



## HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 13,8



### Order data

|              |               |
|--------------|---------------|
| Order number | 122776 13,8   |
| GTIN         | 4045197828095 |
| Item class   | 12F           |

### Description

#### Version:

**Straight major cutting edges** and a **special flute profile** ensure a 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. 122777**.

For **HE shanks**: use order **No. 122778**.

Standard: DIN 6537

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 56.3 mm

Overall length L: 124 mm

Shank Ø  $D_s$ : 14 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.26 mm/rev.

### Technical description

|                     |       |
|---------------------|-------|
| Shank Ø $D_s$       | 14 mm |
| Tolerance nominal Ø | h7    |
| Flute length $L_c$  | 77 mm |

|                                          |                   |
|------------------------------------------|-------------------|
| Standard                                 | DIN 6537          |
| recommended maximum drilling depth $L_2$ | 56.3 mm           |
| Feed $f$ in steel $< 900 \text{ N/mm}^2$ | 0.26 mm/rev.      |
| Overall length $L$                       | 124 mm            |
| Number of cutting edges $Z$              | 2                 |
| Nominal $\varnothing D_c$                | 13.8 mm           |
| Series                                   | Pro Steel         |
| Coating                                  | TiAlN             |
| Tool material                            | Solid carbide     |
| Version                                  | 6xD               |
| 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                               | $V_c$     | 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 $> 10\% \text{ Si}$       | suitable only under restricted conditions | 160 m/min | N        |
| Steel $< 500 \text{ N/mm}^2$  | suitable                                  | 125 m/min | P        |
| Steel $< 750 \text{ N/mm}^2$  | suitable                                  | 115 m/min | P        |
| Steel $< 900 \text{ N/mm}^2$  | suitable                                  | 95 m/min  | P        |
| Steel $< 1100 \text{ N/mm}^2$ | 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<br>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                                     |           |   |