



## HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 8



### Order data

|              |               |
|--------------|---------------|
| Order number | 122504 8      |
| GTIN         | 4045197826138 |
| 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  $L_2$ : 29 mm

Overall length L: 79 mm

Shank Ø  $D_s$ : 8 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.18 mm/rev.

### Technical description

|                    |            |
|--------------------|------------|
| Standard           | DIN 6537 K |
| Flute length $L_c$ | 41 mm      |
| Nominal Ø $D_c$    | 8 mm       |

|   |                   |
|---|-------------------|
| Overall length L                                  | 79 mm             |
| Tolerance nominal $\varnothing$                   | h7                |
| Feed f in steel < 900 N/mm <sup>2</sup>           | 0.18 mm/rev.      |
| recommended maximum drilling depth L <sub>2</sub> | 29 mm             |
| Shank $\varnothing$ D <sub>s</sub>                | 8 mm              |
| Number of cutting edges Z                         | 2                 |
| 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 <sub>c</sub> | 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 <sup>2</sup>  | suitable                                  | 125 m/min      | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 115 m/min      | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 95 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 90 m/min       | P        |

|                                |   |           |   |
|--------------------------------|---|-----------|---|
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 65 m/min  | P |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 35 m/min  | M |
| INOX > 900 N/mm <sup>2</sup>   | 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                                  |           |   |