



Solid carbide high performance drill plain shank DIN 6535 HA, TiN, Ø 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 $\pm 10\%$ (minimum 1 piece).

Technical description

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|---------------------------------|----------|
| Standard | DIN 6537 |
| Flute length L_c | 101 mm |
| Number of cutting edges Z | 2 |
| Tolerance nominal \varnothing | h7 |

| | |
|---|-------------------|
| Feed f in steel < 900 N/mm ² | 0.28 mm/rev. |
| Shank Ø D _s | 20 mm |
| Overall length L | 153 mm |
| Ø 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/mm ² | suitable | 110 m/min | P |
| Steel < 750 N/mm ² | suitable | 90 m/min | P |
| Steel < 900 N/mm ² | suitable | 80 m/min | P |
| Steel < 1100 N/mm ² | suitable only under restricted conditions | 65 m/min | P |
| Steel < 1400 N/mm ² | suitable only under restricted conditions | 30 m/min | P |
| INOX < 900 N/mm ² | suitable | 35 m/min | M |
| INOX > 900 N/mm ² | suitable | 30 m/min | M |
| Ti > 850 N/mm ² | suitable | 30 m/min | S |
| Uni | suitable | | |
| wet maximum | suitable | | |

| | |
|-------------|---|
| wet minimum | suitable |
| Air | suitable only under restricted conditions |