

**Garant****WNGA 080412, BU7220, Cutting edge version: G****Order data**

Order number	255481 G
GTIN	4045197895493
Item class	21H

**Description****Version:**

Fitted with 3 cutters.

**Description:**

New type of CBN with a balanced combination wear-resistance and tensile strength for general-purpose use in hardened steel up to 67 HRC in combination with a special constitution. For use both in continuous cutting and also in slightly interrupted and heavily interrupted cutting.

Grade: BU7220

Cutting edge version: G

Cutting depth  $a_p$ : 0.05 - 0.2 mm

Feed  $f$ : 0.05 - 0.15 mm/rev.

Cutting speed  $v_c$  main application: 90 - 140 m/min

**Technical description**

Cutting depth $a_p$	0.05 - 0.2 mm
Finishing/roughing assignment	Finishing
Tool material	CBN

Feed f	0.05 - 0.15 mm/rev.
Grade	BU7220
Cutting conditions	heavily interrupted
Cutting conditions	slightly interrupted
Cutting conditions	continuous
Corner radius	1.2 mm
Cutting speed $v_c$ main application	90 - 140 m/min
Cutting edge version	G
ISO code indexable insert	WNGA 080412
Number of changes/inserts	3
Product name attribute	BU7220
Type of product	Indexable insert for turning

## User data

	Suitability	$V_c$	ISO code
Steel < 55 HRC	suitable		
Steel < 60 HRC	suitable		
Steel < 67 HRC	suitable		
continuous	suitable		
irregular	suitable		
interrupted	suitable		
dry	suitable		