

**Drill insert with pointed tip HSS, TiN, Ø D: 19mm****Order data**

Order number	232282 19
GTIN	4062406096502
Item class	22F

Description**Version:**

Exchangeable HSS cutter for universal application. Cannot be reground.
With chip breaker. Pointed tip for high stability and self-centring.
For holes up to IT10 accuracy.

Note:

Other sizes, version with solid carbide cutting edges and 180° cutting edges, available on request.

Technical description

for base body type	18
Feed f in steel < 900 N/mm ²	0.18 mm/rev.
Feed f in stainless steel > 900 N/mm ²	0.19 mm/rev.
Ø D	19 mm
Number of changes/inserts	1
Coating	TiN
Point angle	132 degrees

Grade	TiN
Tool material	HSS
Number of cutting edges Z	2
Type of product	Cutter insert for boring

User data

	Suitability	V _c	ISO code
Alu plastics	suitable	180 m/min	N
Aluminium (short chipping)	suitable	130 m/min	N
Alu > 10% Si	suitable	100 m/min	N
Steel < 500 N/mm ²	suitable	45 m/min	P
Steel < 750 N/mm ²	suitable	45 m/min	P
Steel < 900 N/mm ²	suitable	30 m/min	P
Steel < 1100 N/mm ²	suitable	25 m/min	P
INOX < 900 N/mm ²	suitable	22 m/min	M
INOX > 900 N/mm ²	suitable	22 m/min	M
GG(G)	suitable	45 m/min	K
CuZn	suitable	90 m/min	N
wet maximum	suitable		