## HOLEX

HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAIN, Ø DC h7 (mm or inch): 16,5 mm or inch



## Order data

Order number	122501 16,5
GTIN	4045197825285
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<sub>2</sub>: 48.3 mm Overall length L: 123 mm Shank  $\emptyset$  D<sub>s</sub>: 18 mm Feed f in steel < 900 N/mm<sup>2</sup>: 0.28 mm/rev.

# **Technical description**

Overall length L123 mmFlute length Lc73 mmNumber of cutting edges Z2Feed f in steel < 900 N/mm²0.28 mm/rev.recommended maximum drilling depth L248.3 mmStandardDIN 6537 KShank Ø D,18 mmNominal Ø Dc16.5 mmSeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreenType of productJobber drill	Tolerance nominal Ø	h7
Number of cutting edges Z2Feed f in steel < 900 N/mm²	Overall length L	123 mm
Feed f in steel < 900 N/mm²0.28 mm/rev.recommended maximum drilling depth L₂48.3 mmStandardDIN 6537 KShank Ø D₅18 mmNominal Ø Dc16.5 mmSeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	Flute length L <sub>c</sub>	73 mm
recommended maximum drilling depth L <sub>2</sub> 48.3 mm Standard DIN 6537 K Shank Ø D <sub>s</sub> 18 mm Nominal Ø D <sub>c</sub> 116.5 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	Number of cutting edges Z	2
StandardDIN 6537 KShank Ø Ds18 mmNominal Ø Dc16.5 mmSeriesHOLEX 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>	0.28 mm/rev.
Shank Ø Ds18 mmNominal Ø Dc16.5 mmSeriesHOLEX Pro SteelCoatingTIAINTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	recommended maximum drilling depth $L_2$	48.3 mm
Nominal Ø Dc16.5 mmSeriesHOLEX 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	Shank Ø D <sub>s</sub>	18 mm
CoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	Nominal Ø D <sub>c</sub>	16.5 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 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