### HOLEX

## HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAIN, Ø DC h7 (mm or inch): 5,9 mm or inch



### Order data

Order number	122501 5,9
GTIN	4045197824486
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  $L_2$ : 19.2 mm Overall length L: 66 mm Shank  $\emptyset$  D<sub>s</sub>: 6 mm Feed f in steel < 900 N/mm<sup>2</sup>: 0.14 mm/rev.

### **Technical description**

Tolerance nominal Øh7Number of cutting edges Z2Flute length Lc28 mmStandardDIN 6537 KOverall length L66 mmSeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	Shank Ø D <sub>s</sub>	6 mm
Feed f in steel < 900 N/mm²0.14 mm/rev.Tolerance nominal Øh7Number of cutting edges Z2Flute length Lc28 mmStandardDIN 6537 KOverall length L66 mmSeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	Nominal Ø D <sub>c</sub>	5.9 mm
Tolerance nominal Øh7Number of cutting edges Z2Flute length Lc28 mmStandardDIN 6537 KOverall length L66 mmSeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	recommended maximum drilling depth L <sub>2</sub>	19.2 mm
Number of cutting edges Z2Flute length L28 mmStandardDIN 6537 KOverall length L66 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>	0.14 mm/rev.
Flute length Lc28 mmStandardDIN 6537 KOverall length L66 mmSeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	Tolerance nominal Ø	h7
StandardDIN 6537 KOverall length L66 mmSeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	Number of cutting edges Z	2
Overall length L66 mmSeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	Flute length L <sub>c</sub>	28 mm
SeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	Standard	DIN 6537 K
CoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantnoMachining strategyHPCColour ringgreen	Overall length L	66 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