

**HOLEX**
**Solid carbide drill plain shank DIN 6535 HA, AlTiN-Si, Ø DC m7 (mm or inch): 5,3**

**Order data**

Order number	122771 5,3
GTIN	4062406147556
Item class	12F

**Description**
**Version:**

Tool specially matched to drilling holes without through-coolant. **Concave major cutting edges** and a **special flute profile** ensure a good chip evacuation. The sturdy cutter geometry with **special point geometry** and 4 cutting edges ensures 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** and **heat-resistant coating**.

**Note:**

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 122772**.

Form **HE**: order with **No. 122773**.

Flute length  $L_c = L_2 + 1.5 \times D_c$ .

Through-coolant: no

Standard: DIN 6537

Tolerance nominal Ø: m7

Number of cutting edges Z: 2

recommended maximum drilling depth  $L_2$ : 36.1 mm

Tolerance nominal Ø: m7

Overall length L: 82 mm

Shank Ø  $D_s$ : 6 mm

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

**Technical description**

Nominal Ø $D_c$	5.3 mm
Shank Ø $D_s$	6 mm

Flute length $L_c$	44 mm
Feed $f$ in steel $< 900 \text{ N/mm}^2$	0.18 mm/rev.
Number of cutting edges $Z$	2
Overall length $L$	82 mm
Standard	DIN 6537
Tolerance nominal $\varnothing$	m7
recommended maximum drilling depth $L_2$	36.1 mm
Coating	AlTiN-Si
Tool material	Solid carbide
Version	6xD
Point angle	140 °
Shank	DIN 6535 HA to h6
Through-coolant	no
Colour ring	green
Type of product	Jobber drill

## User data

	Suitability	$V_c$	ISO code
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	110 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	90 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	80 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	70 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable only under restricted conditions	60 m/min	P
GG	suitable	90 m/min	K

GGG	suitable only under restricted conditions	60 m/min	K
Uni	suitable		
wet maximum	suitable		
dry	suitable only under restricted conditions		