



Solid carbide high performance drill plain shank DIN 6535 HA, TiAlN, Ø DC m7: 18,5 mm



Order data

Order number	122404 18,5
GTIN	4045197421005
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 $L_c = L_2 + 1.5 \times D_c$.

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 122406**.

Form **HE**: order with **No. 122408**.

Through-coolant: yes, with 25 bar

Standard: DIN 6537 K

Tolerance nominal Ø: m7

Number of cutting edges Z: 2

Tolerance nominal Ø: m7

recommended maximum drilling depth L_2 : 51.3 mm

Overall length L: 131 mm

Shank Ø D_s : 20 mm

Feed f in stainless steel < 900 N/mm²: 0.16 mm/rev.

Technical description

Flute length L_c	79 mm
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Feed f in stainless steel < 900 N/mm ²	0.16 mm/rev.
Number of cutting edges Z	2
Shank tolerance	h6
Nominal Ø D _c	18.5 mm
Tolerance nominal Ø	m7
Shank Ø D _s	20 mm
Overall length L	131 mm
Standard	DIN 6537 K
recommended maximum drilling depth L ₂	51.3 mm
Coating	TiAlN
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
Colour ring	blue
Type of product	Jobber drill