



HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 18,01-X



Order data

Order number	122776 18,01-X
GTIN	4062406662165
Item class	12F

Description

Version:

Straight major cutting edges and a **special flute profile** ensure a good chip evacuation. The robust cutter geometry ensures high-performance drilling with good process reliability. A wide range of applications in steel materials thanks to a combination of tough ultra-fine grain carbide and an extremely wear-resistant coating.

Up to Ø 1.9 with 4 facets, from Ø 2 with relieved cone.

Note:

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

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

For **HB shanks**: use order **no. 122777**.

For **HE shanks**: use order **No. 122778**. Delivery time: 10 weeks

Minimum order quantity: 5 pieces

Items made to order for a specific customer: Cancellation only up to a maximum of 3 working days after receipt of order acknowledgement. Items cannot be returned. We reserve the right to over-deliver or under-deliver by $\pm 10\%$ (minimum 1 piece).

Technical description

Standard	DIN 6537
Overall length L	153 mm
Ø range	18.01 - 20 mm
Flute length L_c	101 mm
Tolerance nominal Ø	h7

Shank $\varnothing D_s$	20 mm
Number of cutting edges Z	2
Series	Pro Steel
Coating	TiAlN
Tool material	Solid carbide
Version	6xD
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Alu plastics	suitable only under restricted conditions	250 m/min	N
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/mm ²	suitable	125 m/min	P
Steel < 750 N/mm ²	suitable	115 m/min	P
Steel < 900 N/mm ²	suitable	95 m/min	P
Steel < 1100 N/mm ²	suitable	90 m/min	P
Steel < 1400 N/mm ²	suitable	65 m/min	P
INOX < 900 N/mm ²	suitable	35 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	30 m/min	M

GG	suitable	100 m/min	K
GGG	suitable	65 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		