

# HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAIN, Ø DC h7 (mm or inch): 2,2 mm or inch



### **Order data**

Order number	122504 2,2
GTIN	4045197825551
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  $\varnothing$  1.9 with 4 facets, from  $\varnothing$  2 with relieved cone.

#### **Recommendation:**

## **Maximum drilling depth:**

flute length (see table) less  $1.5 \times \text{nominal } \emptyset$ .

#### 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. 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<sub>2</sub>: 9.7 mm

Overall length L: 55 mm Shank Ø D<sub>c</sub>: 4 mm

Feed f in steel  $< 900 \text{ N/mm}^2$ : 0.07 mm/rev.

## **Technical description**

Tolerance nominal Ø       h7         Standard       DIN 6537 K         Feed f in steel < 900 N/mm²       0.07 mm/rev.         Overall length L       55 mm         Number of cutting edges Z       2         Nominal Ø Dc       2.2 mm         recommended maximum drilling depth L₂       9.7 mm         Series       HOLEX Pro Steel         Coating       TiAIN         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	Flute length L <sub>c</sub>	13 mm
Standard       DIN 6537 K         Feed f in steel < 900 N/mm²	Shank Ø D <sub>s</sub>	4 mm
Feed f in steel < 900 N/mm²  Overall length L  S5 mm  Number of cutting edges Z  Nominal Ø D <sub>C</sub> 2.2 mm  recommended maximum drilling depth L <sub>2</sub> Series  HOLEX Pro Steel  Coating  TiAIN  Tool material  Solid carbide  Drill depth up to  4×D  Point angle  Shank  DIN 6535 HA to h6  Through-coolant  Machining strategy  HPC  Colour ring  0.07 mm/rev.  55 mm  Number of cutting edges Z  2  Nominal Solid carbide  140 degrees  HPC  Glour ring  green	Tolerance nominal Ø	h7
Overall length L       55 mm         Number of cutting edges Z       2         Nominal Ø Dc       2.2 mm         recommended maximum drilling depth L₂       9.7 mm         Series       HOLEX Pro Steel         Coating       TiAIN         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	Standard	DIN 6537 K
Number of cutting edges Z2Nominal $\oslash$ Dc2.2 mmrecommended maximum drilling depth L29.7 mmSeriesHOLEX Pro SteelCoatingTiAINTool materialSolid carbideDrill depth up to $4 \times D$ Point angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCColour ringgreen	Feed f in steel < 900 N/mm <sup>2</sup>	0.07 mm/rev.
Nominal Ø D <sub>c</sub> recommended maximum drilling depth L₂  9.7 mm  Series  HOLEX Pro Steel  Coating  TiAIN  Tool material  Solid carbide  Drill depth up to  4×D  Point angle  Shank  DIN 6535 HA to h6  Through-coolant  Machining strategy  HPC  Colour ring  2.2 mm  2.2 mm  2.2 mm  9.7 mm  Solid carbide  TiAIN  Solid carbide  DIN 6535 HA to h6  Through-coolant  yes, with 25 bar	Overall length L	55 mm
recommended maximum drilling depth L <sub>2</sub> Series  HOLEX Pro Steel  TiAIN  Tool material  Solid carbide  Drill depth up to  Point angle  Shank  DIN 6535 HA to h6  Through-coolant  Machining strategy  HPC  Colour ring  green	Number of cutting edges Z	2
Series HOLEX Pro Steel  Coating TiAIN  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	Nominal Ø D <sub>c</sub>	2.2 mm
Coating TiAIN  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	recommended maximum drilling depth $L_2$	9.7 mm
Tool material  Drill depth up to  Point angle  Shank  DIN 6535 HA to h6  Through-coolant  Machining strategy  Colour ring  Solid carbide  4×D  140 degrees  140 degrees  HPC  Green	Series	HOLEX Pro Steel
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	Coating	TiAIN
Point angle 140 degrees  Shank DIN 6535 HA to h6  Through-coolant yes, with 25 bar  Machining strategy HPC  Colour ring green	Tool material	Solid carbide
Shank DIN 6535 HA to h6 Through-coolant yes, with 25 bar Machining strategy HPC Colour ring green	Drill depth up to	4×D
Through-coolant yes, with 25 bar  Machining strategy HPC  Colour ring green	Point angle	140 degrees
Machining strategy HPC Colour ring green	Shank	DIN 6535 HA to h6
Colour ring green	Through-coolant	yes, with 25 bar
-	Machining strategy	HPC
Type of product Jobber drill	Colour ring	green
	Type of product	Jobber drill