



HOLEX Pro Steel solid carbide drill, Whistle-Notch shank DIN 6535 HE, TiAlN, Ø DC h7 (mm or inch): 18



Order data

Order number	122503 18
GTIN	4045197835338
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 \varnothing : h7

Number of cutting edges Z: 2

Tolerance nominal \varnothing : h7

recommended maximum drilling depth L_2 : 46 mm

Overall length L: 123 mm

Shank $\varnothing D_s$: 18 mm

Feed f in steel < 900 N/mm²: 0.28 mm/rev.

Technical description

Overall length L	123 mm
Flute length L_c	73 mm
Tolerance nominal \varnothing	h7
Shank $\varnothing D_s$	18 mm
Standard	DIN 6537 K

recommended maximum drilling depth L_2	46 mm
Nominal $\varnothing D_c$	18 mm
Feed f in steel $< 900 \text{ N/mm}^2$	0.28 mm/rev.
Number of cutting edges Z	2
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 $< 500 \text{ N/mm}^2$	suitable	115 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	105 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	85 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	80 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable	60 m/min	P
INOX $< 900 \text{ N/mm}^2$	suitable	30 m/min	M
INOX $> 900 \text{ N/mm}^2$	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		

