



## Solid carbide high performance drill, Weldon shank DIN 6535 HB, TiN, Ø DC h7: 18mm



### Order data

|              |               |
|--------------|---------------|
| Order number | 122315 18     |
| GTIN         | 4045197387516 |
| 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

|  |              |
|--|--------------|
| Flute length $L_c$                       | 73 mm        |
| Nominal $\varnothing D_c$                | 18 mm        |
| Feed $f$ in steel $< 900 \text{ N/mm}^2$ | 0.28 mm/rev. |
| Number of cutting edges $Z$              | 2            |
| Shank tolerance                          | h6           |
| 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 HB to h6 |
| Through-coolant | no                |
| Semi-Standard   | yes               |
| Colour ring     | without           |
| Type of product | Jobber drill      |

### User data

|                                | Suitability                               | V <sub>c</sub> | 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 <sup>2</sup>  | suitable                                  | 80 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 75 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 65 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable only under restricted conditions | 60 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable only under restricted conditions | 35 m/min       | P        |
| GG(G)                          | suitable only under restricted conditions | 70 m/min       | K        |
| wet maximum                    | suitable                                  |                |          |
| dry                            | suitable                                  |                |          |