

GROOVE-TURN

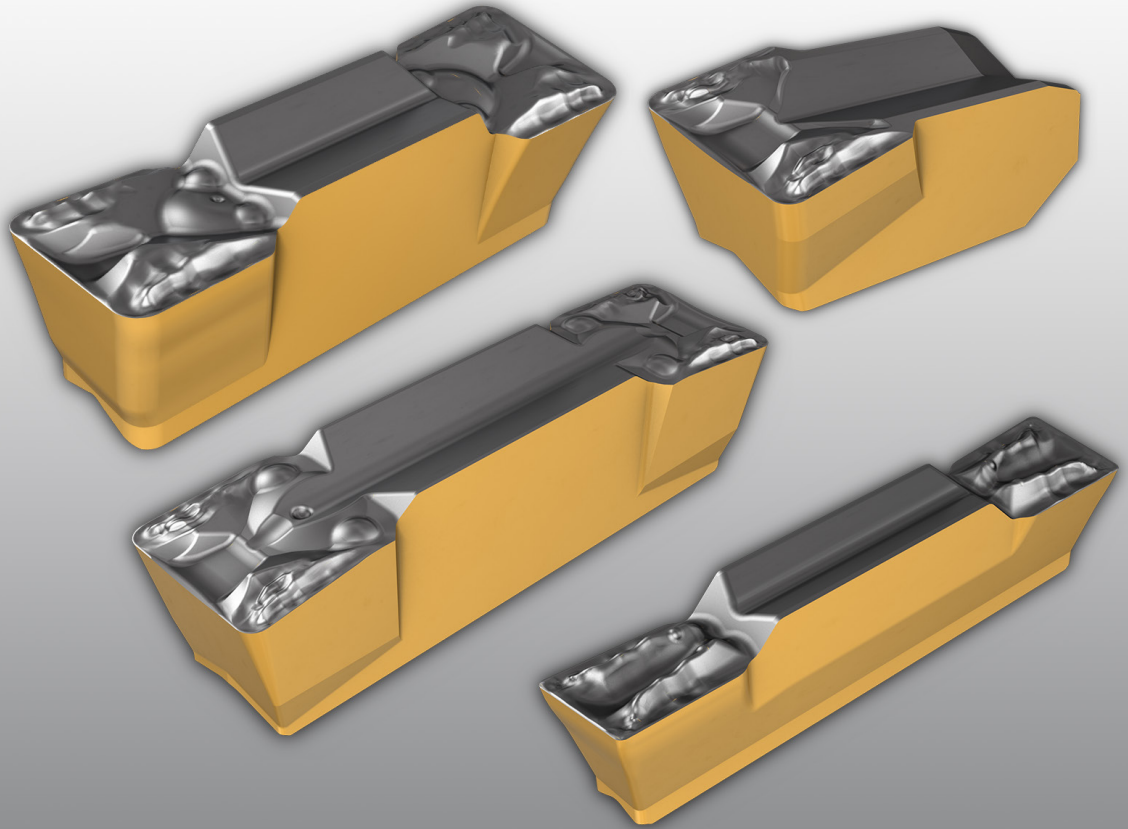
02-2023

JANUARY 2023

METRIC

NPA

New Product Announcement



Cost Effective



Easy Chip
Evacuation



High
Productivity



HELI-GRIP

CUT-GRIP

Expansion of the T-Type Chipbreaker

METRIC



Cost Effective

Easy Chip
EvacuationHigh
Productivity

NPA

New Product Announcement

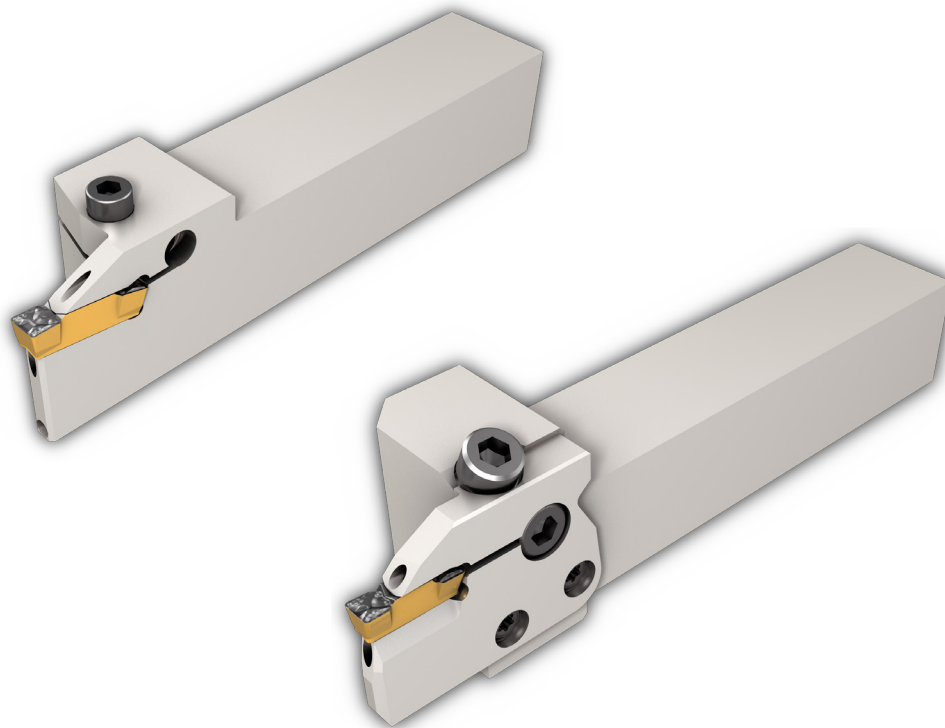
HELI-GRIP CUT-GRIP

Highlights

New HELI-GRIP and CUT-GRIP Inserts with T-Type Chipbreakers

Overview

The successful launch of single ended CUT-GRIP inserts with a T-Type chipbreaker, provide winning grounds for the introduction of a new range of HELI-GRIP inserts in addition to 8 and 10mm CUT-GRIP inserts with a T-Type chipbreaker.



Main Features

- Optimal chip control in full width grooving, partial grooving and turning applications.
- HELI-GRIP double ended 3, 4, 5 & 6mm utility inserts.
- CUT-GRIP double ended 8mm utility insert & single ended 8 & 10mm utility inserts.
- Designations – GIMT 8 / 10...
GDMT 8...
GRIP...T...

METRIC



Cost Effective

Easy Chip
EvacuationHigh
Productivity

NPA

New Product Announcement

HELI-GRIP**CUT-GRIP****TEST REPORTS**

Application: External Grooving
 Part material: SAE 4340
 Cooling pressure: 10 Bar (Internal)

		
	Y- Type Chipbreaker	T- Type Chipbreaker
Tool	HGPAD 6R-T22-JHP	HGPAD 6R-T22-JHP
Insert	GRIP 6008Y IC808	GRIP 6008T IC808
Cutting Speed (m/min)	160	160
Feed (mm/rev)	0.2	0.2
Depth of groove (mm)	8	8
Tool life (Grooves)	28	40
Chip Control	Poor	Excellent
		

Availability

- 3, 6mm GRIP inserts – In stock
- 4, 5mm GRIP inserts – First quarter of 2023
- 8mm GIMT inserts – In stock
- 10mm GIMT inserts – First quarter of 2023
- 8mm GDMT inserts – In stock

