

Garant**HiPer-Drill cutter insert h7, HB7630, Ø D: 13,8mm****Order data**

Order number	231650 13,8
GTIN	4045197660039
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

Feed f in stainless steel $> 900 \text{ N/mm}^2$	0.15 mm/rev.
for base body size	13.5 mm
Ø D	13.8 mm
Series	HiPer-Drill
Number of changes/inserts	1
Point angle	135 degrees

Grade	HB7630
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
Alu plastics	suitable only under restricted conditions	200 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	200 m/min	N
Alu > 10% Si	suitable only under restricted conditions	150 m/min	N
INOX < 900 N/mm ²	suitable	65 m/min	M
INOX > 900 N/mm ²	suitable	55 m/min	M
Ti > 850 N/mm ²	suitable	30 m/min	S
wet maximum	suitable		

Accessories

Torx Plus® screw Drive 7IP	231999 7IP
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