#### HOLEX

# 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	122776 1/8
GTIN	4045197957337
Item class	12F

#### Description

#### Version:

#### **HOLEX Pro Steel:**

**Straight major cutting edges** and a **special flute profile** ensure good chip evacuation. The robust cutting edge 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  $1.5 \times nominal \emptyset$ .

#### 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. 122777**. Form **HE**: state **No. 122778**. Machining strategy: HPC Standard: DIN 6537 Tolerance nominal Ø: h7 Number of cutting edges Z: 2 Tolerance nominal Ø: h7 recommended maximum drilling depth L<sub>2</sub>: 23.3 mm Overall length L: 66 mm Shank Ø D<sub>s</sub>: 6 mm Feed f in steel < 900 N/mm<sup>2</sup>: 0.11 mm/rev.

#### **Technical description**

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### Data sheet

Number of cutting edges Z2StandardDIN 6537Tolerance nominal Øh7recommended maximum drilling depth L223.3 mmFlute length L428 mmShank Ø D56 mmInch nominal Ø corresponds to3.18 mmSeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to6 xDPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCColour ringGreen	Overall length L	66 mm
StandardDIN 6537Tolerance nominal Øh7recommended maximum drilling depth L223.3 mmFlute length Lc28 mmShank Ø D36 mmInch nominal Ø corresponds to3.18 mmSeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCColour ringgreen	Feed f in steel < 900 N/mm <sup>2</sup>	0.11 mm/rev.
Tolerance nominal Øh7recommended maximum drilling depth L223.3 mmFlute length LC28 mmShank Ø D36 mmInch nominal Ø corresponds to3.18 mmSeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to6 xDPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCColour ringgreen	Number of cutting edges Z	2
recommended maximum drilling depth L <sub>2</sub> 23.3 mm Flute length L <sub>c</sub> 28 mm Shank Ø D, 6 mm Inch nominal Ø corresponds to 3.18 mm Series HOLEX Pro Steel Coating TiAlN Tool material Solid carbide Drill depth up to 6×D Point angle 140 degrees Shank DIN 6535 HA to h6 Through-coolant yes, with 25 bar Machining strategy HPC Colour ring Green	Standard	DIN 6537
Flute length Lc28 mmShank Ø D,6 mmInch nominal Ø corresponds to3.18 mmSeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCColour ringgreen	Tolerance nominal Ø	h7
Shank Ø Ds6 mmInch nominal Ø corresponds to3.18 mmSeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCColour ringgreen	recommended maximum drilling depth $L_2$	23.3 mm
Inch nominal Ø corresponds to3.18 mmSeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCColour ringgreen	Flute length L <sub>c</sub>	28 mm
SeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCColour ringgreen	Shank Ø D <sub>s</sub>	6 mm
CoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCColour ringgreen	Inch nominal Ø corresponds to	3.18 mm
Tool materialSolid carbideDrill depth up to6×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCColour ringgreen	Series	HOLEX Pro Steel
Drill depth up to6×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCColour ringgreen	Coating	TiAIN
Point angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCColour ringgreen	Tool material	Solid carbide
ShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCColour ringgreen	Drill depth up to	6×D
Through-coolantyes, with 25 barMachining strategyHPCColour ringgreen	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