



## HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 1



### Order data

Order number	122501 1
GTIN	4045197823953
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.

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  $L_c = L_2 + 1.5 \times D_c$ .

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

For **HB shanks**: use order **no. 122502**.

For **HE shanks**: use order **No. 122503**.

Standard: DIN 6537 K

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 4.5 mm

Overall length L: 45 mm

Shank Ø  $D_s$ : 4 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.05 mm/rev.

### Technical description

Standard	DIN 6537 K
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Number of cutting edges Z	2
Nominal $\varnothing D_c$	1 mm
Shank $\varnothing D_s$	4 mm
Overall length L	45 mm
Flute length $L_c$	6 mm
Feed f in steel < 900 N/mm <sup>2</sup>	0.05 mm/rev.
Tolerance nominal $\varnothing$	h7
recommended maximum drilling depth $L_2$	4.5 mm
Series	Pro Steel
Coating	TiAlN
Tool material	Solid carbide
Version	4xD
Point angle	140°
Shank	DIN 6535 HA to h6
Through-coolant	no
Machining strategy	HPC
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

## User data

	Suitability	$V_c$	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	115 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	105 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	85 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	60 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	30 m/min	M

INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	25 m/min	M
GG	suitable	90 m/min	K
GGG	suitable	55 m/min	K
Uni	suitable		
wet maximum	suitable		
dry	suitable		