



HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 8,4 mm or inch



Order data

Order number	122504 8,4
GTIN	4045197826176
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 : 34.4 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

Tolerance nominal \varnothing	h7
Flute length L_c	47 mm
Shank $\varnothing D_s$	10 mm
Number of cutting edges Z	2
Feed f in steel < 900 N/mm ²	0.2 mm/rev.
recommended maximum drilling depth L_2	34.4 mm
Nominal $\varnothing D_c$	8.4 mm
Standard	DIN 6537 K
Overall length L	89 mm
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