



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



### Order data

Order number	122507 8,4
GTIN	4045197832191
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×nominal Ø.

##### Note:

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

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/mm<sup>2</sup>: 0.2 mm/rev.

### Technical description

Nominal Ø $D_c$	8.4 mm
Overall length L	89 mm
Number of cutting edges Z	2

Feed f in steel < 900 N/mm <sup>2</sup>	0.2 mm/rev.
Tolerance nominal Ø	h7
recommended maximum drilling depth L <sub>2</sub>	34.4 mm
Standard	DIN 6537 K
Flute length L <sub>c</sub>	47 mm
Shank Ø D <sub>s</sub>	10 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