



## HOLEX Pro Steel solid carbide drill, Whistle-Notch shank DIN 6535 HE, TiAlN, Ø DC h7 (mm or inch): W/L-16



### Order data

|              |               |
|--------------|---------------|
| Order number | 122503 W/L-16 |
| GTIN         | 4062406121938 |
| 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.

#### 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  $L_2$ : 17.25 mm

Overall length L: 66 mm

Shank Ø  $D_s$ : 6 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.14 mm/rev.

### Technical description

|   |              |
|---|--------------|
| Shank Ø $D_s$                           | 6 mm         |
| Standard                                | DIN 6537 K   |
| Overall length L                        | 66 mm        |
| Inch nominal Ø corresponds to           | 4.5 mm       |
| Feed f in steel < 900 N/mm <sup>2</sup> | 0.14 mm/rev. |

|   |                   |
|---|-------------------|
| Number of cutting edges Z                         | 2                 |
| Flute length L <sub>c</sub>                       | 24 mm             |
| Tolerance nominal Ø                               | h7                |
| recommended maximum drilling depth L <sub>2</sub> | 17.25 mm          |
| Coating   | TiAlN             |
| Tool material                                     | Solid carbide     |
| Version   | 4×D               |
| Point angle                                       | 140 °             |
| Shank   | DIN 6535 HE to h6 |
| Through-coolant                                   | no                |
| Machining strategy                                | HPC               |
| Colour ring                                       | green             |
| Type of product                                   | Jobber drill      |

## User data

|                                | Suitability                               | V <sub>c</sub> | ISO code |
|--------------------------------|---|----------------|----------|
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 115 m/min      | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 105 m/min      | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 85 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 80 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 60 m/min       | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 30 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 25 m/min       | M        |
| GG                             | suitable                                  | 90 m/min       | K        |
| GGG                            | suitable                                  | 55 m/min       | K        |
| wet maximum                    | suitable                                  |                |          |
| dry                            | suitable                                  |                |          |

