



## Drill insert with pointed tip HSS-E-PM, TiAlN, Ø D: 27mm



### Order data

Order number	232286 27
GTIN	4045197593573
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

Feed f in steel < 900 N/mm <sup>2</sup>	0.34 mm/rev.
Feed f in stainless steel > 900 N/mm <sup>2</sup>	0.24 mm/rev.
Ø D	27 mm
for base body type	25
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 <sub>c</sub>	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 <sup>2</sup>	suitable	65 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	60 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	55 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	50 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	30 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	30 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	20 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	15 m/min	S
GG(G)	suitable	60 m/min	K
CuZn	suitable	140 m/min	N
wet maximum	suitable		