



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



Order data

Order number	122635 18
GTIN	4045197395382
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 : 66 mm

Overall length L: 143 mm

Shank Ø D_s : 18 mm

Feed f in steel < 900 N/mm²: 0.28 mm/rev.

Technical description

Feed f in steel < 900 N/mm ²	0.28 mm/rev.
Nominal Ø D_c	18 mm

Flute length L_c	93 mm
Shank tolerance	h6
Number of cutting edges Z	2
Tolerance nominal \varnothing	h7
Shank $\varnothing D_s$	18 mm
Overall length L	143 mm
Standard	DIN 6537
recommended maximum drilling depth L_2	66 mm
Coating	TiN
Tool material	Solid carbide
Drill depth up to	6xD
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Colour ring	green
Type of product	Jobber drill