

Garant**HiPer-Drill cutter insert m7, HB7530, Ø D: 13,8mm****Order data**

Order number	231640 13,8
GTIN	4045197659347
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

Ø D	13.8 mm
for base body size	13.5 mm
Feed f in steel < 900 N/mm ²	0.21 mm/rev.
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 _c	ISO code
Steel < 500 N/mm ²	suitable	130 m/min	P
Steel < 750 N/mm ²	suitable	110 m/min	P
Steel < 900 N/mm ²	suitable	100 m/min	P
Steel < 1100 N/mm ²	suitable	90 m/min	P
Steel < 1400 N/mm ²	suitable	75 m/min	P
TOOLOX 33	suitable	40 m/min	H
TOOLOX 44	suitable	35 m/min	H
HARDOX 500 < 1600 N/mm ²	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 7IP	231999 7IP
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