

Garant**Grooving insert Full radius, HB9140, Groove width w: 3mm****Order data**

Order number	275045 3
GTIN	4062406378752
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
Groove width w	3 mm
Feed f in steel < 900 N/mm ²	0.1 mm/rev.
Tool material	Carbide
Cutting conditions	continuous
Grade	HB9140
Number of changes/inserts	1
Type of product	Indexable insert for grooving

User data

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