

Garant
HiPer-Drill base body, 12×D, Ø DC: 39mm

Order data

Order number	231620 39
GTIN	4062406641757
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:

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

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.

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.**

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.

Reduce feed rates f by 10 % and v_c values by 40 %.

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Technical description

Clamping screw	231999 25IP
Reach L_1	492 mm

Shank length L _s	70 mm
Shank Ø D _s	40 mm
Number of cutting edges Z	2
Series	HiPer-Drill
Dia. range D _c	39 - 40.99 mm
Overall length L	617 mm
Version	12xD
Shank	ISO 9766
Use for drilling	limited cross-drilling
Use for drilling	limited drilling through a stack
Use for drilling	limited oblique spot drilling
Use for drilling	limited drilling with oblique exit
Through-coolant	yes
Type of product	Indexable drill

Accessories

Torx Plus® screw Drive 25IP	231999 25IP
PrecisionBit for Torx Plus®, 1/4 inch E 6.3 Torx Plus® profile 25IP	674252 25IP