



HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 3,9



Order data

| | |
|--------------|---------------|
| Order number | 122504 3,9 |
| GTIN | 4045197825728 |
| Item class | 12F |

Description

Version:

Straight major cutting edges and a **special flute profile** ensure 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.

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. 122507**.

For **HE shanks**: use order **No. 122508**.

Standard: DIN 6537 K

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth L_2 : 18.2 mm

Overall length L: 66 mm

Shank Ø D_s : 6 mm

Feed f in steel < 900 N/mm²: 0.11 mm/rev.

Technical description

| | |
|---------------------|------------|
| Standard | DIN 6537 K |
| Overall length L | 66 mm |
| Tolerance nominal Ø | h7 |

| | |
|--|-------------------|
| Nominal $\varnothing D_c$ | 3.9 mm |
| Shank $\varnothing D_s$ | 6 mm |
| Number of cutting edges Z | 2 |
| recommended maximum drilling depth L_2 | 18.2 mm |
| Flute length L_c | 24 mm |
| Feed f in steel < 900 N/mm ² | 0.11 mm/rev. |
| Series | Pro Steel |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 4xD |
| Point angle | 140 ° |
| Shank | DIN 6535 HA to h6 |
| Through-coolant | yes, with 25 bar |
| Machining strategy | HPC |
| Semi-Standard | yes |
| Colour ring | green |
| Type of product | Jobber drill |

User data

| | Suitability | V_c | ISO code |
|--------------------------------|---|-----------|----------|
| Alu plastics | suitable only under restricted conditions | 250 m/min | N |
| Aluminium (short chipping) | suitable only under restricted conditions | 200 m/min | N |
| Alu > 10% Si | suitable only under restricted conditions | 160 m/min | N |
| Steel < 500 N/mm ² | suitable | 125 m/min | P |
| Steel < 750 N/mm ² | suitable | 115 m/min | P |
| Steel < 900 N/mm ² | suitable | 95 m/min | P |
| Steel < 1100 N/mm ² | suitable | 90 m/min | P |

| | | | |
|--------------------------------|---|-----------|---|
| Steel < 1400 N/mm ² | suitable | 65 m/min | P |
| INOX < 900 N/mm ² | suitable | 35 m/min | M |
| INOX > 900 N/mm ² | suitable only under restricted conditions | 30 m/min | M |
| GG | suitable | 100 m/min | K |
| GGG | suitable | 65 m/min | K |
| Uni | suitable | | |
| wet maximum | suitable | | |
| wet minimum | suitable | | |