



## HOLEX Pro Steel solid carbide drill, Whistle-Notch shank DIN 6535 HE, TiAlN, Ø DC h7 (mm or inch): 18,5



### Order data

|              |               |
|--------------|---------------|
| Order number | 122508 18,5   |
| GTIN         | 4045197836595 |
| 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  $L_2$ : 51.3 mm

Overall length L: 131 mm

Shank Ø  $D_s$ : 20 mm

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

### Technical description

|                           |            |
|---------------------------|------------|
| Number of cutting edges Z | 2          |
| Nominal Ø $D_c$           | 18.5 mm    |
| Flute length $L_c$        | 79 mm      |
| Shank Ø $D_s$             | 20 mm      |
| Standard                  | DIN 6537 K |

|   |                   |
|---|-------------------|
| Feed f in steel < 900 N/mm <sup>2</sup>           | 0.28 mm/rev.      |
| recommended maximum drilling depth L <sub>2</sub> | 51.3 mm           |
| Tolerance nominal Ø                               | h7                |
| Overall length L                                  | 131 mm            |
| Series  | Pro Steel         |
| Coating   | TiAlN             |
| Tool material                                     | Solid carbide     |
| Version   | 4×D               |
| 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 <sub>c</sub> | 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                                  |           |   |