



## Solid carbide drill plain shank DIN 6535 HE, TiAlN, Ø DC m7 (mm or inch): 18,5



### Order data

Order number	122773 18,5
GTIN	4062406151447
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  $L_2$ : 73.25 mm

Tolerance nominal Ø: m7

Overall length L: 153 mm

Shank Ø  $D_s$ : 20 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.28 mm/rev.

### Technical description

Tolerance nominal Ø	m7
Overall length L	153 mm
Number of cutting edges Z	2
recommended maximum drilling depth $L_2$	73.25 mm
Standard	DIN 6537

Shank $\varnothing D_s$	20 mm
Feed f in steel < 900 N/mm <sup>2</sup>	0.28 mm/rev.
Nominal $\varnothing D_c$	18.5 mm
Flute length $L_c$	101 mm
Coating	TiAlN
Tool material	Solid carbide
Version	6xD
Point angle	140°
Shank	DIN 6535 HE 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 <sup>2</sup>	suitable	110 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	70 m/min	P
Steel < 1400 N/mm <sup>2</sup>	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