



HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 8,6



Order data

Order number	122504 8,6
GTIN	4045197826190
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 : 34.1 mm

Overall length L: 89 mm

Shank Ø D_s : 10 mm

Feed f in steel < 900 N/mm²: 0.2 mm/rev.

Technical description

recommended maximum drilling depth L_2	34.1 mm
Tolerance nominal Ø	h7
Flute length L_c	47 mm

Number of cutting edges Z	2
Overall length L	89 mm
Feed f in steel < 900 N/mm ²	0.2 mm/rev.
Nominal Ø D _c	8.6 mm
Standard	DIN 6537 K
Shank Ø D _s	10 mm
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		