

**Garant**
**HiPer-Drill base body, 8×D, Ø DC: 25mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 231615 25     |
| GTIN         | 4045197603302 |
| 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**

|                  |                      |
|------------------|----------------------|
| Dia. range $D_c$ | 25 - 25.99 mm        |
| Clamping screw   | 231999 10IP (3.3 Nm) |
| Shank Ø $D_s$    | 32 mm                |

|                             |                                    |
|-----------------------------|------------------------------------|
| Reach L <sub>1</sub>        | 208 mm                             |
| Shank length L <sub>s</sub> | 60 mm                              |
| Series                      | HiPer-Drill                        |
| Number of cutting edges Z   | 2                                  |
| Overall length L            | 305 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 15IP                   | 674252 15IP |
| Torx Plus® screw Drive 15IP   | 231999 15IP |
| 8 mm blade with magnet with 1/4 inch bit holder overall length 50 mm                  | 659874 50   |
| Torque screwdriver with scale, to take interchangeable blades maximum torque 1600 cNm | 659906 1600 |
| Torque screwdriver with scale, to take interchangeable blades maximum torque 1600 cNm | 659957 1600 |