



## Solid carbide high performance drill, Whistle-Notch shank DIN 6535 HE, TiN, Ø DC h7: 18mm



### Order data

|              |               |
|--------------|---------------|
| Order number | 122355 18     |
| GTIN         | 4045197394279 |
| Item class   | 12E           |

### Description

#### Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. **Straight major cutting edges** with slightly honed edges and special flute profile produce **short chips**.

#### Note:

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

**NEW GENERATION AVAILABLE!**

**Recommended successor product is No. 122508.**

### Technical description

|                                          |              |
|------------------------------------------|--------------|
| Flute length $L_c$                       | 73 mm        |
| Number of cutting edges Z                | 2            |
| Shank tolerance                          | h6           |
| Nominal $\varnothing D_c$                | 18 mm        |
| Feed f in steel < 900 N/mm <sup>2</sup>  | 0.28 mm/rev. |
| Tolerance nominal $\varnothing$          | h7           |
| Shank $\varnothing D_s$                  | 18 mm        |
| Overall length L                         | 123 mm       |
| Standard                                 | DIN 6537 K   |
| recommended maximum drilling depth $L_2$ | 46 mm        |

|                 |                   |
|-----------------|-------------------|
| Coating         | TiN               |
| Tool material   | Solid carbide     |
| Version         | 4xD               |
| Point angle     | 140 degrees       |
| Shank           | DIN 6535 HE to h6 |
| Through-coolant | yes, with 25 bar  |
| Colour ring     | green             |
| Type of product | Jobber drill      |

### User data

|                                | Suitability                               | V <sub>c</sub> | ISO code |
|--------------------------------|-------------------------------------------|----------------|----------|
| Aluminium (short chipping)     | suitable only under restricted conditions | 240 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 only under restricted conditions | 65 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable only under restricted conditions | 35 m/min       | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 35 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable                                  | 30 m/min       | M        |
| Ti > 850 N/mm <sup>2</sup>     | suitable                                  | 30 m/min       | S        |
| Uni                            | suitable                                  |                |          |
| wet maximum                    | suitable                                  |                |          |
| wet minimum                    | suitable                                  |                |          |
| Air                            | suitable only under restricted conditions |                |          |