

Garant**HiPer-Drill cutter insert m7, HB3040, Ø D: 24,5mm****Order data**

Order number	231645 24,5
GTIN	4062406162993
Item class	21M

Description**Version:**

Vee ground cutter inserts for precise positioning and stable seating.
Concentricity when assembled $\leq 20 \mu\text{m}$. For holes up to IT9 accuracy.

Special pyramidal point geometry, optimal spot drilling – even with unstable conditions and long tool overhangs.

Such as when processing sheet metal and steel girders. Also suitable for stack drilling.

Note:

1xD maximum drilling depth without through-coolant.

Cutting data applies for the base body 5xD.

Drill pilot holes exclusively with cutter insert of the same type.

Technical description

Series	HiPer-Drill
Ø D	24.5 mm
for base body size	24 mm
Use for drilling	Drilling through a stack

Feed f in steel < 750 N/mm ²	0.33 mm/rev.
Number of changes/inserts	1
Coating	TiAlN
Point angle	160 degrees
Grade	HB3040
Tool material	Carbide
Semi-Standard	yes
Number of cutting edges Z	2
Type of product	Cutter insert for boring

User data

	Suitability	V _c	ISO code
Steel < 500 N/mm ²	suitable	140 m/min	P
Steel < 750 N/mm ²	suitable	120 m/min	P
Steel < 900 N/mm ²	suitable	100 m/min	P
GG(G)	suitable only under restricted conditions	80 m/min	K
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		