

**HOLEX****Drill insert with pointed tip HSS, TiN, Ø D: 27mm****Order data**

Order number	232282 27
GTIN	4062406096618
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**

Feed f in stainless steel > 900 N/mm <sup>2</sup>	0.24 mm/rev.
Feed f in steel < 900 N/mm <sup>2</sup>	0.25 mm/rev.
Ø D	27 mm
for base body type	25
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 <sup>2</sup>	suitable	45 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	45 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	30 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	25 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	22 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	22 m/min	M
GG(G)	suitable	45 m/min	K
CuZn	suitable	90 m/min	N
wet maximum	suitable		