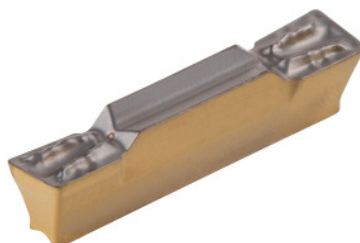




HELIGRIP inserts, IC830, Groove width w / corner radius R: 4/0,4mm



Order data

| | |
|--------------|---------------|
| Order number | 273411 4/0,4 |
| GTIN | 7291075488401 |
| Item class | 26C |

Description

Version:

Optimised chip forming and chip control.

Application:

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

Suitable for:

Blade carrier 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 |
| Cutting depth a_p | 0.5 - 2.4 mm |
| Tolerance groove width w | 0.05 mm |
| Feed rate f when turning | 0.18 - 0.24 mm/rev. |
| INSL | 19 mm |
| Corner radius R | 0.4 mm |
| Feed rate f when parting off | 0.09 - 0.15 mm/rev. |

| | |
|--------------------------------------|-------------------------------|
| Number of changes/inserts | 1 |
| Tool material | Carbide |
| Indexable insert profile | neutral |
| Finishing/roughing assignment | Finishing |
| Main application | UNI |
| Cutting conditions | heavily interrupted |
| Chip breaker | T |
| Cutting speed v_c main application | 50 - 140 m/min |
| Grade | IC830 |
| Type of product | Indexable insert for grooving |