HOLEX

Solid carbide jobber drill, TiN, ⌀ DC h7: 1,8mm

Order data

Order number	122301 1,8
GTIN	4045197042231
Item class	12E

Description

Version:
Similar to DIN 338.
Nominal ⌀ and shank ⌀ equal.
TiN coating.
Note:
Flute length $L_C = L_2 + 1.5 \times D_C$.
Non slip clamping in drill chuck No. 341050 with diamond coated jaws.

Technical description

Shank tolerance	h7
Nominal ⌀ D_C	1.8 mm
Feed f in steel < 1100 N/mm^2	0.03 mm/rev.
Flute length L_c	22 mm
Number of cutting edges Z	2
Tolerance nominal ⌀	h7
Shank ⌀ D_s	1.8 mm
Overall length L	46 mm
Standard	DIN 338
recommended maximum drilling depth L_2	19.3 mm
Coating	TiN
Tool material	Solid carbide

Type	N
Point angle	118 degrees
Helix angle	30 degrees
Shank	Parallel shank to h7
Through-coolant	no
Colour ring	without
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Alu plastics	suitable only under restricted conditions	230 m/min	N
Aluminium (short chipping)	suitable	160 m/min	N
Alu > 10% Si	suitable	160 m/min	N
Steel < 500 N/mm²	suitable	80 m/min	P
Steel < 750 N/mm²	suitable	80 m/min	P
Steel < 900 N/mm²	suitable	70 m/min	P
Steel < 1100 N/mm²	suitable	50 m/min	P
Steel < 1400 N/mm²	suitable	30 m/min	P
INOX < 900 N/mm²	suitable only under restricted conditions	30 m/min	M
INOX > 900 N/mm²	suitable only under restricted conditions	25 m/min	M
Ti > 850 N/mm²	suitable	20 m/min	S
GG(G)	suitable	85 m/min	K
CuZn	suitable	160 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		

dry	suitable only under restricted conditions