



HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 1,8



Order data

| | |
|--------------|---------------|
| Order number | 122501 1,8 |
| GTIN | 4045197824073 |
| 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 : 8.3 mm

Overall length L: 50 mm

Shank Ø D_s : 4 mm

Feed f in steel < 900 N/mm²: 0.07 mm/rev.

Technical description

| | |
|-----------------|--------|
| Nominal Ø D_c | 1.8 mm |
|-----------------|--------|

| | |
|---|-------------------|
| Shank $\varnothing D_s$ | 4 mm |
| Standard | DIN 6537 K |
| Overall length L | 50 mm |
| Feed f in steel < 900 N/mm ² | 0.07 mm/rev. |
| Number of cutting edges Z | 2 |
| Tolerance nominal \varnothing | h7 |
| Flute length L _c | 11 mm |
| recommended maximum drilling depth L ₂ | 8.3 mm |
| Series | Pro Steel |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 4×D |
| 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 ² | suitable | 115 m/min | P |
| Steel < 750 N/mm ² | suitable | 105 m/min | P |
| Steel < 900 N/mm ² | suitable | 85 m/min | P |
| Steel < 1100 N/mm ² | suitable | 80 m/min | P |
| Steel < 1400 N/mm ² | suitable | 60 m/min | P |
| INOX < 900 N/mm ² | suitable | 30 m/min | M |

| | | | |
|------------------------------|---|----------|---|
| INOX > 900 N/mm ² | 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 | | |