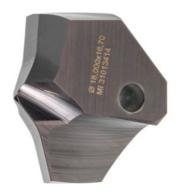


HiPer-Drill cutter insert m7, HB3040, Ø D: 27mm



Order data

Order number	231645 27		
GTIN	4062406163044		
Item class	21M		

Description

Version:

Vee ground cutter inserts for precise positioning and stable seating.

Concentricity when assembled \leq 20 µm. 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:

1×D maximum drilling depth without through-coolant.

Cutting data applies for the base body 5×D.

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

Technical description

ØD	27 mm		
Series	HiPer-Drill		
for base body size	27 mm		
Use for drilling	Drilling through a stack		

Feed f in steel < 750 N/mm ²	0.35 mm/rev.		
Number of changes/inserts	1		
Coating	TiAIN		
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	\mathbf{V}_{c}	ISO code
Steel < 500 N/mm ²	suitable	140 m/min	Р
Steel < 750 N/mm ²	suitable	120 m/min	Р
Steel < 900 N/mm ²	suitable	100 m/min	Р
GG(G)	suitable only under restricted conditions	80 m/min	К
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		