Garant

# Solid carbide NC high performance drill FS, plain shank DIN 6535 HB, TiAlN, ∅ DC h7: 18,06-Xmm

## Order data

| | |
|---|---|
| Order number | 122545 18,06-X |
| GTIN | 4062406081331 |
| Item class | 11E |

## Description

**Version:**
**Particularly strong** due to strengthened core and **special profile.** Special point geometry.
**High concentricity** and **long tool life. Precision drilling qualities.**
**Note:**
Flute length $L_C = L_2 + 1.5 \times D_C$. Delivery time: 12 working weeks
Minimum order quantity: 3 pcs
Items made to order for a specific customer:
Cancellation only up to a maximum of 3 working days after receipt of order acknowledgement. Items cannot be returned. We reserve the right to over-deliver or under-deliver by ±10% (minimum 1 piece).

## Technical description

| | |
|---|---|
| Tolerance nominal ∅ | h7 |
| Number of cutting edges Z | 2 |
| Overall length L | 153 mm |
| Shank ∅ $D_s$ | 20 mm |
| Standard | DIN 6537 |
| Feed f in steel < 750 N/mm$^2$ | 0.45 mm/rev. |
| Flute length $L_c$ | 101 mm |
| ∅ range | 18.06 - 20.05 mm |
| Coating | TiAlN |

| | |
|---|---|
| Tool material | Solid carbide |
| Version | 6×D |
| Type | FS |
| Point angle | 140 degrees |
| Shank | DIN 6535 HB to h6 |
| Through-coolant | no |
| Semi-Standard | yes |
| Colour ring | green |
| Type of product | Jobber drill |

## User data

| | Suitability | $V_c$ | ISO code |
|---|---|---|---|
| Alu plastics | suitable | 190 m/min | N |
| Aluminium (short chipping) | suitable | 170 m/min | N |
| Alu > 10% Si | suitable | 140 m/min | N |
| Steel < 500 N/mm² | suitable | 90 m/min | P |
| Steel < 750 N/mm² | suitable | 85 m/min | P |
| Steel < 900 N/mm² | suitable | 75 m/min | P |
| Steel < 1100 N/mm² | suitable | 65 m/min | P |
| Steel < 1400 N/mm² | suitable | 40 m/min | P |
| INOX < 900 N/mm² | suitable only under restricted conditions | 40 m/min | M |
| INOX > 900 N/mm² | suitable only under restricted conditions | 30 m/min | M |
| Ti > 850 N/mm² | suitable only under restricted conditions | 25 m/min | S |
| GG(G) | suitable only under restricted conditions | 70 m/min | K |
| CuZn | suitable only under restricted conditions | 160 m/min | N |

| | |
|---|---|
| Uni | suitable |
| wet maximum | suitable |
| dry | suitable |