



Solid carbide high performance drill plain shank DIN 6535 HA, TiAlN, Ø DC m7: 18mm



Order data

Order number	122394 18
GTIN	4045197419903
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 $L_c = L_2 + 1.5 \times D_c$.

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 122396**.

Form **HE**: order with **No. 122398**.

Through-coolant: no

Standard: DIN 6537 K

Tolerance nominal Ø: m7

Number of cutting edges Z: 2

recommended maximum drilling depth L_2 : 46 mm

Tolerance nominal Ø: m7

Overall length L: 123 mm

Shank Ø D_s : 18 mm

Feed f in stainless steel < 900 N/mm²: 0.16 mm/rev.

Technical description

Flute length L_c	73 mm
Nominal Ø D_c	18 mm
Feed f in stainless steel < 900 N/mm ²	0.16 mm/rev.

Number of cutting edges Z	2
Shank tolerance	h6
Tolerance nominal \varnothing	m7
Shank $\varnothing D_s$	18 mm
Overall length L	123 mm
Standard	DIN 6537 K
recommended maximum drilling depth L_2	46 mm
Coating	TiAlN
Tool material	Solid carbide
Version	4xD
Point angle	140°
Shank	DIN 6535 HA to h6
Through-coolant	no
Colour ring	blue
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	140 m/min	N
Alu > 10% Si	suitable only under restricted conditions	120 m/min	N
Steel < 500 N/mm ²	suitable	80 m/min	P
Steel < 750 N/mm ²	suitable	75 m/min	P
Steel < 900 N/mm ²	suitable	65 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	60 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	35 m/min	P
INOX < 900 N/mm ²	suitable	35 m/min	M

INOX > 900 N/mm ²	suitable	30 m/min	M
GG	suitable only under restricted conditions	70 m/min	K
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		