

**Garant****HiPer-Drill cutter insert h7, HB7630, Ø D: 27mm****Order data**

Order number	231650 27
GTIN	4045197605221
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 $> 900 \text{ N/mm}^2$	0.28 mm/rev.
for base body size	27 mm
Ø D	27 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 <sub>c</sub>	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 <sup>2</sup>	suitable	65 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	55 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	30 m/min	S
wet maximum	suitable		

### Accessories

Torx Plus® screw Drive 15IP	231999 15IP
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