

**Garant**
**HiPer-Drill base body, 1.5×D, Ø DC: 22mm**

**Order data**

Order number	231600 22
GTIN	4045197602619
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. (For holes up to IT9 accuracy)**
- **Shank support for optimum stability in operation.**

**Application:**

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

**Note:**

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

Further sizes up to Ø 50.99 mm available on request.

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.

**Technical description**

Reach $L_1$	35 mm
Dia. range $D_c$	22 - 22.99 mm
Shank Ø $D_s$	25 mm
Clamping screw	231999 10IP (3.3 Nm)
Shank length $L_s$	56 mm
Series	HiPer-Drill

Number of cutting edges Z	2
Overall length L	125 mm
Version	1.5xD
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

Torque screwdriver with scale, to take interchangeable blades maximum torque 1600 cNm	659906 1600
Torx Plus® screw Drive 10IP	231999 10IP
8 mm blade with magnet with 1/4 inch bit holder overall length 50 mm	659874 50
PrecisionBit for Torx Plus®, 1/4 inch E 6.3 Torx Plus® profile 10IP	674252 10IP
Torque screwdriver with scale, to take interchangeable blades maximum torque 1600 cNm	659957 1600