

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

**Order data**

Order number	122504 3,9
GTIN	4045197825728
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  $1.5 \times$  nominal Ø.

**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  $L_2$ : 18.2 mm

Overall length L: 66 mm

Shank Ø  $D_s$ : 6 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.11 mm/rev.

**Technical description**

Standard	DIN 6537 K
Overall length L	66 mm
Tolerance nominal $\varnothing$	h7
Nominal $\varnothing D_c$	3.9 mm
Shank $\varnothing D_s$	6 mm
Number of cutting edges Z	2
recommended maximum drilling depth $L_2$	18.2 mm
Flute length $L_c$	24 mm
Feed f in steel < 900 N/mm <sup>2</sup>	0.11 mm/rev.
Series	HOLEX Pro Steel
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	4xD
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