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 |