



## HOLEX Pro Steel solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7 (mm or inch): 5,4



### Order data

Order number	122502 5,4
GTIN	4045197830654
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 extremely wear-resistant coating.

#### Note:

Flute length  $L_c = L_2 + 1.5 \times D_c$ .

Standard: DIN 6537 K

Tolerance nominal  $\varnothing$ : h7

Number of cutting edges Z: 2

Tolerance nominal  $\varnothing$ : h7

recommended maximum drilling depth  $L_2$ : 19.9 mm

Overall length L: 66 mm

Shank  $\varnothing D_s$ : 6 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.14 mm/rev.

### Technical description

Overall length L	66 mm
Standard	DIN 6537 K
Number of cutting edges Z	2
Tolerance nominal $\varnothing$	h7
Nominal $\varnothing D_c$	5.4 mm
recommended maximum drilling depth $L_2$	19.9 mm

Flute length $L_c$	28 mm
Shank $\varnothing D_s$	6 mm
Feed $f$ in steel $< 900 \text{ N/mm}^2$	0.14 mm/rev.
Series	Pro Steel
Coating	TiAlN
Tool material	Solid carbide
Version	4xD
Point angle	140°
Shank	DIN 6535 HB 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 $> 900 \text{ N/mm}^2$	suitable only under restricted conditions	25 m/min	M
GG	suitable	90 m/min	K
GGG	suitable	55 m/min	K
wet maximum	suitable		
dry	suitable		

