HOLEX

HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAIN, Ø DC h7 (mm or inch): 14,8 mm or inch



Order data

Order number	122501 14,8
GTIN	4045197825209
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 : 42.8 mm Overall length L: 115 mm Shank \emptyset D_s: 16 mm Feed f in steel < 900 N/mm²: 0.26 mm/rev.

Technical description

Feed f in steel < 900 N/mm²	Overall length L	115 mm
Flute length L65 mmTolerance nominal Øh7StandardDIN 6537 KNominal Ø Dc14.8 mmNumber of cutting edges Z2recommended maximum drilling depth L242.8 mmSeriesHOLEX Pro SteelCoatingTiAlNTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	Feed f in steel < 900 N/mm ²	0.26 mm/rev.
Tolerance nominal Øh7StandardDIN 6537 KNominal Ø Dc14.8 mmNumber of cutting edges Z2recommended maximum drilling depth L242.8 mmSeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	Shank Ø D _s	16 mm
StandardDIN 6537 KNominal Ø Dc14.8 mmNumber of cutting edges Z2recommended maximum drilling depth L242.8 mmSeriesHOLEX Pro SteelCoatingTIAINTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	Flute length L _c	65 mm
Nominal Ø Dc14.8 mmNumber of cutting edges Z2recommended maximum drilling depth L242.8 mmSeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	Tolerance nominal Ø	h7
Number of cutting edges Z2recommended maximum drilling depth L242.8 mmSeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	Standard	DIN 6537 K
recommended maximum drilling depth L ₂ 42.8 mm 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 HPC Colour ring green	Nominal Ø D _c	14.8 mm
SeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	Number of cutting edges Z	2
CoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	recommended maximum drilling depth L_2	42.8 mm
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 strategyHPCColour ringgreen	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