



HOLEX Pro Steel solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7 (mm or inch): 5/16



Order data

Order number	122507 5/16
GTIN	4062406126483
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 Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth L_2 : 29.09 mm

Overall length L: 79 mm

Shank Ø D_s : 8 mm

Feed f in steel < 900 N/mm²: 0.18 mm/rev.

Technical description

Number of cutting edges Z	2
Inch nominal Ø corresponds to	7,94 mm
recommended maximum drilling depth L_2	29.09 mm
Overall length L	79 mm
Standard	DIN 6537 K
Shank Ø D_s	8 mm

Flute length L_c	41 mm
Feed f in steel $< 900 \text{ N/mm}^2$	0.18 mm/rev.
Tolerance nominal \varnothing	h7
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 $> 10\% \text{ Si}$	suitable only under restricted conditions	160 m/min	N
Steel $< 500 \text{ N/mm}^2$	suitable	125 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	115 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	95 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	90 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable	65 m/min	P
INOX $< 900 \text{ N/mm}^2$	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		