



HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 8,2 mm or inch



Order data

Order number	122504 8,2
GTIN	4045197826152
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 : 34.7 mm

Overall length L: 89 mm

Shank Ø D_s : 10 mm

Feed f in steel < 900 N/mm²: 0.2 mm/rev.

Technical description

Nominal $\varnothing D_c$	8.2 mm
recommended maximum drilling depth L_2	34.7 mm
Feed f in steel $< 900 \text{ N/mm}^2$	0.2 mm/rev.
Overall length L	89 mm
Standard	DIN 6537 K
Shank $\varnothing D_s$	10 mm
Number of cutting edges Z	2
Flute length L_c	47 mm
Tolerance nominal \varnothing	h7
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