Garant

Micro boring-out insert, internal, right-hand, L1 = 26 mm, ⌀ Dmin: 4,2mm

Order data

Order number	270218 4,2
GTIN	4045197466174
Item class	21I

Description

Application:
For cutter holder No. 270200 – 270204.

Technical description

Shank ⌀ d	4 mm
maximum cutting depth t_{max}	0.3 mm
Minimum ⌀ D_{min}	4.2 mm
Tip centre offset L_3	1.95 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.
Series	Micro

Overhang L_1	26 mm
Product name attribute	L_1 = 26 mm
Type of product	Cutter insert for turning

User data

	Suitability	V_c	ISO code
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/mm²	suitable	160 m/min	P
Steel < 750 N/mm²	suitable	150 m/min	P
Steel < 900 N/mm²	suitable	150 m/min	P
Steel < 1100 N/mm²	suitable	80 m/min	P
Steel < 1400 N/mm²	suitable	60 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	30 m/min	H
INOX < 900 N/mm²	suitable	90 m/min	M
INOX > 900 N/mm²	suitable	60 m/min	M
Ti > 850 N/mm²	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		