

**Garant****HiPer-Drill cutter insert m7, HB7530, Ø D: 18,2mm****Order data**

|              |               |
|--------------|---------------|
| Order number | 231640 18,2   |
| GTIN         | 4045197659705 |
| Item class   | 21M           |

**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.

**Technical description**

|  |              |
|--|--------------|
| for base body size                     | 18 mm        |
| Feed f in steel $< 900 \text{ N/mm}^2$ | 0.28 mm/rev. |
| Ø D                                    | 18.2 mm      |
| Series                                 | HiPer-Drill  |
| Number of changes/inserts              | 1            |
| 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 |
|-----------------------------|-------------|