

Garant**HiPer-Drill cutter insert Form E, HB7530, Counterbore Ø: 18mm****Order data**

Order number	231690 18
GTIN	4045197761095
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	18 mm
suitable for through hole Ø	11 mm
for DIN cylinder head screws	M10
Series	HiPer-Drill

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

User data

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