Garant

HiPer-Drill base body, 12×D, Ø DC: 21mm

Order data

Order number	231620 21
GTIN	4045197688736
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 1.5×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 Ø D_s	25 mm
Reach L_1	264 mm

Clamping screw	231999 9IP (2.2 Nm)
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	352 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

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