

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

Order data

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|--------------|---------------|
| Order number | 270242 4,2 |
| GTIN | 4045197466297 |
| Item class | 211 |

Description
Application:

For cutter holder No. 270200 – 270204.

Technical description

| | |
|---|---------------------------|
| Tip centre offset L_3 | 1.95 mm |
| Minimum $\varnothing D_{min}$ | 4.2 mm |
| Shank $\varnothing d$ | 4 mm |
| maximum cutting depth t_{max} | 0.3 mm |
| Radius R | 0.15 mm |
| Feed f in stainless steel > 900 N/mm ² | 0,015 mm/rev. |
| Feed f in steel < 1100 N/mm ² | 0.020 mm/rev. |
| Feed f in stainless steel < 900 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 | | |