

**Garant**
**CNGA 120408, BU7220, Cutting edge version: G**

**Order data**

Order number	255412 G
GTIN	4045197895233
Item class	21H

**Description**
**Version:**

Fitted with 2 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.

Corner radius: 0.8 mm

Grade: BU7220

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

Cutting edge version: G

**Technical description**

Tool material	CBN
Finishing/roughing assignment	Finishing
Corner radius	0.8 mm

Cutting depth $a_p$	0.05 - 0.2 mm
Cutting edge version	G
Feed f	0.05 - 0.15 mm/rev.
Cutting conditions	heavily interrupted
Cutting conditions	continuous
Cutting conditions	slightly interrupted
Cutting speed $v_c$ main application	90 - 140 m/min
Grade	BU7220
ISO code indexable insert	CNGA 120408
Number of changes/inserts	2
Product name attribute	BU7220
Type of product	Indexable insert for turning