### HOLEX

## HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAIN, Ø DC h7 (mm or inch): 1,6 mm or inch



### Order data

Order number	122501 1,6
GTIN	4045197824059
Item class	12F

### Description

### Version:

#### HOLEX Pro Steel:

**Straight major cutting edges** and a **special flute profile** ensure good chip evacuation. The robust cutter geometry ensures high-performance drilling with good process reliability. A wide range of applications in steel materials thanks to a combination of tough ultra-fine grain carbide and an extremely wear-resistant coating.

Up to  $\emptyset$  1.9 with 4 facets, from  $\emptyset$  2 with relieved cone.

# 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  $1.5 \times nominal \emptyset$ .

### Note:

Flute length  $L_c = L_2 + 1.5 \times D_c$ . Version HB and HE supplied at the same price as HA. Form **HB:** state **No. 122502**. Form **HE:** state **No. 122503**. Machining strategy: HPC Standard: DIN 6537 K Tolerance nominal  $\emptyset$ : h7 Number of cutting edges Z: 2 Tolerance nominal  $\emptyset$ : h7 recommended maximum drilling depth  $L_2$ : 7.1 mm Overall length L: 50 mm Shank  $\emptyset$  D<sub>s</sub>: 4 mm Feed f in steel < 900 N/mm<sup>2</sup>: 0.05 mm/rev.

### **Technical description**

Shank Ø D,4 mmNumber of cutting edges Z2recommended maximum drilling depth L27.1 mmOverall length L50 mmNominal Ø Dc1.6 mmStandardDIN 6537 KFeed f in steel < 900 N/mm²0.05 mm/rev.Tolerance nominal Øh7SeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringJobber drill	Flute length L <sub>c</sub>	9.5 mm
recommended maximum drilling depth L <sub>2</sub> 7.1 mm Overall length L 50 mm Nominal Ø D <sub>c</sub> 1.6 mm Standard DIN 6537 K Feed f in steel < 900 N/mm <sup>2</sup> 0.05 mm/rev. Tolerance nominal Ø h7 Series HOLEX Pro Steel Coating TiAlN Tool material Solid carbide Drill depth up to 4×D Point angle 140 degrees Shank DIN 6535 HA to h6 Through-coolant no Machining strategy HC	Shank Ø D <sub>s</sub>	4 mm
Overall length L50 mmNominal Ø Dc1.6 mmStandardDIN 6537 KFeed f in steel < 900 N/mm²	Number of cutting edges Z	2
Nominal Ø Dc1.6 mmStandardDIN 6537 KFeed f in steel < 900 N/mm²	recommended maximum drilling depth L <sub>2</sub>	7.1 mm
StandardDIN 6537 KFeed f in steel < 900 N/mm²	Overall length L	50 mm
Feed f in steel < 900 N/mm²0.05 mm/rev.Tolerance nominal Øh7SeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	Nominal Ø D <sub>c</sub>	1.6 mm
Tolerance nominal Øh7SeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	Standard	DIN 6537 K
SeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	Feed f in steel < 900 N/mm <sup>2</sup>	0.05 mm/rev.
CoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	Tolerance nominal Ø	h7
Tool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	Series	HOLEX Pro Steel
Drill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	Coating	TiAIN
Point angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	Tool material	Solid carbide
ShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	Drill depth up to	4×D
Through-coolantnoMachining strategyHPCColour ringgreen	Point angle	140 degrees
Machining strategy HPC   Colour ring green	Shank	DIN 6535 HA to h6
Colour ring green	Through-coolant	no
	Machining strategy	HPC
Type of product Jobber drill	Colour ring	green
	Type of product	Jobber drill