



## Solid carbide high performance drill, plain shank DIN 6535 HA, TiN, Ø DC h7 (mm or inch): 18,5 mm or inch



### Order data

Order number	122340 18,5
GTIN	4045197045249
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**.

#### Recommendation:

##### Maximum drilling depth:

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

##### Note:

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

#### NEW GENERATION AVAILABLE!

##### Recommended successor product is No. 122504.

Versions with HB and HE shank available at the same price as HA.

**HB shank:** use order **No. 122345**.

**HE shank:** use order **No. 122355**.

Semi-Standard: yes

Standard: DIN 6537 K

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 51.3 mm

Overall length L: 131 mm

Shank Ø  $D_s$ : 20 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.28 mm/rev.

### Technical description

Feed f in steel < 900 N/mm <sup>2</sup>	0.28 mm/rev.
Flute length L <sub>c</sub>	79 mm
Nominal Ø D <sub>c</sub>	18.5 mm
Shank tolerance	h6
Number of cutting edges Z	2
Tolerance nominal Ø	h7
Shank Ø D <sub>s</sub>	20 mm
Overall length L	131 mm
Standard	DIN 6537 K
recommended maximum drilling depth L <sub>2</sub>	51.3 mm
Coating	TiN
Tool material	Solid carbide
Drill depth up to	4×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