

**HOLEX**
**HOLEX Pro Steel solid carbide drill, Whistle-Notch shank DIN 6535 HE, TiAlN, Ø DC h7 (mm or inch): 17,2**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 122778 17,2   |
| GTIN         | 4045197837820 |
| 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  $L_c = L_2 + 1.5 \times D_c$ .

Machining strategy: HPC

Standard: DIN 6537

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 67.2 mm

Overall length L: 143 mm

Shank Ø  $D_s$ : 18 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.28 mm/rev.

**Technical description**

|   |              |
|---|--------------|
| Standard                                | DIN 6537     |
| Tolerance nominal Ø                     | h7           |
| Number of cutting edges Z               | 2            |
| Feed f in steel < 900 N/mm <sup>2</sup> | 0.28 mm/rev. |

|  |                   |
|--|-------------------|
| Shank $\varnothing D_s$                  | 18 mm             |
| Nominal $\varnothing D_c$                | 17.2 mm           |
| Flute length $L_c$                       | 93 mm             |
| recommended maximum drilling depth $L_2$ | 67.2 mm           |
| Overall length $L$                       | 143 mm            |
| Series                                   | Pro Steel         |
| Coating                                  | TiAlN             |
| Tool material                            | Solid carbide     |
| Version                                  | 6xD               |
| Point angle                              | 140 °             |
| Shank                                    | DIN 6535 HE to h6 |
| Through-coolant                          | yes, with 25 bar  |
| Machining strategy                       | HPC               |
| 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/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                                  |           |   |