

**Garant**
**Boring-out insert, internal, left-hand, L1 = 10 mm, Ø Dmin: 5,2mm**

**Order data**

Order number	270242 5,2
GTIN	4045197466303
Item class	211

**Description**
**Application:**

For cutter holder No. 270200 – 270204.

**Technical description**

maximum cutting depth $t_{max}$	0.5 mm
Tip centre offset $L_3$	2.45 mm
Shank $\varnothing d$	5 mm
Minimum $\varnothing D_{min}$	5.2 mm
Radius R	0.2 mm
Feed f in steel < 1100 N/mm <sup>2</sup>	0.028 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 $L_1$	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 <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		