HOLEX

# Solid carbide high performance drill Whistle-Notch shank DIN 6535 HE, TiAlN, ⌀ DC m7: 16mm

## Order data

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|---|---|
| Order number | 122668 16 |
| GTIN | 4045197429360 |
| 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 $L_C = L_2 + 1.5 \times D_C$.
Through-coolant: yes, with 25 bar
Standard: DIN 6537
Tolerance nominal ⌀: m7
Number of cutting edges Z: 2
recommended maximum drilling depth $L_2$: 59 mm
Tolerance nominal ⌀: m7
Overall length L: 133 mm
Shank ⌀ $D_s$: 16 mm
Feed f in stainless steel < 900 N/mm$^2$: 0.16 mm/rev.

## Technical description

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|---|---|
| Feed f in stainless steel < 900 N/mm$^2$ | 0.16 mm/rev. |
| Flute length $L_c$ | 83 mm |
| Number of cutting edges Z | 2 |
| Nominal ⌀ $D_C$ | 16 mm |
| Shank tolerance | h6 |

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|---|---|
| Tolerance nominal ∅ | m7 |
| Shank ∅ $D_s$ | 16 mm |
| Overall length L | 133 mm |
| Standard | DIN 6537 |
| recommended maximum drilling depth $L_2$ | 59 mm |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 6×D |
| Point angle | 140 ° |
| Shank | DIN 6535 HE to h6 |
| Through-coolant | yes, with 25 bar |
| Colour ring | blue |
| Type of product | Jobber drill |

## User data

| | Suitability | $V_c$ | ISO code |
|---|---|---|---|
| Aluminium (short chipping) | suitable only under restricted conditions | 140 m/min | N |
| Alu > 10% Si | suitable only under restricted conditions | 120 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 | 60 m/min | P |
| Steel < 1400 N/mm² | suitable only under restricted conditions | 35 m/min | P |
| INOX < 900 N/mm² | suitable | 45 m/min | M |
| INOX > 900 N/mm² | suitable | 40 m/min | M |
| Ti > 850 N/mm² | suitable | 32 m/min | S |

| | | | |
|---|---|---|---|
| GG | suitable only under restricted conditions | 70 m/min | K |
| Uni | suitable | | |
| wet maximum | suitable | | |
| wet minimum | suitable | | |
| Air | suitable | | |