


**HELIGRIP inserts, IC8250, Groove width w / corner radius R: 5/0,5mm**

**Order data**

Order number	273403 5/0,5
GTIN	7291075028898
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**

Corner radius R	0.5 mm
Groove width w	5 mm
Tolerance groove width w	0.05 mm
Feed rate f when parting off	0.11 - 0.2 mm/rev.
Feed rate f when turning	0.2 - 0.3 mm/rev.
INSL	19 mm

Feed rate $f$ when facing	0.15 - 0.35 mm/rev.
Feed rate $f$ when axial grooving	0.12 - 0.24 mm/rev.
Cutting depth $a_p$	0.6 - 3 mm
Series	HELI-GRIP
Cutting depth $a_{p \max}$	3 mm
Cutting depth $a_{p \min}$	0.6 mm
Manufacturer's designation	GRIP 5005Y 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