

Garant

Thread turning insert, internal, full profile 60°, right-hand, L1 = 16 mm, Ø Dmin / Pitch: 4/0,8mm


Order data

Order number	270400 4/0,8
GTIN	4045197467423
Item class	21I

Description
Application:

For cutter holder No. 270200 – 270204.

Technical description

Minimum Ø D _{min}	4 mm
Minimum advance h _{min}	0.46 mm
Thread tip-face distance Y	0.6 mm
Tip centre offset L ₃	0.9 mm
Tolerance class	DIN 13 6H
Shank Ø d	4 mm
Overhang L ₁	16 mm
Product name attribute	L ₁ = 16 mm
Flank angle	60 degrees
Thread type	M
Thread type	MF
Type of product	Thread turning insert

User data

	Suitability	V_c	ISO code
Alu plastics	suitable only under restricted conditions	200 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	200 m/min	N
Alu > 10% Si	suitable only under restricted conditions	150 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		
wet maximum	suitable		