

Garant
HiPer-Drill base body, 8×D, Ø DC: 12mm

Order data

Order number	231615 12
GTIN	4045197716309
Item class	21S

Description
Version:

- **Very high feed rates and maximum performance due to optimally matched geometries and materials.**
- **Precise positioning of the cutter insert due to Vee insert seating and secure clamping by the centre bore.**
- **High concentricity when assembled.**
- **Shank support for optimum stability in operation.**

Created by an additive procedure.

Application:

For stationary and rotating use. For holes up to IT9 accuracy.

Recommendation:

Drill the pilot hole.

Note:

Further sizes up to Ø 50.99 mm available on request.

The insert screw must be replaced after every fifth change of cutter insert.

reduce v_f values by 20 %.

Clamp in a hydraulic chuck (such as No. 302026 size 20) for optimum radial run-out.

For optimum stability, clamp the drill so the overhang is as short as possible.

For process reliability when using the drill, initial pilot drilling to 1.5×D with the drill No. 231600 with the same cutter insert size and type is necessary. **The generation of a pilot hole improves process reliability.**

Technical description

Shank Ø D_s	16 mm
Reach L_1	100 mm

Clamping screw	231999 6IP (0.4 Nm)
Dia. range D_c	12 - 12.49 mm
Shank length L_s	48 mm
Series	HiPer-Drill
Number of cutting edges Z	2
Overall length L	169 mm
Version	8xD
Shank	ISO 9766
Use for drilling	limited drilling with oblique exit
Use for drilling	limited drilling through a stack
Use for drilling	limited oblique spot drilling
Use for drilling	limited cross-drilling
Through-coolant	yes
Type of product	Indexable drill

Accessories

8 mm blade with magnet with 1/4 inch bit holder overall length 50 mm	659874 50
Torx Plus® screw Drive 6IP	231999 6IP
PrecisionBit for Torx Plus®, 1/4 inch E 6.3 Torx Plus® profile 6IP	674252 6IP
Torque screwdriver with scale, to take interchangeable blades maximum torque 200 cNm	659957 200