Garant

Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, ∅ DC m6 (∅ DC X = h7): 18,02-Xmm

Order data

Order number	122661 18,02-X
GTIN	4062406078959
Item class	11E

Description

Version:
Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry.** High roundness and alignment accuracy of the deep hole, thanks to **4 guide chamfers.** Outstanding chip evacuation due to **4 internal cooling channels** from ∅ 3.8 mm. Up to 3.7 mm ∅ with 2 internal cooling channels. **Straight major cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.
Attention:
Sizes **ending with X** = cutter ∅ tolerance **h7.**
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 ±10% (minimum 1 piece).

Technical description

Tolerance nominal ∅	h7
Standard	DIN 6537
Shank ∅ D_s	20 mm
Feed f in stainless steel > 900 N/mm^2	0.25 mm/rev.
Flute length L_c	101 mm

Overall length L	153 mm
Number of cutting edges Z	2
∅ range	18.02 - 20.05 mm
Coating	TiAlN
Tool material	Solid carbide
Version	6×D
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	blue
Type of product	Jobber drill

User data

	Suitability	**V_c**	**ISO code**
Steel < 500 N/mm^2	suitable	170 m/min	P
Steel < 750 N/mm^2	suitable	140 m/min	P
Steel < 900 N/mm^2	suitable	130 m/min	P
Steel < 1100 N/mm^2	suitable	110 m/min	P
Steel < 1400 N/mm^2	suitable	70 m/min	P
INOX < 900 N/mm^2	suitable	90 m/min	M
INOX > 900 N/mm^2	suitable	80 m/min	M
GG(G)	suitable	95 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		