



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



Order data

Order number	122778 18
GTIN	4045197837851
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 : 66 mm

Overall length L: 143 mm

Shank Ø D_s : 18 mm

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

Technical description

Overall length L	143 mm
Feed f in steel < 900 N/mm ²	0.28 mm/rev.
Tolerance nominal Ø	h7
Standard	DIN 6537

Flute length L_c	93 mm
Number of cutting edges Z	2
Nominal $\varnothing D_c$	18 mm
recommended maximum drilling depth L_2	66 mm
Shank $\varnothing D_s$	18 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 ²	suitable	125 m/min	P
Steel < 750 N/mm ²	suitable	115 m/min	P
Steel < 900 N/mm ²	suitable	95 m/min	P
Steel < 1100 N/mm ²	suitable	90 m/min	P
Steel < 1400 N/mm ²	suitable	65 m/min	P
INOX < 900 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		