

Garant
HiPer-Drill base body, 8×D, Ø DC: 21mm

Order data

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|--------------|---------------|
| Order number | 231615 21 |
| GTIN | 4045197603265 |
| 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

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|------------------------|---------------------|
| Shank Ø D _s | 25 mm |
| Reach L ₁ | 176 mm |
| Clamping screw | 231999 9IP (2.2 Nm) |

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|---------------------------|------------------------------------|
| Dia. range D_c | 21 - 21.99 mm |
| Shank length L_s | 56 mm |
| Series | HiPer-Drill |
| Number of cutting edges Z | 2 |
| Overall length L | 264 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 9IP | 674252 9IP |
| Torx Plus® screw Drive 9IP | 231999 9IP |
| Torque screwdriver, fixed setting set torque 2,2 N·m | 211750 2,2 |