



## HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 19,5 mm or inch



### Order data

|              |               |
|--------------|---------------|
| Order number | 122776 19,5   |
| GTIN         | 4045197828330 |
| Item class   | 12F           |

### Description

#### Version:

#### HOLEX Pro Steel:

**Straight major cutting edges** and a **special flute profile** ensure good chip evacuation. The robust cutting edge 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×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. 122777**.

Form **HE**: state **No. 122778**.

Machining strategy: HPC

Standard: DIN 6537

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 71.8 mm

Overall length L: 153 mm

Shank Ø  $D_s$ : 20 mm

Feed  $f$  in steel < 900 N/mm<sup>2</sup>: 0.28 mm/rev.

### Technical description

|   |                   |
|---|-------------------|
| Feed f in steel < 900 N/mm <sup>2</sup>           | 0.28 mm/rev.      |
| Overall length L                                  | 153 mm            |
| Flute length L <sub>c</sub>                       | 101 mm            |
| Number of cutting edges Z                         | 2                 |
| recommended maximum drilling depth L <sub>2</sub> | 71.8 mm           |
| Tolerance nominal Ø                               | h7                |
| Standard  | DIN 6537          |
| Shank Ø D <sub>s</sub>                            | 20 mm             |
| Nominal Ø D <sub>c</sub>                          | 19.5 mm           |
| Series  | HOLEX Pro Steel   |
| Coating   | TiAlN             |
| Tool material                                     | Solid carbide     |
| Drill depth up to                                 | 6×D               |
| 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      |