

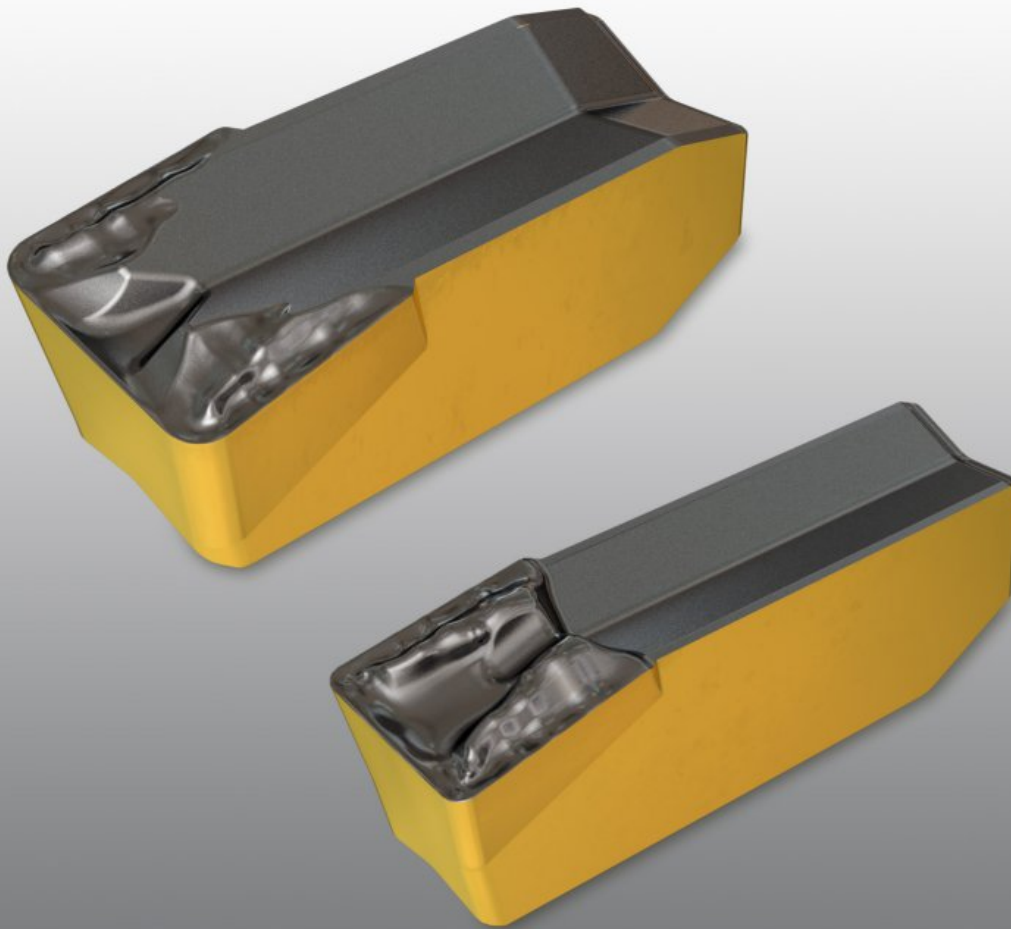
# NPA

## New Product Announcement

GROOVE TURN

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# **CUT-GRIP**

## **GIMT – Grooving and Turning Inserts with a New Advanced Chipformer**



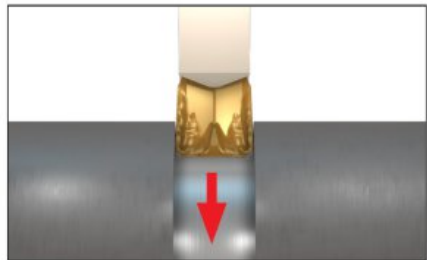
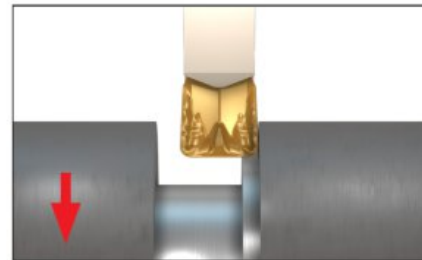
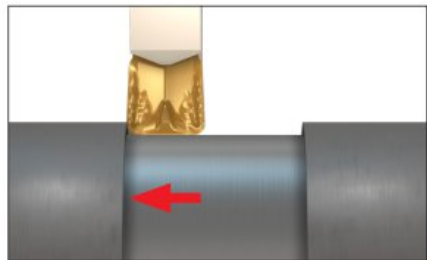
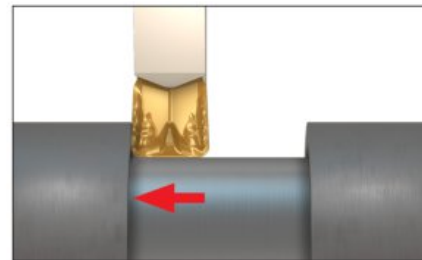


