



HOLEX Pro Steel solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7 (mm or inch): 3,9 mm or inch



Order data

Order number	122502 3,9
GTIN	4045197830500
Item class	12F

Description

Version:

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 extremely wear-resistant coating.

Recommendation:

Maximum drilling depth:

clamping slot length (see table) less 1.5×nominal Ø.

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.

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 : 18.2 mm

Overall length L: 66 mm

Shank Ø D_s : 6 mm

Feed f in steel < 900 N/mm²: 0.11 mm/rev.

Technical description

Tolerance nominal Ø	h7
Feed f in steel < 900 N/mm ²	0.11 mm/rev.
Flute length L_c	24 mm

recommended maximum drilling depth L_2	18.2 mm
Nominal $\varnothing D_c$	3.9 mm
Shank $\varnothing D_s$	6 mm
Overall length L	66 mm
Standard	DIN 6537 K
Number of cutting edges Z	2
Series	HOLEX Pro Steel
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	4×D
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	no
Machining strategy	HPC
Colour ring	green
Type of product	Jobber drill