

**Garant****Grooving insert Full radius, HB7020, Groove width w: 2,5mm****Order data**

|              |               |
|--------------|---------------|
| Order number | 273735 2,5    |
| GTIN         | 4045197578358 |
| Item class   | 21J           |

**Technical description**

|                               |                                    |
|-------------------------------|------------------------------------|
| Groove width w                | 2.5 mm                             |
| Tolerance groove width w      | $\pm 0.03$ mm                      |
| Feed f                        | 0.08 - 0.16 mm/rev.                |
| Cutting depth $a_p$           | 0.2 - 0.7 mm                       |
| Finishing/roughing assignment | Skrubbearbejdning-sletbearbejdning |
| Tool material                 | Carbide                            |
| Main application              | P                                  |
| Secondary application         | M                                  |
| Cutting conditions            | continuous                         |
| Grade                         | HB7020                             |
| Number of changes/inserts     | 2                                  |
| Indexable insert profile      | neutral                            |
| Type of product               | Indexable insert for grooving      |

## User data

|                                | Suitability                               | V <sub>c</sub> | ISO code |
|--------------------------------|---|----------------|----------|
| 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 |                |          |