



HOLEX Pro Steel solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7 (mm or inch): 8,4



Order data

Order number	122502 8,4
GTIN	4045197830951
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 : 34.4 mm

Overall length L: 89 mm

Shank $\varnothing D_s$: 10 mm

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

Technical description

Standard	DIN 6537 K
Tolerance nominal \varnothing	h7
Feed f in steel < 900 N/mm ²	0.2 mm/rev.
recommended maximum drilling depth L_2	34.4 mm
Shank $\varnothing D_s$	10 mm

Number of cutting edges Z	2
Nominal $\varnothing D_c$	8.4 mm
Overall length L	89 mm
Flute length L_c	47 mm
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 N/mm ²	suitable	115 m/min	P
Steel < 750 N/mm ²	suitable	105 m/min	P
Steel < 900 N/mm ²	suitable	85 m/min	P
Steel < 1100 N/mm ²	suitable	80 m/min	P
Steel < 1400 N/mm ²	suitable	60 m/min	P
INOX < 900 N/mm ²	suitable	30 m/min	M
INOX > 900 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