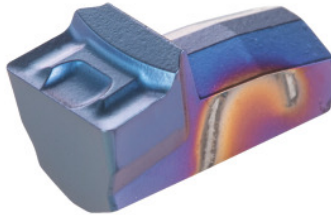


Garant**Grooving insert straight cutting edge, HB9140, Groove width w: 4mm****Order data**

Order number	275024 4
GTIN	4062406378424
Item class	21H

Description**Application:**

For blade carriers No. 274030 – 274090.

Suitable for:

Blade carrier No. 274030 – 274134.

Technical description

Finishing/roughing assignment	Finishing
Finishing/roughing assignment	Skrubbearbejdning-sletbearbejdning
Feed f in steel < 900 N/mm ²	0.12 mm/rev.
Groove width w	4 mm
Corner radius	0.2 mm
Tool material	Carbide
Cutting conditions	continuous
Grade	HB9140
Number of changes/inserts	1

Indexable insert profile	neutral
Type of product	Indexable insert for grooving

User data

	Suitability	V _c	ISO code
Steel < 500 N/mm ²	suitable only under restricted conditions	130 m/min	P
Steel < 750 N/mm ²	suitable only under restricted conditions	110 m/min	P
Steel < 900 N/mm ²	suitable only under restricted conditions	90 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	70 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	40 m/min	P
INOX < 900 N/mm ²	suitable	100 m/min	M
INOX > 900 N/mm ²	suitable	80 m/min	M
continuous	suitable		
irregular	suitable only under restricted conditions		
wet maximum	suitable		