

Garant
Boring-out insert, internal, right-hand, L1 = 35 mm, Ø Dmin: 5,2mm

Order data

Order number	270222 5,2
GTIN	4045197466228
Item class	211

Description
Application:

For cutter holder No. 270200 – 270204.

Technical description

Minimum $\varnothing D_{\min}$	5.2 mm
maximum cutting depth t_{\max}	0.5 mm
Shank $\varnothing d$	5 mm
Tip centre offset L_3	2.45 mm
Radius R	0.2 mm
Feed f in stainless steel $> 900 \text{ N/mm}^2$	0,015 mm/rev.
Feed f in stainless steel $< 900 \text{ N/mm}^2$	0,015 mm/rev.
Feed f in steel $< 1100 \text{ N/mm}^2$	0.028 mm/rev.
Overhang L_1	35 mm
Product name attribute	$L_1 = 35 \text{ mm}$
Type of product	Cutter insert for turning

User data

	Suitability	V_c	ISO code
--	-------------	-------	----------

Alu plastics	suitable only under restricted conditions	250 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	200 m/min	N
Alu > 10% Si	suitable only under restricted conditions	200 m/min	N
Steel < 500 N/mm ²	suitable	160 m/min	P
Steel < 750 N/mm ²	suitable	150 m/min	P
Steel < 900 N/mm ²	suitable	150 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	30 m/min	H
INOX < 900 N/mm ²	suitable	90 m/min	M
INOX > 900 N/mm ²	suitable	60 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	30 m/min	S
GG(G)	suitable	90 m/min	K
CuZn	suitable	150 m/min	N
continuous	suitable		
irregular	suitable only under restricted conditions		
interrupted	suitable only under restricted conditions		
wet maximum	suitable		