**CUTGRIP**

## Highlights

- **New GIMT Groove-Turn chipformer for cut-grip pressed insert**
- **Optimized for 4 applications: Grooving, Partial Grooving, Turning and Finish Turning**
- **Standard widths 3, 4,5 & 6 mm**

Groove-Turn inserts are used in four different applications:

**Full Width Grooving****Partial (finish) Grooving****Finish Turning****Turning**

Most of the chipformers available in the market perform well in one or two of the above-mentioned four applications, but very rarely in all of them.

Based on ISCAR's accumulated experience and intensive R&D, a unique **GIMT** insert with a new chipformer has been designed that **excels in all four applications**, providing efficient chip control in a wide range of machining conditions. The **GIMT** inserts were optimized for steel materials but they also function very well on stainless steel and high temperature material groups. The **GIMT** inserts are available in standard widths of 3, 4, 5 and 6 mm.

The new inserts provide a high-performance and cost-effective solution, which can eliminate the use of different insert types for each application, reduce stock requirements, and provide end users with higher flexibility.

**Click Link to  
See Short Video**



<https://youtu.be/bez1OIMKsLM>



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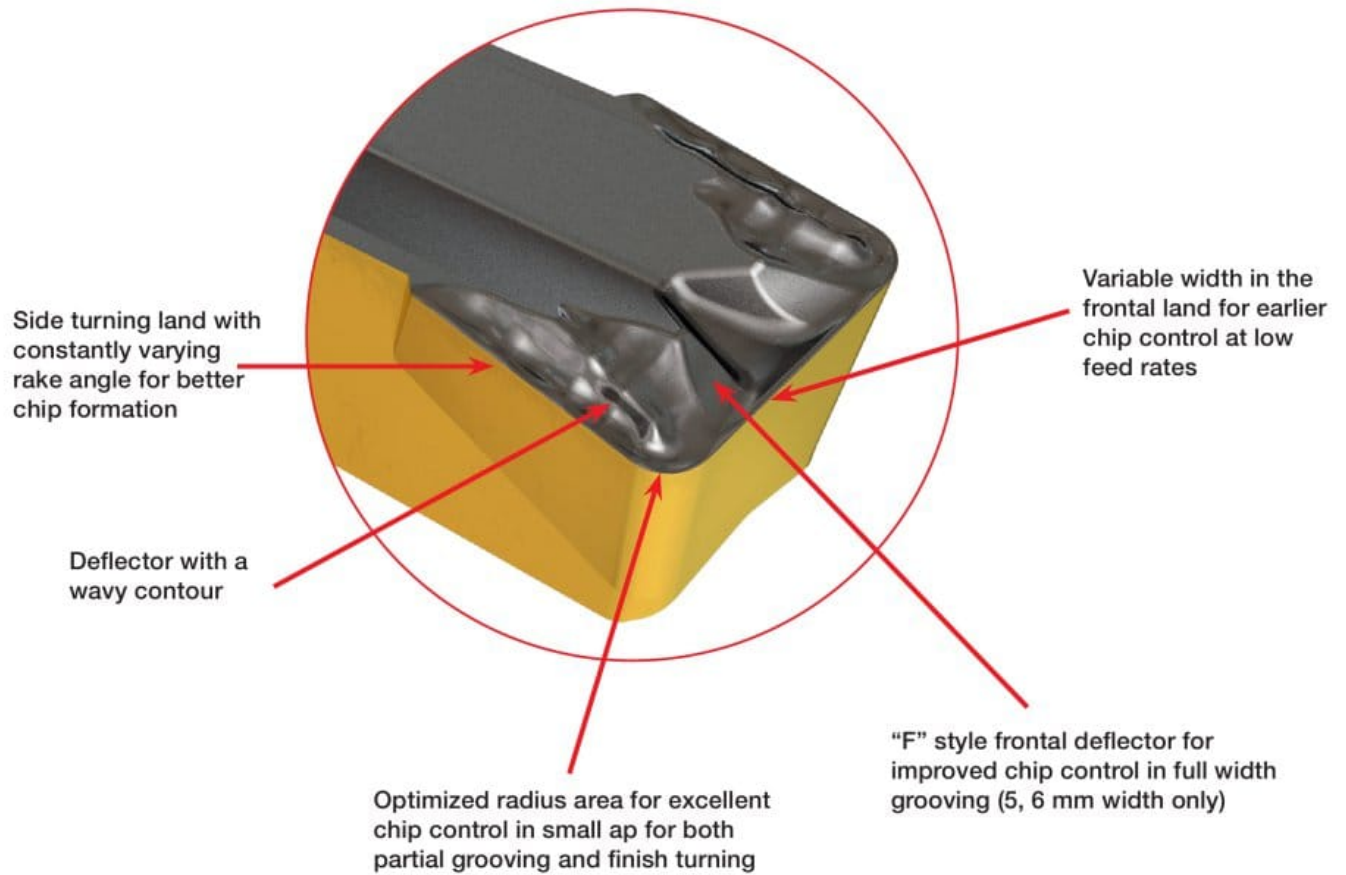
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## CUTGRIP

