



## HOLEX Pro Steel solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7 (mm or inch): 12



### Order data

|              |               |
|--------------|---------------|
| Order number | 122502 12     |
| GTIN         | 4045197831316 |
| 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  $L_2$ : 37 mm

Overall length L: 102 mm

Shank  $\varnothing D_s$ : 12 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.22 mm/rev.

### Technical description

|   |              |
|---|--------------|
| Nominal $\varnothing D_c$               | 12 mm        |
| Standard                                | DIN 6537 K   |
| Shank $\varnothing D_s$                 | 12 mm        |
| Feed f in steel < 900 N/mm <sup>2</sup> | 0.22 mm/rev. |
| Tolerance nominal $\varnothing$         | h7           |

|   |                   |
|---|-------------------|
| Number of cutting edges Z                         | 2                 |
| recommended maximum drilling depth L <sub>2</sub> | 37 mm             |
| Overall length L                                  | 102 mm            |
| Flute length L <sub>c</sub>                       | 55 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 <sub>c</sub> | 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