


**KUB Pentron® indexable drill ABS® shank, 5×D, Ø DC: 22mm**

**Order data**

Order number	236604 22
GTIN	4047109181793
Item class	24P

**Description**
**Version:**
**Bore tolerance:** D – 0.1 / + 0.35

**Application:**

With indexable inserts No. 236605 – 236610.

**Recommendation:**
**When spot-drilling** reduce the feed rate to 70%.

**Note:**

- **For use only under stable machining conditions.**
- **Version 2×D and 3×D with ABS® shank available on request.**
- **Offset-axis drilling up to  $V_{max} = 0.25$  mm.**
- **Maximum  $\varnothing = D + 0.5$  mm achievable by offsetting.**
- **Version with PSC shank available on request.**

**Technical description**

Number of cutting edges Z	1
ISO code indexable insert	SOGX 07T208 20-...
Reach L <sub>1</sub>	110 mm
Pack of insert screws	239652 6IP2 (1.0 Nm)
ABS® shank Ø D <sub>s</sub>	50 mm
Series	KUB Pentron®
Nominal Ø D	22

Overhang L <sub>A</sub>	142 mm
Drill depth for indexable insert drill up to	5×D
Shank	ABS
Use for drilling	limited centre drilling
Use for drilling	limited convexity
Use for drilling	limited cross-drilling
Use for drilling	limited drilling through a stack
Use for drilling	limited drilling with oblique exit
Use for drilling	limited cross-drilling
Through-coolant	yes
Machining strategy	HPC
Type of product	Indexable drill

## Accessories

Torx Plus® insert screw set 10 pieces Drive 6IP2	239652 6IP2
PrecisionBit for Torx Plus®, 1/4 inch E 6.3 Torx Plus® profile 6IP	674252 6IP
Torque screwdriver, fixed setting set torque 1,0 N·m	211750 1,0