### Chipbreaker Elements



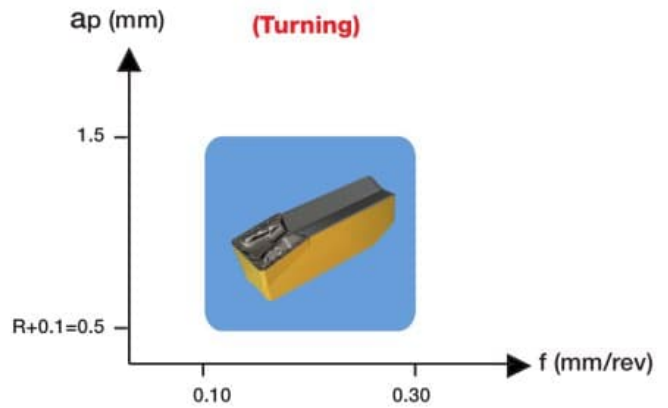
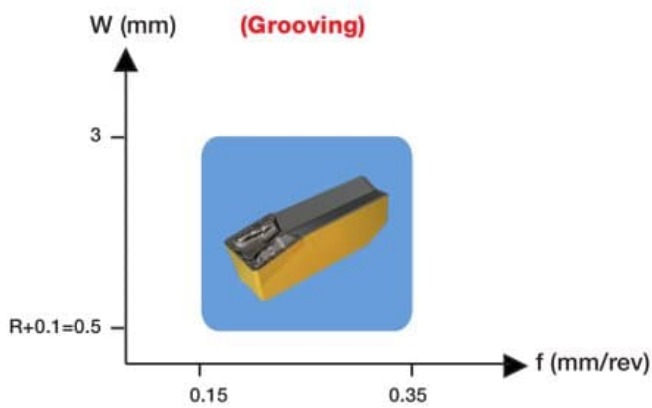
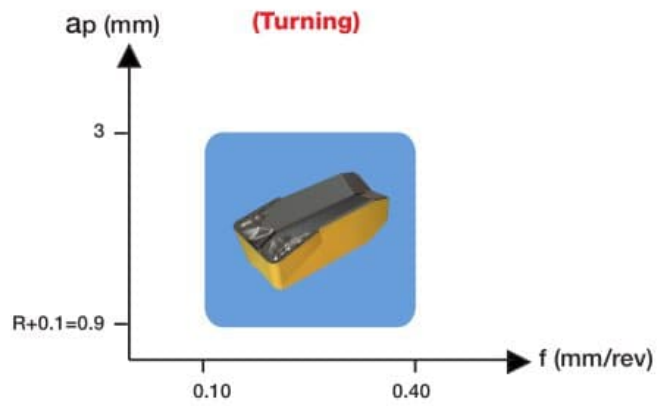
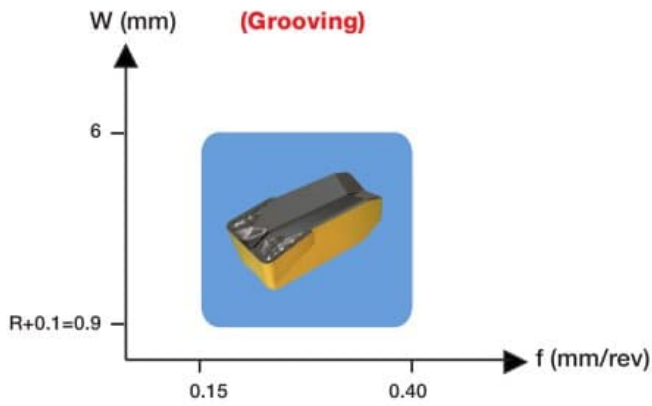




