

**Garant****Indexable insert for turning VCGT 110302 FN, PKD (7°), Cutting edge version: TWM****Order data**

Order number	265877 TWM
GTIN	4045197452832
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.

**Technical description**

Feed f	0.05 - 0.3 mm/rev.
Cutting depth $a_p$	0.2 - 2.5 mm
Cutting speed $v_c$ for alu < 10 % Si	400 - 3500 m/min
Cutting edge version	TWM
Cutting conditions	continuous
Cutting speed $v_c$ for non-ferrous metals	300 - 2200 m/min

Corner radius	0.2 mm
Cutting speed $v_c$ for G(C)RP	400 - 900 m/min
Grade	PCD
Finishing/roughing assignment	Semi-roughing
Tool material	PCD
ISO code indexable insert	VCGT 110302 FN
Number of changes/inserts	1
Product name attribute	PCD
Rake	6 degrees
Type of product	Indexable insert for turning