

Garant
HiPer-Drill base body, 12xD, Ø DC: 16mm

Order data

| | |
|--------------|---------------|
| Order number | 231620 16 |
| GTIN | 4045197687685 |
| 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.**

Polished flutes.

Application:

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

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 feed rates f by 10 % and v_c values by 40 %.

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

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 1.5xD 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

| | |
|----------------|----------------------|
| Clamping screw | 231999 8IP1 (1.2 Nm) |
| Shank Ø D_s | 20 mm |

| | |
|---------------------------|------------------------------------|
| Dia. range D_c | 16 - 16.99 mm |
| Reach L_1 | 204 mm |
| Shank length L_s | 50 mm |
| Series | HiPer-Drill |
| Number of cutting edges Z | 2 |
| Overall length L | 280 mm |
| Version | 12xD |
| Shank | ISO 9766 |
| Use for drilling | limited cross-drilling |
| Use for drilling | limited drilling through a stack |
| Use for drilling | limited oblique spot drilling |
| Use for drilling | limited drilling with oblique exit |
| Through-coolant | yes |
| Type of product | Indexable drill |

Accessories

| | |
|--|-------------|
| Torx Plus® screw Drive 8IP1 | 231999 8IP1 |
| Torque screwdriver, fixed setting set torque 1,2 N·m | 211750 1,2 |
| PrecisionBit for Torx Plus®, 1/4 inch E 6.3 Torx Plus® profile 8IP | 674252 8IP |