

**Garant**
**HiPer-Drill base body, 3×D, Ø DC: 18 mm**

**Order data**

Order number	231605 18
GTIN	4045197602794
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<sub>c</sub>: 18 - 18.99 mm

Reach L<sub>1</sub>: 57 mm

Shank Ø D<sub>s</sub>: 25 mm

Shank length L<sub>s</sub>: 56 mm

Clamping screw: 231999\_8IP1 (1.2 Nm)

**Technical description**

Dia. range D <sub>c</sub>	18 - 18.99 mm
Reach L <sub>1</sub>	57 mm

Clamping screw	231999_8IP1 (1.2 Nm)
Shank $\varnothing D_s$	25 mm
Shank length $L_s$	56 mm
Number of cutting edges Z	2
Drill depth up to	3×D
Shank	ISO 9766
Use for drilling	limited drilling with oblique exit
Use for drilling	limited oblique spot drilling
Use for drilling	limited cross-drilling
Use for drilling	limited drilling through a stack
Through-coolant	yes
Type of product	Indexable drill

## Accessories

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