HOLEX

Solid carbide drill plain shank DIN 6535 HA, AlTiN-Si, ⌀ DC m7 (mm or inch): 1,8

Order data

Order number	122771 1,8
GTIN	4062406147167
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 ⌀: m7
Number of cutting edges Z: 2
recommended maximum drilling depth L_2: 13.3 mm
Tolerance nominal ⌀: m7
Overall length L: 55 mm
Shank ⌀ D_s: 3 mm
Feed f in steel < 900 N/mm^2: 0.07 mm/rev.

Technical description

Tolerance nominal ⌀	m7
Overall length L	55 mm

Shank ⌀ D_s	3 mm
Standard	DIN 6537
Nominal ⌀ D_C	1.8 mm
Number of cutting edges Z	2
Feed f in steel < 900 N/mm²	0.07 mm/rev.
Flute length L_c	16 mm
recommended maximum drilling depth L_2	13.3 mm
Coating	AlTiN-Si
Tool material	Solid carbide
Version	6×D
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% Si	suitable only under restricted conditions	160 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	70 m/min	P
Steel < 1400 N/mm²	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		