

**Garant**
**HiPer-Drill base body, 8×D, Ø DC: 34mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 231615 34     |
| GTIN         | 4045197726025 |
| 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.**

**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**

|                |                       |
|----------------|-----------------------|
| Reach $L_1$    | 280 mm                |
| Shank Ø $D_s$  | 32 mm                 |
| Clamping screw | 231999 20IP1 (7.5 Nm) |

|                           |                                    |
|---------------------------|------------------------------------|
| Dia. range $D_c$          | 34 - 34.99 mm                      |
| Shank length $L_s$        | 60 mm                              |
| Series                    | HiPer-Drill                        |
| Number of cutting edges Z | 2                                  |
| Overall length L          | 388 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

|   |             |
|---|-------------|
| PrecisionBit for Torx Plus®, 1/4 inch E 6.3 Torx Plus® profile 20IP | 674252 20IP |
| Torx Plus® screw Drive 20IP   | 231999 20IP |
| Torque screwdriver, fixed setting set torque 5,7 N·m                | 211750 5,7  |