



## HOLEX Pro Steel solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7 (mm or inch): 3,7



### Order data

|              |               |
|--------------|---------------|
| Order number | 122507 3,7    |
| GTIN         | 4045197831729 |
| 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  $L_2$ : 14.5 mm

Overall length L: 62 mm

Shank  $\varnothing D_s$ : 6 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.11 mm/rev.

### Technical description

|  |            |
|--|------------|
| Nominal $\varnothing D_c$                | 3.7 mm     |
| Tolerance nominal $\varnothing$          | h7         |
| recommended maximum drilling depth $L_2$ | 14.5 mm    |
| Number of cutting edges Z                | 2          |
| Standard                                 | DIN 6537 K |
| Overall length L                         | 62 mm      |

|  |                   |
|--|-------------------|
| Flute length $L_c$                       | 20 mm             |
| Shank $\varnothing D_s$                  | 6 mm              |
| Feed $f$ in steel $< 900 \text{ N/mm}^2$ | 0.11 mm/rev.      |
| Series                                   | Pro Steel         |
| Coating                                  | TiAlN             |
| Tool material                            | Solid carbide     |
| Version                                  | 4xD               |
| Point angle                              | 140°              |
| Shank                                    | DIN 6535 HB to h6 |
| Through-coolant                          | yes, to 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 $< 1400 \text{ N/mm}^2$ | suitable                                  | 65 m/min  | P        |
| INOX $< 900 \text{ N/mm}^2$   | suitable                                  | 35 m/min  | M        |

|                              |   |           |   |
|------------------------------|---|-----------|---|
| INOX > 900 N/mm <sup>2</sup> | 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                                  |           |   |