



## HOLEX Pro Steel solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7 (mm or inch): 8,7



### Order data

|              |               |
|--------------|---------------|
| Order number | 122502 8,7    |
| GTIN         | 4045197830982 |
| 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 mm

Overall length L: 89 mm

Shank  $\varnothing D_s$ : 10 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.2 mm/rev.

### Technical description

|   |             |
|---|-------------|
| Tolerance nominal $\varnothing$         | h7          |
| Overall length L                        | 89 mm       |
| Shank $\varnothing D_s$                 | 10 mm       |
| Feed f in steel < 900 N/mm <sup>2</sup> | 0.2 mm/rev. |
| Flute length $L_c$                      | 47 mm       |

|  |                   |
|--|-------------------|
| Number of cutting edges Z                | 2                 |
| Nominal $\varnothing D_c$                | 8.7 mm            |
| Standard                                 | DIN 6537 K        |
| recommended maximum drilling depth $L_2$ | 34 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 <sup>2</sup>  | suitable                                  | 115 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 105 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 85 m/min  | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 80 m/min  | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 60 m/min  | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 30 m/min  | M        |
| INOX > 900 N/mm <sup>2</sup>   | 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