

**Solid carbide high performance drill, Weldon shank DIN 6535 HB, TiN, Ø DC
h7: 18,06-Xmm****Order data**

Order number	122315 18,06-X
GTIN	4062406076139
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 $L_c = L_2 + 1.5 \times D_c$. Delivery time: 12 working weeks

Minimum order quantity: 3 pcs

Items made to order for a specific customer:

Cancellation only up to a maximum of 3 working days after receipt of order acknowledgement.

Items cannot be returned. We reserve the right to over-deliver or under-deliver by $\pm 10\%$ (minimum 1 piece).

Technical description

Flute length L_c	79 mm
Feed f in steel $< 900 \text{ N/mm}^2$	0.28 mm/rev.
Shank $\varnothing D_s$	20 mm
Tolerance nominal \varnothing	h7
Standard	DIN 6537 K
Number of cutting edges Z	2
Overall length L	131 mm
\varnothing range	18.06 - 20.05 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 _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		