



Solid carbide drill plain shank DIN 6535 HB, TiAlN, Ø DC m7 (mm or inch): 18



Order data

Order number	122772 18
GTIN	4062406149994
Item class	12F

Description

Version:

Tool specially matched to drilling holes without through-coolant. **Concave major cutting edges** and a **special flute profile** ensure a good chip evacuation. The sturdy cutter geometry with **special point geometry** and 4 cutting edges ensures drilling with good process reliability. A wide range of applications in steel materials thanks to a combination of tough ultra-fine grain carbide and extremely **wear-resistant** and **heat-resistant coating**.

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.

Through-coolant: no

Standard: DIN 6537

Tolerance nominal Ø: m7

Number of cutting edges Z: 2

recommended maximum drilling depth L_2 : 66 mm

Tolerance nominal Ø: m7

Overall length L: 143 mm

Shank Ø D_s : 18 mm

Feed f in steel < 900 N/mm²: 0.28 mm/rev.

Technical description

recommended maximum drilling depth L_2	66 mm
Nominal Ø D_c	18 mm
Flute length L_c	93 mm
Shank Ø D_s	18 mm

Feed f in steel < 900 N/mm ²	0.28 mm/rev.
Number of cutting edges Z	2
Tolerance nominal Ø	m7
Overall length L	143 mm
Standard	DIN 6537
Coating	TiAlN
Tool material	Solid carbide
Version	6×D
Point angle	140°
Shank	DIN 6535 HB to h6
Through-coolant	no
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	200 m/min	N
Alu > 10% Si	suitable only under restricted conditions	160 m/min	N
Steel < 500 N/mm ²	suitable	110 m/min	P
Steel < 750 N/mm ²	suitable	90 m/min	P
Steel < 900 N/mm ²	suitable	80 m/min	P
Steel < 1100 N/mm ²	suitable	70 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	60 m/min	P
GG	suitable	90 m/min	K
GGG	suitable only under restricted conditions	60 m/min	K
Uni	suitable		

wet maximum	suitable
dry	suitable only under restricted conditions