



Solid carbide high performance drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m7: 18 mm



Order data

Order number	122396 18
GTIN	4045197424068
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:

clamping slot length (see table) less $1.5 \times \text{nominal } \varnothing$.

Note:

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

Through-coolant: no

Standard: DIN 6537 K

Tolerance nominal \varnothing : m7

Number of cutting edges Z: 2

Tolerance nominal \varnothing : m7

recommended maximum drilling depth L_2 : 46 mm

Overall length L: 123 mm

Shank $\varnothing D_s$: 18 mm

Feed f in stainless steel $< 900 \text{ N/mm}^2$: 0.16 mm/rev.

Technical description

Nominal $\varnothing D_c$	18 mm
Feed f in stainless steel $< 900 \text{ N/mm}^2$	0.16 mm/rev.
Number of cutting edges Z	2
Flute length L_c	73 mm

Shank tolerance	h6
Tolerance nominal \varnothing	m7
Shank $\varnothing D_s$	18 mm
Overall length L	123 mm
Standard	DIN 6537 K
recommended maximum drilling depth L_2	46 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	4xD
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	no
Colour ring	blue
Type of product	Jobber drill