



HOLEX Pro Steel solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 6,9mm



Order data

Order number	123304 6,9
GTIN	4062406091729
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 $L_c = L_2 + 1.5 \times D_c$.

For process reliability when using the 12xD drill, an initial centre drilling with NC spotting drills No. 121068 - 121130 or HOLEX Pro Steel No. 122501 is necessary.

Technical description

Nominal Ø D_c	6.9 mm
recommended maximum drilling depth L_2	97.65 mm
Number of cutting edges Z	2
Overall length L	146 mm
Shank Ø D_s	8 mm
Tolerance nominal Ø	h7
Standard	Manufacturer's standard
Feed f in steel $< 900 \text{ N/mm}^2$	0.16 mm/rev.
Flute length L_c	108 mm

Series	Pro Steel
Coating	TiAlN
Tool material	Solid carbide
Version	12×D
Point angle	135 degrees
Shank	DIN 6535 HB
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% 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