

**Garant**
**HiPer-Drill base body, 8xD, Ø DC: 24 mm**

**Order data**

Order number	231615 24
GTIN	4045197603296
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 1.5xD with the drill No. 231600 with the same cutter insert size and type is necessary. **The generation of a pilot hole improves process reliability.**

Number of cutting edges Z: 2

Dia. range  $D_c$ : 24 - 24.99 mm

Reach  $L_1$ : 200 mm

Shank Ø  $D_s$ : 32 mm

Shank length  $L_s$ : 60 mm

Clamping screw: 231999\_10IP (3.3 Nm)

**Technical description**

Reach $L_1$	200 mm
Shank $\varnothing D_s$	32 mm
Dia. range $D_c$	24 - 24.99 mm
Clamping screw	231999_10IP (3.3 Nm)
Shank length $L_s$	60 mm
Number of cutting edges Z	2
Drill depth up to	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

Torx Plus® screw Drive 10IP	231999 10IP
PrecisionBit for Torx Plus®, shank E 6.3 Torx Plus® profile 10IP	674252 10IP
Torque screwdriver with scale, to take interchangeable blades maximum torque 1600 cNm	659906 1600
8 mm blade with magnet with 1/4 inch bit holder overall length 50 mm	659874 50