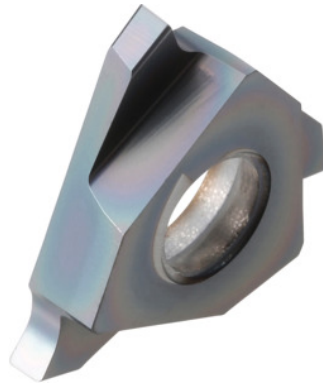


**Garant**
**Grooving insert left-hand, HB9635, Slot width m (H13): 1,1 mm**

**Order data**

Order number	273908 1,1
GTIN	4045197768490
Item class	21J

**Technical description**

for circlips to DIN 471 / 472 ring thickness	1 mm
Blade width w	1.1 mm
Slot width m (H13)	1.1 mm
$t_{\max}$	2 mm
Finishing/roughing assignment	Skrubbearbejdning-sletbearbejdning
Tool material	Carbide
Corner radius R	0.05 mm
Insert assignment	left-hand
Grade	HB9635
Slots to standard	DIN 472
Slots to standard	DIN 471

Number of changes/inserts	3
Main application	P
Secondary application	M
Cutting conditions	continuous
Cutting speed $v_c$ main application	110 - 170 mm/min
Cutting speed $v_c$ secondary application	90 - 140 mm/min
Type of product	Indexable insert for grooving

### User data

	Suitability	$V_c$	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	170 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	170 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	150 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	110 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	90 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	140 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	140 m/min	M
GG(G)	suitable only under restricted conditions	170 m/min	K
continuous	suitable		
wet maximum	suitable		
dry	suitable		