



HOLEX Pro Steel solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7 (mm or inch): 6,9



Order data

Order number	122777 6,9
GTIN	4045197833303
Item class	12F

Description

Version:

HOLEX Pro Steel:

Straight major cutting edges and a **special flute profile** ensure good chip evacuation. The robust cutting edge 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

Tolerance nominal \varnothing : h7

Number of cutting edges Z: 2

Tolerance nominal \varnothing : h7

recommended maximum drilling depth L_2 : 42.7 mm

Overall length L: 91 mm

Shank $\varnothing D_s$: 8 mm

Feed f in steel < 900 N/mm²: 0.18 mm/rev.

Technical description

Standard	DIN 6537
Number of cutting edges Z	2
Overall length L	91 mm
Tolerance nominal \varnothing	h7
Shank $\varnothing D_s$	8 mm

Flute length L_c	53 mm
Feed f in steel $< 900 \text{ N/mm}^2$	0.18 mm/rev.
Nominal $\varnothing D_c$	6.9 mm
recommended maximum drilling depth L_2	42.7 mm
Series	Pro Steel
Coating	TiAlN
Tool material	Solid carbide
Version	6×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_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 ²	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		