



HELIGRIP inserts, IC808, Groove width w / corner radius R: 6/0,5mm



Order data

Order number	273407 6/0,5
GTIN	7291075028829
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	6 mm
Feed rate f when parting off	0.13 - 0.23 mm/rev.
Tolerance groove width w	0.05 mm
Feed rate f when turning	0.22 - 0.36 mm/rev.
INSL	19 mm

Feed rate f when facing	0.15 - 0.4 mm/rev.
Feed rate f when axial grooving	0.12 - 0.28 mm/rev.
Cutting depth a_p	0.6 - 3 mm
Series	HELI-GRIP
Cutting depth $a_{p \max}$	3.6 mm
Cutting depth $a_{p \min}$	0.6 mm
Manufacturer's designation	GRIP 6005Y 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