## Chip Control Range



### GIMT 608



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## CUTGRIP

**Application:** Grooving  
**Workpiece Material:** SAE 4340  
**Insert:** GIMT 304  
**Vc:** 120 m/min

f mm/rev ap mm	0.5	1.0	3.0
0.10			
0.15			
0.20			
0.25			

**Application:** Turning  
**Workpiece Material:** SAE 4340  
**Insert:** GIMT 304  
**Vc:** 120 m/min



f mm/rev ap mm	0.5	1.0	1.5
0.12			
0.22			
0.30			







# CUTGRIP

## TEST REPORTS GIMT 3

	ISCAR	Competitor
Insert	GIMT 304 IC808	3 mm Grooving Insert
Material	Steel 12CrNi4Pb	
Operation	External Grooving	
Vc (m/min)	180	
f (mm/rev)	0.12	
D.O.C (mm)	2	
Chips		

## TEST REPORTS GIMT 4

	ISCAR	Former
Insert	GIMT 404 IC808	GIMF 406 IC808
Material	Steel 39NiCrMo3	
Operation	External Grooving	
Vc (m/min)	150	
f (mm/rev)	0.12	
D.O.C (mm)	15	
Chips		

## TEST REPORTS GIMT 6

	ISCAR	Competitor
Insert	GIMT 608 IC808	6 mm Grooving Insert
Material	Steel 20MnCr5	
Operation	External Grooving	
Vc (m/min)	240	
f (mm/rev)	0.17	
D.O.C (mm)	7	
Chips		



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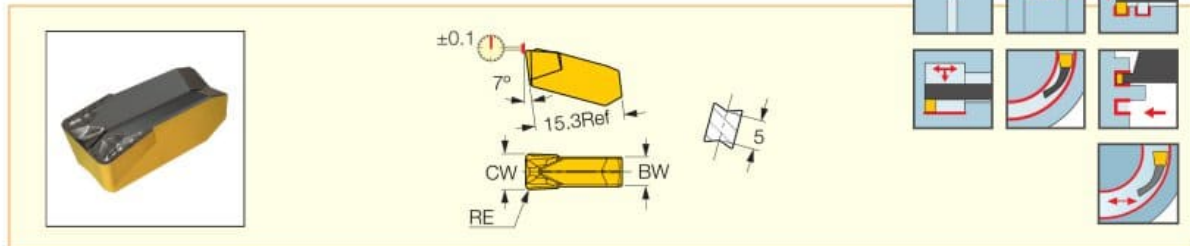
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## CUTGRIP

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### GIMT

Utility Single-Ended Inserts for Grooving and Turning



Designation	Dimensions			Tough → Hard				Recommended Machining Data		
	CW	RE	BW	IC830	IC808	IC07	IC806	$a_p$ (min)	f turn (mm/rev)	f groove (mm/rev)
<b>GIMT 304</b>	3.00	0.40	2.40	•	•	•	•	0.50-1.80	0.10-0.22	0.07-0.15
<b>GIMT 404</b>	4.00	0.40	3.40	•	•	•	•	0.50-2.40	0.15-0.25	0.09-0.20
<b>GIMT 508</b>	5.00	0.80	4.00	•	•	•	•	1.00-3.00	0.20-0.35	0.11-0.22
<b>GIMT 608</b>	6.00	0.80	5.00	•	•	•	•	1.00-3.60	0.22-0.40	0.13-0.25

• Dmin for internal applications = 70 mm

