



Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø h7: 18,5 mm

Order data

Order number	123102 18,5
GTIN	4045197459022
Item class	11E

Description

Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**.

Particularly high alignment accuracy due to **4 guide chamfers** which stabilise the drill even at extreme depths!

Convex cutting edges with honed edges and special flute profile for **short chips**, even on long chipping materials.

Advantage:

High process reliability and surface quality of the hole.

Recommendation:

Maximum drilling depth:

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

Note:

NEW GENERATION AVAILABLE!

Recommended successor products are No. 123026 and 123036.

Tool material: Solid carbide

Drill depth up to: 8×D

Point angle: 135 degrees

Skaft: DIN 6535 HB to h6

Through-coolant: yes, with 25 bar

Machining strategy: HPC

Norm: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

Flute length: 190 mm

Overall length L_{tot} : 243 mm

Shank Ø: 20 mm

Feed f in steel < 1100 N/mm²: 0.3 mm/rev.

Technical description

Use for drilling	
Drill depth up to	8×D
Type	
Helix angle	degrees
Tool material	Solid carbide
Coating	TiAlN
Point angle	135 degrees
Through-coolant	yes, with 25 bar
Pilot drill required	
Colour ring	green
Hole tolerance	
Cutting direction	
Machining strategy	HPC
Skaft	DIN 6535 HB to h6
Series	
Type of product	