



## HELIGRIP inserts, IC808, Groove width w / corner radius R: 4/0,2mm



### Order data

Order number	273407 4/0,2
GTIN	7291075028775
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

Tolerance groove width w	0.05 mm
Groove width w	4 mm
Corner radius R	0.2 mm
Feed rate f when parting off	0.09 - 0.14 mm/rev.
Feed rate f when turning	0.16 - 0.21 mm/rev.
INSL	19 mm

Feed rate $f$ when axial grooving	0.1 - 0.24 mm/rev.
Feed rate $f$ when facing	0.15 - 0.3 mm/rev.
Cutting depth $a_p$	0.5 - 1.9 mm
Series	HELI-GRIP
Cutting depth $a_{p \max}$	2.4 mm
Cutting depth $a_{p \min}$	0.25 mm
Manufacturer's designation	GRIP 4002Y IC808
Number of changes/inserts	1
Tool material	Carbide
Indexable insert profile	neutral
Finishing/roughing assignment	Finishing
Main application	UNI
Cutting conditions	continuous
Chip breaker	ZC
Cutting speed $v_c$ main application	30 - 200 m/min
Grade	IC808
Type of product	Indexable insert for grooving