



## HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 3,5



### Order data

|              |               |
|--------------|---------------|
| Order number | 122501 3,5    |
| GTIN         | 4045197824240 |
| 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  $L_2$ : 14.8 mm

Overall length L: 62 mm

Shank Ø  $D_s$ : 6 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.11 mm/rev.

### Technical description

|                 |        |
|-----------------|--------|
| Nominal Ø $D_c$ | 3.5 mm |
|-----------------|--------|

|  |                   |
|--|-------------------|
| Shank $\varnothing D_s$                  | 6 mm              |
| recommended maximum drilling depth $L_2$ | 14.8 mm           |
| Overall length L                         | 62 mm             |
| Number of cutting edges Z                | 2                 |
| Flute length $L_c$                       | 20 mm             |
| Standard                                 | DIN 6537 K        |
| Feed f in steel < 900 N/mm <sup>2</sup>  | 0.11 mm/rev.      |
| Tolerance nominal $\varnothing$          | h7                |
| 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                                  |          |   |