



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



Order data

Order number	122507 8,5
GTIN	4045197832207
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 : 34.3 mm

Overall length L: 89 mm

Shank $\varnothing D_s$: 10 mm

Feed f in steel $< 900 \text{ N/mm}^2$: 0.2 mm/rev.

Technical description

Number of cutting edges Z	2
Shank $\varnothing D_s$	10 mm
Feed f in steel $< 900 \text{ N/mm}^2$	0.2 mm/rev.

Nominal $\varnothing D_c$	8.5 mm
Standard	DIN 6537 K
Overall length L	89 mm
Flute length L_c	47 mm
Tolerance nominal \varnothing	h7
recommended maximum drilling depth L_2	34.3 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