



## Solid carbide high performance drill, Whistle-Notch shank DIN 6535 HE, TiAlN, Ø DC m7: 18,5 mm



### Order data

|              |               |
|--------------|---------------|
| Order number | 122408 18,5   |
| GTIN         | 4045197428394 |
| 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×nominal Ø.

#### Note:

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

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/mm<sup>2</sup>: 0.16 mm/rev.

### Technical description

|   |              |
|---|--------------|
| Flute length $L_c$                                | 79 mm        |
| Feed f in stainless steel < 900 N/mm <sup>2</sup> | 0.16 mm/rev. |
| Number of cutting edges Z                         | 2            |
| Nominal Ø $D_c$                                   | 18.5 mm      |

|  |                   |
|--|-------------------|
| Shank tolerance                          | h6                |
| Tolerance nominal $\varnothing$          | m7                |
| Shank $\varnothing D_s$                  | 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                        | 4xD               |
| Point angle                              | 140 degrees       |
| Shank                                    | DIN 6535 HE to h6 |
| Through-coolant                          | yes, with 25 bar  |
| Colour ring                              | blue              |
| Type of product                          | Jobber drill      |