HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HB, TiAlN, ⌀ DC h7 (mm or inch): 8,5

Order data

Order number	122777 8,5
GTIN	4045197833471
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 $L_C = L_2 + 1.5 \times D_C$.

Technical description

Nominal ⌀ D_C	8.5 mm
Flute length L_c	61 mm
recommended maximum drilling depth L_2	48.3 mm
Number of cutting edges Z	2
Overall length L	103 mm
Feed f in steel < 900 N/mm^2	0.2 mm/rev.
Standard	DIN 6537
Shank ⌀ D_s	10 mm
Tolerance nominal ⌀	h7
Series	Pro Steel

Coating	TiAlN
Tool material	Solid carbide
Version	6×D
Point angle	140 degrees
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% Si	suitable only under restricted conditions	160 m/min	N
Steel < 500 N/mm²	suitable	125 m/min	P
Steel < 750 N/mm²	suitable	115 m/min	P
Steel < 900 N/mm²	suitable	95 m/min	P
Steel < 1100 N/mm²	suitable	90 m/min	P
Steel < 1400 N/mm²	suitable	65 m/min	P
INOX < 900 N/mm²	suitable	35 m/min	M
INOX > 900 N/mm²	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