HOLEX

HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, ⌀ DC h7 (mm or inch): 11,9

Order data

Order number	122501 11,9
GTIN	4045197825087
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 ⌀ 1.9 with 4 facets, from ⌀ 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 ⌀: h7
Number of cutting edges Z: 2
Tolerance nominal ⌀: h7
recommended maximum drilling depth L_2: 37.2 mm
Overall length L: 102 mm
Shank ⌀ D_s: 12 mm
Feed f in steel < 900 N/mm^2: 0.22 mm/rev.

Technical description

Tolerance nominal ⌀	h7

Feed f in steel < 900 N/mm²	0.22 mm/rev.
Overall length L	102 mm
Nominal Ø D_C	11.9 mm
Flute length L_c	55 mm
Number of cutting edges Z	2
Shank Ø D_s	12 mm
recommended maximum drilling depth L_2	37.2 mm
Standard	DIN 6537 K
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/mm²	suitable	115 m/min	P
Steel < 750 N/mm²	suitable	105 m/min	P
Steel < 900 N/mm²	suitable	85 m/min	P
Steel < 1100 N/mm²	suitable	80 m/min	P
Steel < 1400 N/mm²	suitable	60 m/min	P
INOX < 900 N/mm²	suitable	30 m/min	M

INOX > 900 N/mm²	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		