



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



Order data

| | |
|--------------|---------------|
| Order number | 122396 18 |
| GTIN | 4045197424068 |
| 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 $L_c = L_2 + 1.5 \times D_c$.

Technical description

| | |
|---|--------------|
| 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 |
| Flute length L_c | 73 mm |
| Shank tolerance | h6 |
| Tolerance nominal Ø | m7 |
| Shank Ø 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 degrees |
| Shank | DIN 6535 HB 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 |
| Uni | suitable | | |
| wet maximum | suitable | | |
| wet minimum | suitable only under restricted conditions | | |

