



## Solid carbide high performance drill Weldon shank DIN 6535 HB, TiN, Ø DC h7: 18,5 mm



### Order data

Order number	122635 18,5
GTIN	4045197395399
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  $L_c = L_2 + 1.5 \times D_c$ .

#### NEW GENERATION AVAILABLE!

**Recommended successor product is No. 122777.**

Through-coolant: yes, with 25 bar

Standard: DIN 6537

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 73.3 mm

Overall length L: 153 mm

Shank Ø  $D_s$ : 20 mm

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

### Technical description

Nominal Ø $D_c$	18.5 mm
Shank tolerance	h6

Flute length $L_c$	101 mm
Feed $f$ in steel $< 900 \text{ N/mm}^2$	0.28 mm/rev.
Number of cutting edges $Z$	2
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	20 mm
Overall length $L$	153 mm
Standard	DIN 6537
recommended maximum drilling depth $L_2$	73.3 mm
Coating	TiN
Tool material	Solid carbide
Drill depth up to	6×D
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Colour ring	green
Type of product	Jobber drill