

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

Order data

Order number	275012 4
GTIN	4062406612610
Item class	21H

Description
Application:

For blade carriers No. 274030 – 274090.

Suitable for:

Blade carrier No. 274010 – 274026.

Technical description

Finishing/roughing assignment	Skrubbearbejdning-sletbearbejdning
Finishing/roughing assignment	Finishing
Tool material	Carbide
Feed f in steel < 900 N/mm ²	0.12 mm/rev.
Groove width w	4 mm
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	140 m/min	P
Steel < 750 N/mm ²	suitable	120 m/min	P
Steel < 900 N/mm ²	suitable	100 m/min	P
Steel < 1100 N/mm ²	suitable	80 m/min	P
Steel < 1400 N/mm ²	suitable	50 m/min	P
GG(G)	suitable	80 m/min	K
continuous	suitable		
irregular	suitable		
interrupted	suitable		
wet maximum	suitable		