

Garant
Boring-out insert, internal, left-hand, L1 = 10 mm, Ø Dmin: 1,5mm

Order data

Order number	270242 1,5
GTIN	4045197466266
Item class	211

Description
Application:

For cutter holder No. 270200 – 270204.

Technical description

maximum cutting depth t_{max}	0.15 mm
Shank $\varnothing d$	4 mm
Tip centre offset L_3	0.69 mm
Minimum $\varnothing D_{min}$	1.5 mm
Radius R	0.1 mm
Feed f in stainless steel > 900 N/mm ²	0,015 mm/rev.
Feed f in stainless steel < 900 N/mm ²	0,015 mm/rev.
Feed f in steel < 1100 N/mm ²	0,015 mm/rev.
Overhang L_1	10 mm
Product name attribute	$L_1 = 10$ mm
Type of product	Cutter insert for turning

User data

	Suitability	V_c	ISO code
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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		