HOLEX

Solid carbide high performance drill plain shank DIN 6535 HA, TiAlN, Ø DC m7: 14,2mm

Order data

Order number	122404 14,2
GTIN	4045197420855
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 $L_C = L_2 + 1.5 \times D_C$.
Form HB and HE supplied at the same price as HA.
Form **HB:** order with **No. 122406**.
Form **HE:** order with **No. 122408**.
Through-coolant: yes, with 25 bar
Standard: DIN 6537 K
Tolerance nominal Ø: m7
Number of cutting edges Z: 2
recommended maximum drilling depth L_2: 43.7 mm
Tolerance nominal Ø: m7
Overall length L: 115 mm
Shank Ø D_s: 16 mm
Feed f in stainless steel < 900 N/mm^2: 0.15 mm/rev.

Technical description

Number of cutting edges Z	2
Nominal Ø D_C	14.2 mm
Shank tolerance	h6

Flute length L_c	65 mm
Feed f in stainless steel < 900 N/mm²	0.15 mm/rev.
Tolerance nominal ∅	m7
Shank ∅ D_s	16 mm
Overall length L	115 mm
Standard	DIN 6537 K
recommended maximum drilling depth L_2	43.7 mm
Coating	TiAlN
Tool material	Solid carbide
Version	4×D
Point angle	140 °
Shank	DIN 6535 HA 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	30 m/min	S
GG	suitable only under restricted conditions	70 m/min	K
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		