

**Garant**
**HiPer-Drill cutter insert m7, HB7530, Ø D: 27mm**

**Order data**

Order number	231640 27
GTIN	4045197604699
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  $5 \times D$ .  
Drill pilot holes exclusively with cutter insert of the same type.

**Technical description**

Ø D	27 mm
Feed f in steel $< 900 \text{ N/mm}^2$	0.4 mm/rev.
for base body size	27 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 15IP	231999 15IP
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