

# HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAIN, Ø DC h7 (mm or inch): 1,8 mm or inch



## **Order data**

Order number	122504 1,8
GTIN	4045197825513
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 extremely wear-resistant coating.

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

#### **Recommendation:**

### Maximum drilling depth:

flute length (see table) less  $1.5 \times \text{nominal } \emptyset$ .

#### 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. 122507**. Form **HE:** state **No. 122508**. Machining strategy: HPC Standard: DIN 6537 K Tolerance nominal Ø: h7 Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth L<sub>2</sub>: 8.3 mm

Overall length L: 50 mm Shank Ø D.: 4 mm

Feed f in steel  $< 900 \text{ N/mm}^2$ : 0.07 mm/rev.

# **Technical description**

Tolerance nominal Øh7StandardDIN 6537 KFlute length $L_c$ 11 mmNominal Ø $D_c$ 1.8 mmrecommended maximum drilling depth $L_2$ 8.3 mmNumber of cutting edges Z2Feed f in steel < 900 N/mm²0.07 mm/rev.SeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPC	Overall length L	50 mm
Standard       DIN 6537 K         Flute length $L_c$ 11 mm         Nominal Ø $D_c$ 1.8 mm         recommended maximum drilling depth $L_2$ 8.3 mm         Number of cutting edges Z       2         Feed f in steel < 900 N/mm²	Shank Ø D <sub>s</sub>	4 mm
Flute length $L_c$ 11 mm  Nominal $\varnothing$ $D_C$ 1.8 mm  recommended maximum drilling depth $L_2$ 8.3 mm  Number of cutting edges $Z$ 2  Feed f in steel $< 900 \text{ N/mm}^2$ 0.07 mm/rev.  Series HOLEX Pro Steel  Coating TiAIN  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  Machining strategy HPC  Colour ring green	Tolerance nominal Ø	h7
Nominal $\varnothing$ Dc1.8 mmrecommended maximum drilling depth L28.3 mmNumber of cutting edges Z2Feed f in steel < 900 N/mm²	Standard	DIN 6537 K
recommended maximum drilling depth L <sub>2</sub> Number of cutting edges Z  Feed f in steel < 900 N/mm²  O.07 mm/rev.  Series  HOLEX Pro Steel  Coating  TiAIN  Tool material  Solid carbide  Drill depth up to  4×D  Point angle  Shank  DIN 6535 HA to h6  Through-coolant  Machining strategy  HPC  Colour ring  8.3 mm  8.3 mm  8.3 mm  8.3 mm  DIN 6535 HA  DIN 6535 HA  HPC  Green	Flute length L <sub>c</sub>	11 mm
Number of cutting edges Z  Feed f in steel < 900 N/mm²	Nominal Ø D <sub>c</sub>	1.8 mm
Feed f in steel < 900 N/mm²  Series  HOLEX Pro Steel  TiAIN  Tool material  Solid carbide  Drill depth up to  Point angle  Shank  DIN 6535 HA to h6  Through-coolant  Machining strategy  Colour ring  0.07 mm/rev.  HOLEX Pro Steel  140 A  DIN 6535 HA to h6  HPC  Golour ring  green	recommended maximum drilling depth L <sub>2</sub>	8.3 mm
Series HOLEX Pro Steel  Coating TiAIN  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  Machining strategy HPC  Colour ring green	Number of cutting edges Z	2
Coating TiAIN  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  Machining strategy HPC  Colour ring green	Feed f in steel < 900 N/mm <sup>2</sup>	0.07 mm/rev.
Tool material  Drill depth up to  Point angle  Shank  DIN 6535 HA to h6  Through-coolant  Machining strategy  Colour ring  Solid carbide  4×D  140 degrees  140 degrees  HPC  Green	Series	HOLEX Pro Steel
Drill depth up to 4×D  Point angle 140 degrees  Shank DIN 6535 HA to h6  Through-coolant yes, with 25 bar  Machining strategy HPC  Colour ring green	Coating	TiAlN
Point angle 140 degrees  Shank DIN 6535 HA to h6  Through-coolant yes, with 25 bar  Machining strategy HPC  Colour ring green	Tool material	Solid carbide
Shank DIN 6535 HA to h6 Through-coolant yes, with 25 bar Machining strategy HPC Colour ring green	Drill depth up to	4×D
Through-coolant yes, with 25 bar  Machining strategy HPC  Colour ring green	Point angle	140 degrees
Machining strategy HPC Colour ring green	Shank	DIN 6535 HA to h6
Colour ring green	Through-coolant	yes, with 25 bar
-	Machining strategy	HPC
Type of product Jobber drill	Colour ring	green
	Type of product	Jobber drill