

**Garant**
**HiPer-Drill cutter insert m7, HB7530, Ø D: 18-Xmm**

**Order data**

Order number	231640 18-X
GTIN	4062406636098
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.

**Note:**

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**

Feed f in steel $< 900 \text{ N/mm}^2$	0.28 mm/rev.
Number of changes/inserts	1
Series	HiPer-Drill
for base body size	18 mm

Ø range	18 - 18.99 mm
Point angle	135 degrees
Grade	HB7530
Tool material	Carbide
Semi-Standard	yes
Number of cutting edges Z	2
Type of product	Cutter insert for boring

### 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 only under restricted conditions	30 m/min	H
GG(G)	suitable only under restricted conditions	80 m/min	K
wet maximum	suitable		

### Accessories

Torx Plus® screw Drive 8IP1	231999 8IP1
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