

**Garant**
**HiPer-Drill base body, 10×D, Ø DC: 24 mm**

**Order data**

Order number	231617 24
GTIN	4045197869050
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 1.5×D with the drill No. 231600 with the same cutter insert size and type is necessary. **The generation of a pilot hole improves process reliability.**

**process reliability.**

Number of cutting edges Z: 2

Dia. range  $D_c$ : 24 - 24.99 mm

Reach  $L_1$ : 250 mm

Shank Ø  $D_s$ : 32 mm

Shank length  $L_s$ : 60 mm

Clamping screw: 231999\_10IP (3.3 Nm)

## Technical description

Dia. range $D_c$	24 - 24.99 mm
Shank length $L_s$	60 mm
Shank $\varnothing D_s$	32 mm
Reach $L_1$	250 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
8 mm blade with magnet with 1/4 inch bit holder overall length 50 mm	659874 50
Torque screwdriver with scale, to take interchangeable blades maximum torque 1600 cNm	659906 1600
PrecisionBit for Torx Plus®, shank E 6.3 Torx Plus® profile 10IP	674252 10IP