



## HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 6,8 mm or inch



### Order data

|              |               |
|--------------|---------------|
| Order number | 122501 6,8    |
| GTIN         | 4045197824578 |
| 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 Ø 1.9 with 4 facets, from Ø 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  $1.5 \times \text{nominal } \varnothing$ .

#### 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 Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 23.8 mm

Overall length L: 79 mm

Shank Ø  $D_s$ : 8 mm

Feed f in steel <  $900 \text{ N/mm}^2$ : 0.18 mm/rev.

## Technical description

|  |                   |
|--|-------------------|
| Shank $\varnothing D_s$                  | 8 mm              |
| Number of cutting edges Z                | 2                 |
| Nominal $\varnothing D_c$                | 6.8 mm            |
| Standard                                 | DIN 6537 K        |
| Tolerance nominal $\varnothing$          | h7                |
| recommended maximum drilling depth $L_2$ | 23.8 mm           |
| Flute length $L_c$                       | 34 mm             |
| Overall length L                         | 79 mm             |
| Feed f in steel < 900 N/mm <sup>2</sup>  | 0.18 mm/rev.      |
| 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             |
| Type of product                          | Jobber drill      |