



## HOLEX Pro Steel solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7 (mm or inch): 8,6



### Order data

Order number	122507 8,6
GTIN	4045197832214
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  $L_2$ : 34.1 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

Standard	DIN 6537 K
Overall length L	89 mm
Flute length $L_c$	47 mm
Nominal $\varnothing D_c$	8.6 mm
Tolerance nominal $\varnothing$	h7

Feed f in steel < 900 N/mm <sup>2</sup>	0.2 mm/rev.
Number of cutting edges Z	2
recommended maximum drilling depth L <sub>2</sub>	34.1 mm
Shank Ø D <sub>s</sub>	10 mm
Series	Pro Steel
Coating	TiAlN
Tool material	Solid carbide
Version	4×D
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 <sub>c</sub>	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% Si	suitable only under restricted conditions	160 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	125 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	115 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	95 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	65 m/min	P
INOX < 900 N/mm <sup>2</sup>	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		