



## HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 8,9



### Order data

Order number	122504 8,9
GTIN	4045197826220
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 an extremely wear-resistant coating. Up to Ø 1.9 with 4 facets, from Ø 2 with relieved cone.

#### Note:

Flute length  $L_c = L_2 + 1.5 \times D_c$ .

Versions with HB and HE shank available at the same price as HA.

For **HB shanks**: use order **no. 122507**.

For **HE shanks**: use order **No. 122508**.

Standard: DIN 6537 K

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 33.7 mm

Overall length L: 89 mm

Shank Ø  $D_s$ : 10 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.2 mm/rev.

### Technical description

Tolerance nominal Ø	h7
Shank Ø $D_s$	10 mm
recommended maximum drilling depth $L_2$	33.7 mm

Overall length L	89 mm
Flute length L <sub>c</sub>	47 mm
Standard	DIN 6537 K
Nominal Ø D <sub>c</sub>	8.9 mm
Number of cutting edges Z	2
Feed f in steel < 900 N/mm <sup>2</sup>	0.2 mm/rev.
Series	Pro Steel
Coating	TiAlN
Tool material	Solid carbide
Version	4×D
Point angle	140 °
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
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		