NPA New Product Announcement

GROOVE-TURN

02-2023

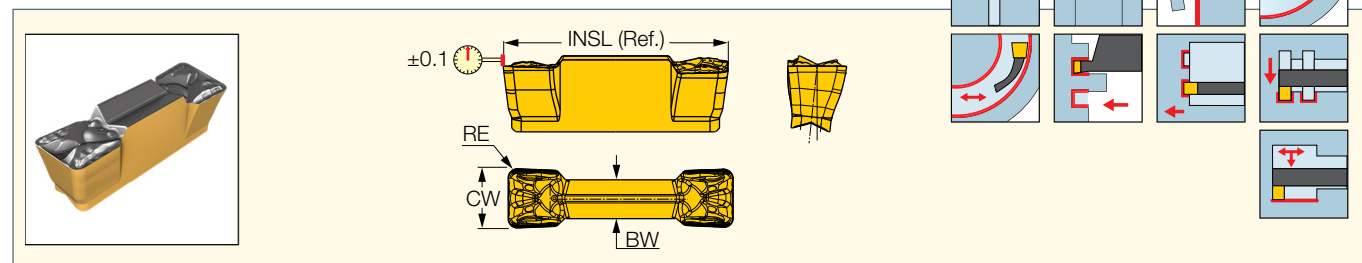
JANUARY 2023

METRIC

HELI-GRIP CUT-GRIP

GRIP-T

Utility Double-Ended Inserts for External, Internal and Face Machining



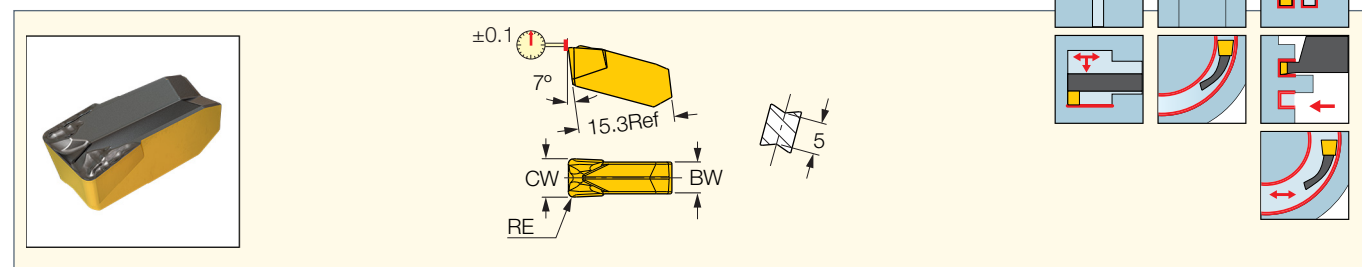
Designation	Dimensions						Tough ↔ Hard					Recommended Machining Data		
	CW	CWTOL ⁽¹⁾	RE	RETOL ⁽²⁾	INSL	BW	IC830	IC8250	IC808	IC806	IC807	a _p (mm)	f turn (mm/rev)	f groove (mm/rev)
GRIP 3002T	3.00	0.050	0.20	0.050	15.80	2.30	•	•	•	•	•	0.25-1.80	0.14-0.18	0.07-0.11
GRIP 3003T	3.00	0.050	0.30	0.050	15.80	2.30	•	•	•	•	•	0.40-1.80	0.14-0.18	0.07-0.11
GRIP 4004T	4.00	0.050	0.40	0.050	19.00	2.80	•	•	•	•	•	0.50-2.40	0.18-0.24	0.09-0.15
GRIP 5005T	5.00	0.050	0.50	0.050	19.00	3.40	•	•	•	•	•	0.60-3.00	0.20-0.30	0.11-0.20
GRIP 5008T	5.00	0.050	0.80	0.050	19.00	3.40	•	•	•	•	•	1.00-3.00	0.23-0.35	0.11-0.21
GRIP 6008T	6.00	0.050	0.80	0.050	19.00	4.20	•	•	•	•	•	1.00-3.60	0.24-0.42	0.13-0.25

⁽¹⁾ Cutting width tolerance (+/-)

⁽²⁾ Corner radius tolerance (+/-)

GIMT

Utility Single-Ended Inserts for Grooving and Turning



Designation	Dimensions						Tough ↔ Hard					Recommended Machining Data		
	CW	RE	CWTOL ⁽¹⁾	RETOL ⁽²⁾	BW		IC830	IC8250	IC808	IC07	IC806	a _p (mm)	f turn (mm/rev)	f groove (mm/rev)
GIMT 302	3.00	0.20	0.050	0.050	2.40		•	•	•	•	•	0.50-1.80	0.10-0.22	0.07-0.15
GIMT 304	3.00	0.40	0.050	0.050	2.40		•	•	•	•	•	0.50-1.80	0.10-0.22	0.07-0.15
GIMT 402	4.00	0.20	0.050	0.050	3.40		•	•	•	•	•	0.50-2.40	0.15-0.25	0.09-0.20
GIMT 404	4.00	0.40	0.050	0.050	3.40		•	•	•	•	•	0.50-2.40	0.15-0.25	0.09-0.20
GIMT 508	5.00	0.80	0.050	0.050	4.00		•	•	•	•	•	1.00-3.00	0.20-0.35	0.11-0.22
GIMT 608	6.00	0.80	0.050	0.050	5.00		•	•	•	•	•	1.00-3.60	0.22-0.40	0.13-0.25
GIMT 808	8.00	0.80	0.050	0.050	6.00		•	•	•	•	•	1.00-4.80	0.32-0.56	0.18-0.34
GIMT 1008	10.00	0.80	0.050	0.050	8.00		•	•	•	•	•	1.00-6.00	0.35-0.65	0.22-0.40

• DMIN for internal applications = 70 mm

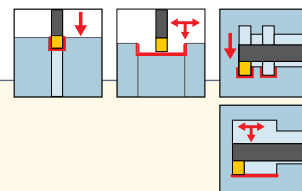
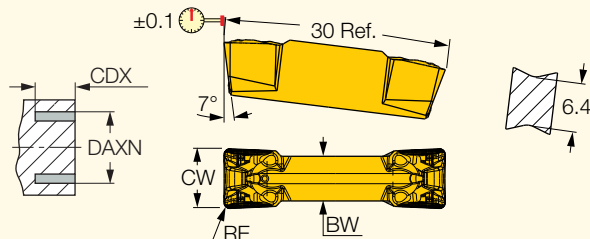
⁽¹⁾ Cutting width tolerance (+/-)

⁽²⁾ Corner radius tolerance (+/-)

HELI-GRIP CUT-GRIP

GDMT

Utility Double-Ended Inserts for Grooving and Turning



Designation	Dimensions						Tough $\longleftrightarrow$ Hard				Recommended Machining Data		
	CW	CWTOL ⁽¹⁾	RE	RETOL ⁽²⁾	BW	CDX	IC830	IC8250	IC808	IC806	a_p (mm)	f turn (mm/rev)	f groove (mm/rev)
GDMT 808	8.00	0.050	0.80	0.050	6.00	27.00	●	●	●	●	1.00-4.80	0.32-0.56	0.18-0.34

⁽¹⁾ Cutting width tolerance (+/-)

⁽²⁾ Corner radius tolerance (+/-)