



HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 12,5



Order data

| | |
|--------------|---------------|
| Order number | 122501 12,5 |
| GTIN | 4045197825117 |
| 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 : 41.3 mm

Overall length L: 107 mm

Shank Ø D_s : 14 mm

Feed f in steel < 900 N/mm²: 0.26 mm/rev.

Technical description

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|-----------------|---------|
| Nominal Ø D_c | 12.5 mm |
|-----------------|---------|

| | |
|--|-------------------|
| Flute length L_c | 60 mm |
| Overall length L | 107 mm |
| Tolerance nominal \varnothing | h7 |
| Number of cutting edges Z | 2 |
| Shank $\varnothing D_s$ | 14 mm |
| Standard | DIN 6537 K |
| recommended maximum drilling depth L_2 | 41.3 mm |
| Feed f in steel $< 900 \text{ N/mm}^2$ | 0.26 mm/rev. |
| 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 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 | | |