



## HOLEX Pro Steel solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7 (mm or inch): 13,8 mm or inch



### Order data

Order number	122507 13,8
GTIN	4045197832627
Item class	12F

### Description

#### Version:

**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.

#### Recommendation:

##### Maximum drilling depth:

clamping slot length (see table) less  $1.5 \times \text{nominal } \varnothing$ .

##### Note:

Flute length  $L_c = L_2 + 1.5 \times D_c$ .

Machining strategy: HPC

Standard: DIN 6537 K

Tolerance nominal  $\varnothing$ : h7

Number of cutting edges Z: 2

Tolerance nominal  $\varnothing$ : h7

recommended maximum drilling depth  $L_2$ : 39.3 mm

Overall length L: 107 mm

Shank  $\varnothing D_s$ : 14 mm

Feed f in steel  $< 900 \text{ N/mm}^2$ : 0.26 mm/rev.

### Technical description

Flute length $L_c$	60 mm
recommended maximum drilling depth $L_2$	39.3 mm
Number of cutting edges Z	2

Overall length L	107 mm
Feed f in steel < 900 N/mm <sup>2</sup>	0.26 mm/rev.
Tolerance nominal Ø	h7
Nominal Ø D <sub>c</sub>	13.8 mm
Standard	DIN 6537 K
Shank Ø D <sub>s</sub>	14 mm
Series	HOLEX Pro Steel
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	4×D
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, to 25 bar
Machining strategy	HPC
Colour ring	green
Type of product	Jobber drill