



## HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 7,7 mm or inch



### Order data

Order number	122501 7,7
GTIN	4045197824660
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  $L_2$ : 29.5 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

Nominal $\varnothing D_c$	7.7 mm
Number of cutting edges Z	2
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	8 mm
Feed f in steel < 900 N/mm <sup>2</sup>	0.18 mm/rev.
recommended maximum drilling depth L <sub>2</sub>	29.5 mm
Overall length L	79 mm
Standard	DIN 6537 K
Flute length L <sub>c</sub>	41 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
Type of product	Jobber drill