

Garant**HiPer-Drill base body, 1.5×D, Ø DC: 18 mm****Order data**

Order number	231600 18
GTIN	4045197602572
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.

Note:

The insert screw must be replaced after every fifth change of cutter insert.

Further sizes up to Ø 50.99 mm available on request.

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.

Number of cutting edges Z: 2

Dia. range D_c: 18 - 18.99 mm

Reach L₁: 29 mm

Shank Ø D_s: 25 mm

Shank length L_s: 56 mm

Clamping screw: 231999_8IP1 (1.2 Nm)

Technical description

Dia. range D _c	18 - 18.99 mm
Shank Ø D _s	25 mm

Clamping screw	231999_8IP1 (1.2 Nm)
Reach L ₁	29 mm
Shank length L _s	56 mm
Number of cutting edges Z	2
Drill depth up to	1.5×D
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

Torx Plus® screw Drive 8IP1	231999 8IP1
Torque screwdriver, fixed setting set torque 1,2 Nm	211750 1,2
PrecisionBit for Torx Plus®, shank E 6.3 Torx Plus® profile 8IP	674252 8IP