



Solid carbide high performance drill, Weldon shank DIN 6535 HB, TiN, Ø DC h7: 18,5mm



Order data

Order number	122315 18,5
GTIN	4045197387523
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	79 mm
Feed f in steel $< 900 \text{ N/mm}^2$	0.28 mm/rev.
Nominal $\varnothing D_c$	18.5 mm
Number of cutting edges Z	2
Shank tolerance	h6
Tolerance nominal \varnothing	h7
Shank $\varnothing D_s$	20 mm
Overall length L	131 mm
Standard	DIN 6537 K
recommended maximum drilling depth L_2	51.3 mm
Coating	TiN

Tool material	Solid carbide
Version	4×D
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 _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
GG(G)	suitable only under restricted conditions	70 m/min	K
wet maximum	suitable		
dry	suitable		