

**Garant****HiPer-Drill cutter insert Form E, HB7530, Counterbore Ø: 15mm****Order data**

Order number	231690 15
GTIN	4045197761088
Item class	21M

**Description****Version:**

Vee ground cutter inserts for precise positioning and stable seating.

Form E 180° cutter with 142° centre point and 0.5 mm protective chamfer

**Application:**

For through holes for screws to DIN-ISO 273 and countersinking to DIN74, sheet2 formH, J and K, medium version.

For screws to DIN912, 6912 and 7984, ISO1207 (DIN84).

**Note:**

Further sizes available on request. Cutting data apply for drilling bodies 5×D.

**Technical description**

Counterbore Ø	15 mm
suitable for through hole Ø	9 mm
for DIN cylinder head screws	M8
Series	HiPer-Drill

Countersink angle	180 degrees
Grade	HB7530
Type of product	Cutter insert for countersinking

## User data

	Suitability	V <sub>c</sub>	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	130 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	110 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	100 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	75 m/min	P
TOOLOX 33	suitable	40 m/min	H
TOOLOX 44	suitable	35 m/min	H
HARDOX 500 < 1600 N/mm <sup>2</sup>	suitable	30 m/min	H
GG(G)	suitable only under restricted conditions	80 m/min	K
wet maximum	suitable		