HOLEX

HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAIN, Ø DC h7 (mm or inch): 2,4 mm or inch



Order data

Order number	122501 2,4
GTIN	4045197824134
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 : 10.9 mm Overall length L: 55 mm Shank \emptyset D_s: 4 mm Feed f in steel < 900 N/mm²: 0.09 mm/rev.

Data sheet

Technical description

Nominal Ø Dc2.4 mmOverall length L55 mmStandardDIN 6537 KFlute length Lc14.5 mmrecommended maximum drilling depth Lc10.9 mmTolerance nominal Øh7Feed f in steel < 900 N/mm²0.09 mm/rev.SeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Though-coolantnoMachining strategyHPCColour ringgreen	Number of cutting edges Z	2
Overall length L55 mmStandardDIN 6537 KFlute length L14.5 mmrecommended maximum drilling depth L10.9 mmTolerance nominal Øh7Feed f in steel < 900 N/mm²	Shank Ø D _s	4 mm
StandardDIN 6537 KFlute length Lc14.5 mmrecommended maximum drilling depth L210.9 mmTolerance nominal Øh7Feed f in steel < 900 N/mm²	Nominal Ø D _c	2.4 mm
Flute length Lc14.5 mmrecommended maximum drilling depth L210.9 mmTolerance nominal Øh7Feed f in steel < 900 N/mm²	Overall length L	55 mm
recommended maximum drilling depth L ₂ 10.9 mm Tolerance nominal Ø h7 Feed f in steel < 900 N/mm ² 0.09 mm/rev. Series 6 HOLEX Pro Steel Coating TiAlN Tool material 6 Solid carbide Drill depth up to 6 4×D Point angle 140 degrees Shank 140 degrees Shank 0 IN 6535 HA to h6 Through-coolant no Machining strategy 140 Colour ring 0 green	Standard	DIN 6537 K
Tolerance nominal Øh7Feed f in steel < 900 N/mm²	Flute length L _c	14.5 mm
Feed f in steel < 900 N/mm²0.09 mm/rev.SeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	recommended maximum drilling depth L_2	10.9 mm
SeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	Tolerance nominal Ø	h7
CoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	Feed f in steel < 900 N/mm ²	0.09 mm/rev.
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