



## HOLEX Pro Steel solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7 (mm or inch): 1/4



### Order data

|              |               |
|--------------|---------------|
| Order number | 122507 1/4    |
| GTIN         | 4062406126452 |
| 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  $L_c = L_2 + 1.5 \times D_c$ .

Standard: DIN 6537 K

Tolerance nominal  $\varnothing$ : h7

Number of cutting edges Z: 2

Tolerance nominal  $\varnothing$ : h7

recommended maximum drilling depth  $L_2$ : 24.475 mm

Overall length L: 79 mm

Shank  $\varnothing D_s$ : 8 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.18 mm/rev.

### Technical description

|   |              |
|---|--------------|
| Flute length $L_c$                      | 34 mm        |
| Overall length L                        | 79 mm        |
| Tolerance nominal $\varnothing$         | h7           |
| Feed f in steel < 900 N/mm <sup>2</sup> | 0.18 mm/rev. |
| Number of cutting edges Z               | 2            |

|   |                   |
|---|-------------------|
| Inch nominal $\varnothing$ corresponds to | 6.35 mm           |
| Shank $\varnothing D_s$                   | 8 mm              |
| recommended maximum drilling depth $L_2$  | 24.475 mm         |
| Standard                                  | DIN 6537 K        |
| Series                                    | Pro Steel         |
| Coating                                   | TiAlN             |
| Tool material                             | Solid carbide     |
| Version                                   | 4xD               |
| Point angle                               | 140 °             |
| Shank                                     | DIN 6535 HB to h6 |
| Through-coolant                           | yes, to 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 <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                                  |           |   |