



## HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 9,2



### Order data

|              |               |
|--------------|---------------|
| Order number | 122501 9,2    |
| GTIN         | 4045197824813 |
| 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  $L_2$ : 33.2 mm

Overall length L: 89 mm

Shank Ø  $D_s$ : 10 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.22 mm/rev.

### Technical description

|                  |       |
|------------------|-------|
| Overall length L | 89 mm |
|------------------|-------|

|  |                   |
|--|-------------------|
| Nominal $\varnothing D_c$                | 9.2 mm            |
| Standard                                 | DIN 6537 K        |
| Flute length $L_c$                       | 47 mm             |
| Feed $f$ in steel $< 900 \text{ N/mm}^2$ | 0.22 mm/rev.      |
| Shank $\varnothing D_s$                  | 10 mm             |
| Number of cutting edges $Z$              | 2                 |
| Tolerance nominal $\varnothing$          | h7                |
| recommended maximum drilling depth $L_2$ | 33.2 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 $< 500 \text{ N/mm}^2$  | suitable    | 115 m/min | P        |
| Steel $< 750 \text{ N/mm}^2$  | suitable    | 105 m/min | P        |
| Steel $< 900 \text{ N/mm}^2$  | suitable    | 85 m/min  | P        |
| Steel $< 1100 \text{ N/mm}^2$ | suitable    | 80 m/min  | P        |
| Steel $< 1400 \text{ N/mm}^2$ | suitable    | 60 m/min  | P        |
| INOX $< 900 \text{ N/mm}^2$   | 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                                  |          |   |