

**HELIGRIP inserts, IC8250, Groove width w / corner radius R: 3/0,3mm****Order data**

Order number	273403 3/0,3
GTIN	7291075028881
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**

Feed rate f when parting off	0.07 - 0.11 mm/rev.
Groove width w	3 mm
Tolerance groove width w	0.05 mm
Corner radius R	0.3 mm
INSL	15.8 mm
Feed rate f when turning	0.15 - 0.19 mm/rev.

Feed rate $f$ when facing	0.1 - 0.2 mm/rev.
Feed rate $f$ when axial grooving	0.08 - 0.2 mm/rev.
Cutting depth $a_p$	0.4 - 1.8 mm
Series	HELI-GRIP
Cutting depth $a_{p \max}$	1.8 mm
Cutting depth $a_{p \min}$	0.25 mm
Manufacturer's designation	GRIP 3003Y 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