



HELIGRIP inserts, IC8250, Groove width w / corner radius R: 4/0,4mm



Order data

Order number	273403 4/0,4
GTIN	7291075028850
Item class	26C

Description

Version:

Positive chip breaker. Soft cut. Reduced cutting forces.

Application:

For axial and radial grooving, parting off and internal machining. (HELIGRIP inserts for axial grooving application only compatible with HFHR holder).

Suitable for:

Toolholder No. 273766 – 273768.

Note:

The minimum order quantity corresponds to one pack unit quantity (VPE) or a multiple thereof.

Technical description

Groove width w	4 mm
Feed rate f when parting off	0.09 - 0.15 mm/rev.
Tolerance groove width w	0.05 mm
Corner radius R	0.4 mm
Feed rate f when turning	0.18 - 0.24 mm/rev.
INSL	19 mm

Feed rate f when facing	0.15 - 0.3 mm/rev.
Feed rate f when axial grooving	0.1 - 0.24 mm/rev.
Cutting depth a_p	0.25 - 2.4 mm
Series	HELI-GRIP
Cutting depth $a_{p \max}$	2.4 mm
Cutting depth $a_{p \min}$	0.5 mm
Manufacturer's designation	GRIP 4004Y IC8250
Number of changes/inserts	1
Tool material	Carbide
Indexable insert profile	neutral
Finishing/roughing assignment	Finishing
Main application	P
Secondary application	M
Cutting conditions	slightly interrupted
Chip breaker	ZC
Cutting speed v_c main application	45 - 260 m/min
Grade	IC8250
Type of product	Indexable insert for grooving