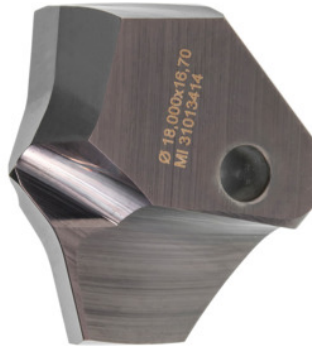


Garant
HiPer-Drill cutter insert m7, HB3040, Ø D: 22-Xmm

Order data

Order number	231645 22-X
GTIN	4062406637262
Item class	20N

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. Delivery time: 10 working weeks

Minimum order quantity: 3 pieces

Items made to order for a specific customer:

Cancellation only up to a maximum of 3 working days after receipt of order acknowledgement.

Items cannot be returned.

Technical description

Coating	TiAlN
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for base body size	22 mm
Number of changes/inserts	1
Series	HiPer-Drill
Use for drilling	Drilling through a stack
Feed f in steel < 750 N/mm ²	0.33 mm/rev.
Ø range	22 - 22.99 mm
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		