



HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 19,8



Order data

Order number	122504 19,8
GTIN	4045197826862
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 : 49.3 mm

Overall length L: 131 mm

Shank Ø D_s : 20 mm

Feed f in steel < 900 N/mm²: 0.28 mm/rev.

Technical description

Nominal Ø D_c	19.8 mm
Overall length L	131 mm
Number of cutting edges Z	2

Flute length L_c	79 mm
Standard	DIN 6537 K
recommended maximum drilling depth L_2	49.3 mm
Shank $\varnothing D_s$	20 mm
Tolerance nominal \varnothing	h7
Feed f in steel $< 900 \text{ N/mm}^2$	0.28 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 $> 10\% \text{ Si}$	suitable only under restricted conditions	160 m/min	N
Steel $< 500 \text{ N/mm}^2$	suitable	125 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	115 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	95 m/min	P
Steel $< 1100 \text{ N/mm}^2$	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		