

**Garant****Grooving insert Finishing, HB7020, Groove width w: 4mm****Order data**

Order number	273715 4
GTIN	4045197486585
Item class	21J

**Technical description**

Groove width w	4 mm
Tolerance groove width w	$\pm 0.04$ mm
Feed f	0.06 - 0.22 mm/rev.
Cutting depth $a_p$	0.5 - 2 mm
Finishing/roughing assignment	Finishing
Tool material	Carbide
Main application	P
Secondary application	M
Cutting conditions	continuous
Grade	HB7020
Corner radius R	0.2 mm
Number of changes/inserts	2
Indexable insert profile	neutral
Type of product	Indexable insert for grooving

**User data**

	<b>Suitability</b>	<b>V<sub>c</sub></b>	<b>ISO code</b>
Steel < 500 N/mm <sup>2</sup>	suitable	220 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	180 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	170 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	140 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	120 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	140 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	130 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	60 m/min	S
GG(G)	suitable	200 m/min	K
CuZn	suitable	250 m/min	N
Uni	suitable		
continuous	suitable		
wet maximum	suitable		
dry	suitable only under restricted conditions		