HOLEX

Solid carbide high performance drill plain shank DIN 6535 HA, TiN, ∅ DC h7 (mm or inch): 18,06-X

Order data

Order number	122630 18,06-X
GTIN	4062406078423
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 $L_C = L_2 + 1.5 \times D_C$.
Form HB and HE supplied at the same price as HA.
Form **HB:** order with **No. 122635**.
Form **HE:** order with **No. 122640**.
NEW GENERATION AVAILABLE!
Recommended successor product is No. 122776. 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 ±10% (minimum 1 piece).

Technical description

Standard	DIN 6537
Flute length L_c	101 mm
Number of cutting edges Z	2
Tolerance nominal ∅	h7

Feed f in steel < 900 N/mm²	0.28 mm/rev.
Shank ∅ D_s	20 mm
Overall length L	153 mm
∅ range	18.06 - 20.05 mm
Coating	TiN
Tool material	Solid carbide
Version	6×D
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	240 m/min	N
Steel < 500 N/mm²	suitable	110 m/min	P
Steel < 750 N/mm²	suitable	90 m/min	P
Steel < 900 N/mm²	suitable	80 m/min	P
Steel < 1100 N/mm²	suitable only under restricted conditions	65 m/min	P
Steel < 1400 N/mm²	suitable only under restricted conditions	30 m/min	P
INOX < 900 N/mm²	suitable	35 m/min	M
INOX > 900 N/mm²	suitable	30 m/min	M
Ti > 850 N/mm²	suitable	30 m/min	S
Uni	suitable		
wet maximum	suitable		

wet minimum	suitable
Air	suitable only under restricted conditions