

**Garant**
**CCGT 09T304 FN, PCD, Cutting edge version: TWF**

**Order data**

Order number	265817 TWF
GTIN	4045197448958
Item class	21L

**Description**
**Version:**

**PCD** – Polycrystalline diamond, fine grain. Finishing, sharp edges for low cutting pressure.

**Application:**

For aluminium, aluminium alloys, non-ferrous metals, plastics, composite materials, titanium alloys, sintered metals.

Rake: 6 degrees

Grade: PCD

Cutting edge version: TWF

Cutting depth  $a_p$ : 0.3 - 1 mm

Feed  $f$ : 0.03 - 0.2 mm/rev.

Cutting speed  $v_c$  for alu < 10 % Si: 400 - 3500 m/min

Cutting speed  $v_c$  for G(C)RP: 400 - 900 m/min

**Technical description**

Corner radius	0.4 mm
Cutting depth $a_p$	0.3 - 1 mm
Cutting conditions	continuous

Feed f	0.03 - 0.2 mm/rev.
Cutting edge version	TWF
Cutting speed $v_c$ for G(C)RP	400 - 900 m/min
Cutting speed $v_c$ for alu < 10 % Si	400 - 3500 m/min
Grade	PCD
Finishing/roughing assignment	Finishing
Tool material	PCD
ISO code indexable insert	CCGT 09T304 FN
Number of changes/inserts	1
Product name attribute	PCD
Rake	6 degrees
Type of product	Indexable insert for turning