



Drill insert with pointed tip HSS-E-PM, TiAlN, Ø D: 22mm



Order data

Order number	232286 22
GTIN	4045197593528
Item class	22F

Description

Version:

Exchangeable HSS cutter for universal application. Cannot be reground.
With chip breaker. Pointed tip for high stability and self-centring.
For holes up to IT10 accuracy.

Note:

Other sizes, version with solid carbide cutting edges and 180° cutting edges, available on request.

Technical description

for base body type	18
Feed f in stainless steel > 900 N/mm ²	0.2 mm/rev.
Feed f in steel < 900 N/mm ²	0.23 mm/rev.
Ø D	22 mm
Number of changes/inserts	1
Coating	TiAlN
Point angle	132 degrees
Grade	TiAlN

Tool material	HSS E PM
Number of cutting edges Z	2
Type of product	Cutter insert for boring

User data

	Suitability	V _c	ISO code
Alu plastics	suitable	200 m/min	N
Aluminium (short chipping)	suitable	200 m/min	N
Alu > 10% Si	suitable	120 m/min	N
Steel < 500 N/mm ²	suitable	65 m/min	P
Steel < 750 N/mm ²	suitable	60 m/min	P
Steel < 900 N/mm ²	suitable	55 m/min	P
Steel < 1100 N/mm ²	suitable	50 m/min	P
Steel < 1400 N/mm ²	suitable	30 m/min	P
INOX < 900 N/mm ²	suitable	30 m/min	M
INOX > 900 N/mm ²	suitable	20 m/min	M
Ti > 850 N/mm ²	suitable	15 m/min	S
GG(G)	suitable	60 m/min	K
CuZn	suitable	140 m/min	N
wet maximum	suitable		