



HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 18,5 mm or inch



Order data

| | |
|--------------|---------------|
| Order number | 122504 18,5 |
| GTIN | 4045197826817 |
| 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 extremely wear-resistant coating.

Up to Ø 1.9 with 4 facets, from Ø 2 with relieved cone.

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. 122507**.

Form **HE**: state **No. 122508**.

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 : 51.3 mm

Overall length L: 131 mm

Shank Ø D_s : 20 mm

Feed f in steel < 900 N/mm²: 0.28 mm/rev.

Technical description

| | |
|---|-------------------|
| Standard | DIN 6537 K |
| Feed f in steel < 900 N/mm ² | 0.28 mm/rev. |
| Nominal Ø D _c | 18.5 mm |
| Shank Ø D _s | 20 mm |
| recommended maximum drilling depth L ₂ | 51.3 mm |
| Number of cutting edges Z | 2 |
| Overall length L | 131 mm |
| Tolerance nominal Ø | h7 |
| Flute length L _c | 79 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 | yes, with 25 bar |
| Machining strategy | HPC |
| Colour ring | green |
| Type of product | Jobber drill |