HOLEX

# Solid carbide high performance drill plain shank DIN 6535 HE, TiN, Ø DC h7: 4,1mm

## Order data

| | |
|---|---|
| Order number | 122355 4,1 |
| GTIN | 4045197392060 |
| Item class | 12E |

## Description

**Version:**
Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry. Straight major cutting edges** with slightly honed edges and special flute profile produce **short chips.**
**Note:**
Flute length $L_C = L_2 + 1.5 \times D_C$.
**NEW GENERATION AVAILABLE!**
**Recommended successor product is No. 122508.**

## Technical description

| | |
|---|---|
| Feed f in steel < 900 N/mm$^2$ | 0.14 mm/rev. |
| Number of cutting edges Z | 2 |
| Nominal Ø $D_C$ | 4.1 mm |
| Flute length $L_c$ | 24 mm |
| Shank tolerance | h6 |
| Tolerance nominal Ø | h7 |
| Shank Ø $D_s$ | 6 mm |
| Overall length L | 66 mm |
| Standard | DIN 6537 K |
| recommended maximum drilling depth $L_2$ | 17.9 mm |

| | |
|---|---|
| Coating | TiN |
| Tool material | Solid carbide |
| Version | 4×D |
| Point angle | 140 degrees |
| Shank | DIN 6535 HE to h6 |
| Through-coolant | yes, with 25 bar |
| Colour ring | green |
| Type of product | Jobber drill |

## User data

| | Suitability | $V_c$ | ISO code |
|---|---|---|---|
| Aluminium (short chipping) | suitable only under restricted conditions | 240 m/min | N |
| Steel < 500 N/mm² | suitable | 110 m/min | P |
| Steel < 750 N/mm² | suitable | 90 m/min | P |
| Steel < 900 N/mm² | suitable | 80 m/min | P |
| Steel < 1100 N/mm² | suitable only under restricted conditions | 65 m/min | P |
| Steel < 1400 N/mm² | suitable only under restricted conditions | 35 m/min | P |
| INOX < 900 N/mm² | suitable | 35 m/min | M |
| INOX > 900 N/mm² | suitable | 30 m/min | M |
| Ti > 850 N/mm² | suitable | 30 m/min | S |
| Uni | suitable | | |
| wet maximum | suitable | | |
| wet minimum | suitable | | |
| Air | suitable only under restricted conditions | | |