



Solid carbide drill plain shank DIN 6535 HE, TiAlN, Ø DC m7 (mm or inch): 18 mm or inch



Order data

Order number	122773 18
GTIN	4062406151430
Item class	12F

Description

Version:

Tool specially matched to drilling holes without through-coolant. **Concave major cutting edges** and a **special flute profile** ensure a good chip evacuation. The sturdy cutter geometry with **special point geometry** and 4 cutting edges ensures drilling with good process reliability. A wide range of applications in steel materials thanks to a combination of tough ultra-fine grain carbide and extremely **wear-resistant** and **heat-resistant coating**.

Recommendation:

Maximum drilling depth:

Flute length (see table) less 1.5×nominal Ø.

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.

Through-coolant: no

Standard: DIN 6537

Tolerance nominal Ø: m7

Number of cutting edges Z: 2

Tolerance nominal Ø: m7

recommended maximum drilling depth L_2 : 66 mm

Overall length L: 143 mm

Shank Ø D_s : 18 mm

Feed f in steel < 900 N/mm²: 0.28 mm/rev.

Technical description

Overall length L	143 mm
Standard	DIN 6537

Tolerance nominal \varnothing	m7
Nominal $\varnothing D_c$	18 mm
Number of cutting edges Z	2
recommended maximum drilling depth L_2	66 mm
Shank $\varnothing D_s$	18 mm
Flute length L_c	93 mm
Feed f in steel < 900 N/mm ²	0.28 mm/rev.
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	6×D
Point angle	140 degrees
Shank	DIN 6535 HE to h6
Through-coolant	no
Colour ring	green
Type of product	Jobber drill