

**Garant****Full profile insert 55°, internal, right-hand, HB7010, TPI: 28****Order data**

Order number	270820 28
GTIN	4045197370686
Item class	21J

**Description****Version:**

- **Maximum cutting edge reliability, thanks to strong and negative indexable insert.**
- **Wide application range due to optimised universal chip breaker geometry.**
- **Very high repeatability because precision sintered and precision ground.**
- **Compatible with the following insert sizes from other manufacturers:**

**Size 9.3 (L)**, 2 cutting edges: 5 mm (IC).

**Full profile insert 55°** for internal threads standard B.S.84: 1956, DIN 259, ISO 228/1: 1982, tolerance class medium class A. The inner  $\varnothing$  is cut with the profile.

**Technical description**

Number of turns/inch	28
Tool material	Carbide
Application type	right-hand
Internal/external application	inner
Indexable insert profile	Full profile

Grade	HB7010
Thread type	BSW
Thread type	BSP
Thread type	BSP-LH
Thread type	BSW-LH
Thread type	G
Thread type	G-LH
Flank angle	55 degrees
Thickness	2.42 mm
Insert size L	9.3 mm
Type of product	Indexable insert for thread turning

## User data

	Suitability	V <sub>c</sub>	ISO code
Aluminium (short chipping)	suitable	250 m/min	N
Alu > 10% Si	suitable	180 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	150 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	150 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	130 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	100 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	40 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	100 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	100 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable only under restricted conditions	50 m/min	S

GG(G)	suitable	130 m/min	K
CuZn	suitable only under restricted conditions	150 m/min	N
continuous	suitable		
wet maximum	suitable		
dry	suitable only under restricted conditions		