

HOLEX
HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 21/32 mm or inch

Order data

Order number	122504 21/32
GTIN	4062406110949
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 Ø 1.9 with 4 facets, from Ø 2 with relieved cone.

Recommendation:
Maximum drilling depth:

flute length (see table) less 1.5×nominal Ø.

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_2 : 48.3 mm

Overall length L: 123 mm

Shank Ø D_s : 18 mm

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

Technical description

Flute length L_c	73 mm
Feed f in steel $< 900 \text{ N/mm}^2$	0.28 mm/rev.
Standard	DIN 6537 K
Shank $\varnothing D_s$	18 mm
Tolerance nominal \varnothing	h7
recommended maximum drilling depth L_2	48.3 mm
Overall length L	123 mm
Number of cutting edges Z	2
Inch nominal \varnothing corresponds to	16.67 mm
Series	HOLEX Pro Steel
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	4xD
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Colour ring	green
Type of product	Jobber drill