



## HOLEX Pro Steel solid carbide drill, Whistle-Notch shank DIN 6535 HE, TiAlN, Ø DC h7: 15,1mm



### Order data

|              |               |
|--------------|---------------|
| Order number | 123109 15,1   |
| GTIN         | 4062406091385 |
| 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

|  |                         |
|--|-------------------------|
| Flute length $L_c$                       | 152 mm                  |
| Feed $f$ in steel $< 900 \text{ N/mm}^2$ | 0.23 mm/rev.            |
| Overall length $L$                       | 203 mm                  |
| recommended maximum drilling depth $L_2$ | 129.35 mm               |
| Tolerance nominal $\varnothing$          | h7                      |
| Nominal $\varnothing D_c$                | 15.1 mm                 |
| Number of cutting edges $Z$              | 2                       |
| Standard                                 | Manufacturer's standard |
| Shank $\varnothing D_s$                  | 16 mm                   |
| Series                                   | Pro Steel               |

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

### User data

|                                | Suitability                               | V <sub>c</sub> | 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 <sup>2</sup>  | suitable                                  | 125 m/min      | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 115 m/min      | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 95 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 90 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 65 m/min       | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 35 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | 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