

**HOLEX**
**Solid carbide high performance drill, plain shank DIN 6535 HA, TiN, Ø DC h7 (mm or inch): 1,9**

**Order data**

Order number	122340 1,9
GTIN	4045197262264
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. 122504.**

Versions with HB and HE shank available at the same price as HA.

**HB shank:** use order **No. 122345**.

**HE shank:** use order **No. 122355**.

**Technical description**

Nominal Ø $D_c$	1.9 mm
Feed $f$ in steel $< 900 \text{ N/mm}^2$	0.06 mm/rev.
Flute length $L_c$	14 mm
Shank tolerance	h6
Number of cutting edges $Z$	2
Tolerance nominal Ø	h7
Shank Ø $D_s$	4 mm
Overall length $L$	55 mm

Standard	DIN 6537 K
recommended maximum drilling depth L <sub>2</sub>	11.2 mm
Coating	TiN
Tool material	Solid carbide
Version	4×D
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

## User data

	Suitability	V <sub>c</sub>	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	240 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	110 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable only under restricted conditions	65 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	35 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	35 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	30 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	30 m/min	S
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		

Air

suitable only under  
restricted conditions