Garant

HiPer-Drill base body, 12×D, ∅ DC: 27mm

Order data

Order number	231620 27
GTIN	4045197688798
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 ∅ 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 1.5×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.**
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 ∅ D_s	32 mm
Dia. range D_c	27 - 27.99 mm

Clamping screw	231999 15IP (5.0 Nm)
Reach L_1	336 mm
Shank length L_s	60 mm
Series	HiPer-Drill
Number of cutting edges Z	2
Overall length L	436 mm
Version	12×D
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

Torque screwdriver, fixed setting set torque 5,0 N·m	211750 5,0
Torx Plus® screw Drive 15IP	231999 15IP
PrecisionBit for Torx Plus®, 1/4 inch E 6.3 Torx Plus® profile 15IP	674252 15IP