

**Garant****Grooving insert Full radius, HB9140, Groove width w: 4mm****Order data**

Order number	275045 4
GTIN	4062406378769
Item class	21H

**Description****Application:**

For blade carriers No. 274030 – 274090.

**Suitable for:**

Blade carrier No. 274030 – 274134.

**Technical description**

Finishing/roughing assignment	Skrubbearbejdning-sletbearbejdning
Finishing/roughing assignment	Finishing
Tool material	Carbide
Feed f in steel < 900 N/mm <sup>2</sup>	0.12 mm/rev.
Groove width w	4 mm
Cutting conditions	continuous
Grade	HB9140
Number of changes/inserts	1
Type of product	Indexable insert for grooving

**User data**

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