



HOLEX Pro Steel solid carbide drill, Whistle-Notch shank DIN 6535 HE, TiAlN, Ø DC h7 (mm or inch): 19



Order data

| | |
|--------------|---------------|
| Order number | 122503 19 |
| GTIN | 4045197835376 |
| 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 : 50.5 mm

Overall length L: 131 mm

Shank Ø D_s : 20 mm

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

Technical description

| | |
|---------------------|------------|
| Tolerance nominal Ø | h7 |
| Standard | DIN 6537 K |
| Nominal Ø D_c | 19 mm |
| Overall length L | 131 mm |
| Shank Ø D_s | 20 mm |

| | |
|--|-------------------|
| Number of cutting edges Z | 2 |
| Flute length L_c | 79 mm |
| Feed f in steel < 900 N/mm ² | 0.28 mm/rev. |
| recommended maximum drilling depth L_2 | 50.5 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 ² | suitable | 115 m/min | P |
| Steel < 750 N/mm ² | suitable | 105 m/min | P |
| Steel < 900 N/mm ² | suitable | 85 m/min | P |
| Steel < 1100 N/mm ² | suitable | 80 m/min | P |
| Steel < 1400 N/mm ² | suitable | 60 m/min | P |
| INOX < 900 N/mm ² | suitable | 30 m/min | M |
| INOX > 900 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 | | |

