

HOLEX
**HOLEX Pro Steel solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC
h7: 4,4mm**

Order data

Order number	123104 4,4
GTIN	4062406091033
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.

Note:

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

Technical description

Overall length L	81 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	36.4 mm
Flute length L_c	43 mm
Feed f in steel < 900 N/mm ²	0.13 mm/rev.
Tolerance nominal Ø	h7
Nominal Ø D_c	4.4 mm
Shank Ø D_s	6 mm
Number of cutting edges Z	2
Series	Pro Steel

Coating	TiAlN
Tool material	Solid carbide
Version	8xD
Point angle	135 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Alu plastics	suitable only under restricted conditions	250 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	200 m/min	N
Alu > 10% Si	suitable only under restricted conditions	160 m/min	N
Steel < 500 N/mm ²	suitable	125 m/min	P
Steel < 750 N/mm ²	suitable	115 m/min	P
Steel < 900 N/mm ²	suitable	95 m/min	P
Steel < 1100 N/mm ²	suitable	90 m/min	P
Steel < 1400 N/mm ²	suitable	65 m/min	P
INOX < 900 N/mm ²	suitable	35 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	30 m/min	M
GG	suitable	100 m/min	K
GGG	suitable	65 m/min	K
Uni	suitable		

wet maximum	suitable
wet minimum	suitable