

**Garant**
**CCGT 120404 FN, PCD, Cutting edge version: TWM**

**Order data**

Order number	265827 TWM
GTIN	4045197449016
Item class	21L

**Description**
**Version:**

**PCD** – Polycrystalline diamond, fine grain. General machining, stable cutting edge for high metal removal rates.

**Application:**

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

Rake: 6 degrees

Grade: PCD

Cutting edge version: TWM

Cutting depth  $a_p$ : 0.2 - 2.5 mm

Feed  $f$ : 0.05 - 0.3 mm/rev.

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

Cutting speed  $v_c$  for non-ferrous metals: 300 - 2200 m/min

**Technical description**

Cutting speed $v_c$ for G(C)RP	400 - 900 m/min
Cutting speed $v_c$ for alu < 10 % Si	400 - 3500 m/min

Cutting depth $a_p$	0.2 - 2.5 mm
Cutting edge version	TWM
Corner radius	0.4 mm
Cutting speed $v_c$ for non-ferrous metals	300 - 2200 m/min
Feed $f$	0.05 - 0.3 mm/rev.
Cutting conditions	continuous
Grade	PCD
Finishing/roughing assignment	Skrubbearbejdning-sletbearbejdning
Tool material	PCD
ISO code indexable insert	CCGT 120404 FN
Number of changes/inserts	1
Product name attribute	PCD
Rake	6 degrees
Type of product	Indexable insert for turning