



## HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 8,5 mm or inch



### Order data

Order number	122504 8,5
GTIN	4045197826183
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  $L_2$ : 34.3 mm

Overall length L: 89 mm

Shank Ø  $D_s$ : 10 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.2 mm/rev.

### Technical description

Flute length $L_c$	47 mm
recommended maximum drilling depth $L_2$	34.3 mm
Number of cutting edges $Z$	2
Tolerance nominal $\varnothing$	h7
Feed $f$ in steel $< 900 \text{ N/mm}^2$	0.2 mm/rev.
Nominal $\varnothing D_c$	8.5 mm
Standard	DIN 6537 K
Shank $\varnothing D_s$	10 mm
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