

Garant
HiPer-Drill base body, 10xD, Ø DC: 22 mm

Order data

Order number	231617 22
GTIN	4045197869036
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.**

Polished flutes.

Application:

For stationary and rotating use. For holes up to IT9 accuracy.

Recommendation:

Drill the pilot hole.

Note:

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.

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 feed rates f by 10 % and v_c values by 30 %.

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 : 22 - 22.99 mm

Reach L_1 : 230 mm

Shank Ø D_s : 25 mm

Shank length L_s : 56 mm

Clamping screw: 231999_10IP (3.3 Nm)

Technical description

Shank $\varnothing D_s$	25 mm
Dia. range D_c	22 - 22.99 mm
Reach L_1	230 mm
Shank length L_s	56 mm
Clamping screw	231999_10IP (3.3 Nm)
Number of cutting edges Z	2
Drill depth up to	10xD
Shank	ISO 9766
Use for drilling	limited drilling through a stack
Use for drilling	limited drilling with oblique exit
Use for drilling	limited cross-drilling
Use for drilling	limited oblique spot drilling
Through-coolant	yes
Type of product	Indexable drill

Accessories

Torx Plus® screw Drive 10IP	231999 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
PrecisionBit for Torx Plus®, shank E 6.3 Torx Plus® profile 10IP	674252 10IP