



## HOLEX Pro INOX solid carbide high-performance drill, plain shank DIN 6535 HE, AlTiN, Ø DC m7: 18mm



### Order data

|              |               |
|--------------|---------------|
| Order number | 122492 18     |
| GTIN         | 4067263011576 |
| Item class   | 12F           |

### Description

#### Version:

Efficient drilling especially for use in **stainless and acid-resistant steels**.

Straight main cutting edges with **optimised cutting edge design** for improved chip breaking behaviour. Enlarged chip grooves for **excellent chip evacuation**. Increased wear resistance due to **improved carbide substrate** and **high temperature resistant coating**.

#### Note:

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

HB and HE shanks are available at the same price as HA.

For **HB shanks**: use order **no. 122491**.

For **HE shanks**: use order **no. 122492**.

### Technical description

|   |              |
|---|--------------|
| Flute length $L_c$                                | 73 mm        |
| Nominal $\varnothing D_c$                         | 18 mm        |
| Tolerance nominal $\varnothing$                   | m7           |
| recommended maximum drilling depth $L_2$          | 46 mm        |
| Shank $\varnothing D_s$                           | 18 mm        |
| Number of cutting edges Z                         | 2            |
| Standard  | DIN 6537 K   |
| Overall length L                                  | 123 mm       |
| Feed f in stainless steel < 900 N/mm <sup>2</sup> | 0.18 mm/rev. |

|                 |                   |
|-----------------|-------------------|
| Series          | Pro Inox          |
| Coating         | AlTiN             |
| Tool material   | Solid carbide     |
| Version         | 4xD               |
| Point angle     | 140 degrees       |
| Shank           | DIN 6535 HE to h6 |
| Through-coolant | yes, with 25 bar  |
| Colour ring     | blue              |
| Type of product | Twist Drill       |

### User data

|                               | Suitability                               | V <sub>c</sub> | 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/mm <sup>2</sup> | suitable                                  | 120 m/min      | P        |
| Steel < 750 N/mm <sup>2</sup> | suitable                                  | 110 m/min      | P        |
| Steel < 900 N/mm <sup>2</sup> | suitable                                  | 80 m/min       | P        |
| INOX < 900 N/mm <sup>2</sup>  | suitable                                  | 55 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>  | suitable                                  | 45 m/min       | M        |
| Ti > 850 N/mm <sup>2</sup>    | suitable                                  | 35 m/min       | S        |
| wet maximum                   | suitable                                  |                |          |
| wet minimum                   | suitable only under restricted conditions |                |          |