



## HOLEX Pro Steel solid carbide drill, Whistle-Notch shank DIN 6535 HE, TiAlN, Ø DC h7 (mm or inch): 4



### Order data

|              |               |
|--------------|---------------|
| Order number | 122503 4      |
| GTIN         | 4045197834270 |
| 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  $L_c = L_2 + 1.5 \times D_c$ .

Machining strategy: HPC

Standard: DIN 6537 K

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 18 mm

Overall length L: 66 mm

Shank Ø  $D_s$ : 6 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.14 mm/rev.

### Technical description

|  |              |
|--|--------------|
| Feed f in steel < 900 N/mm <sup>2</sup>  | 0.14 mm/rev. |
| Nominal Ø $D_c$                          | 4 mm         |
| Number of cutting edges Z                | 2            |
| recommended maximum drilling depth $L_2$ | 18 mm        |
| Standard                                 | DIN 6537 K   |

|                                 |                   |
|---------------------------------|-------------------|
| Tolerance nominal $\varnothing$ | h7                |
| Shank $\varnothing D_s$         | 6 mm              |
| Flute length $L_c$              | 24 mm             |
| Overall length L                | 66 mm             |
| Coating                         | TiAlN             |
| Tool material                   | Solid carbide     |
| Version                         | 4xD               |
| Point angle                     | 140 °             |
| Shank                           | DIN 6535 HE to h6 |
| Through-coolant                 | no                |
| Machining strategy              | HPC               |
| Colour ring                     | green             |
| Type of product                 | Jobber drill      |

## User data

|                                | Suitability                               | $V_c$     | 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                                  |           |          |

