
Minimum advance h_{\min}	0.72 mm
Thread tip-face distance Y	0.8 mm
Tip centre offset L_3	4.44 mm
Number of passes	5 - 9
Thread type	M/MF
Grade	HB720
Flank angle	60 degrees
Standard	DIN 13

Type of product

Mini indexable insert

User data

	Suitability	V_c	ISO code
Alu plastics	suitable only under restricted conditions	80 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	80 m/min	N
Alu > 10% Si	suitable only under restricted conditions	60 m/min	N
Steel < 500 N/mm ²	suitable	80 m/min	P
Steel < 750 N/mm ²	suitable	80 m/min	P
Steel < 900 N/mm ²	suitable	80 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	70 m/min	M
INOX > 900 N/mm ²	suitable	50 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	30 m/min	S
GG(G)	suitable	60 m/min	K
CuZn	suitable	80 m/min	N
continuous	suitable		
irregular	suitable only under restricted conditions		
interrupted	suitable only under restricted conditions		
wet maximum	suitable		