



Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø h7: 18 mm

Order data

Order number	122500 18
GTIN	4045197050878
Item class	11E

Description

Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. **Convex cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

Recommendation:

Maximum drilling depth:

clamping slot length (see table) less 1.5×nominal Ø.

Note:

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

Form **HB**: order with **No. 122445/122505**.

Form **HE**: order with **No. 122440/122500** and **129100HE**.

NEW GENERATION AVAILABLE!

Recommended successor products are No. 122415; 122425 and 122435.

Tool material: Solid carbide

Drill depth up to: 4×D

Point angle: 140 degrees

Schaft: DIN 6535 HA to h6

Through-coolant: yes, with 25 bar

Machining strategy: HPC

Norm: DIN 6537 K

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

Flute length: 73 mm

Overall length L_{tot} : 123 mm

Shank Ø: 18 mm

Feed f in steel < 1100 N/mm²: 0.35 mm/rev.

Technical description

Hole tolerance	
Cutting direction	
Use for drilling	
Pilot drill required	
Through-coolant	yes, with 25 bar
Colour ring	green
Tool material	Solid carbide
Coating	TiAlN
Drill depth up to	4×D
Type	
Helix angle	degrees
Machining strategy	HPC
Point angle	140 degrees
Schaft	DIN 6535 HA to h6
Series	
Type of product	