

**Garant**
**Boring-out insert, internal, right-hand, L1 = 10 mm, Ø Dmin: 4,2mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 270212 4,2    |
| GTIN         | 4045197466068 |
| Item class   | 211           |

**Description**
**Application:**

For cutter holder No. 270200 – 270204.

**Technical description**

|   |                           |
|---|---------------------------|
| Shank Ø d   | 4 mm                      |
| Tip centre offset L <sub>3</sub>                  | 1.95 mm                   |
| Minimum Ø D <sub>min</sub>                        | 4.2 mm                    |
| maximum cutting depth t <sub>max</sub>            | 0.3 mm                    |
| Radius R  | 0.15 mm                   |
| Feed f in steel < 1100 N/mm <sup>2</sup>          | 0.020 mm/rev.             |
| Feed f in stainless steel > 900 N/mm <sup>2</sup> | 0,015 mm/rev.             |
| Feed f in stainless steel < 900 N/mm <sup>2</sup> | 0,015 mm/rev.             |
| Overhang L <sub>1</sub>                           | 10 mm                     |
| Product name attribute                            | L <sub>1</sub> = 10 mm    |
| Type of product                                   | Cutter insert for turning |

**User data**

|  | Suitability | V <sub>c</sub> | 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 <sup>2</sup>  | suitable                                  | 160 m/min | P |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 150 m/min | P |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 150 m/min | P |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 80 m/min  | P |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 60 m/min  | P |
| Steel < 55 HRC                 | suitable only under restricted conditions | 30 m/min  | H |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 90 m/min  | M |
| INOX > 900 N/mm <sup>2</sup>   | suitable                                  | 60 m/min  | M |
| Ti > 850 N/mm <sup>2</sup>     | 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                                  |           |   |