ⶖ Hoffmann Group

HOLEX

Solid carbide drill plain shank DIN 6535 HE, TiAlN, Ø DC m7 (mm or inch): 12

Order data

Order number	122773 12
GTIN	4062406151188
Item class	12F

Description

Version:
Tool specially matched to drilling holes without through-coolant. **Concave major cutting edges** and a **special flute profile** ensure a good chip evacuation. The sturdy cutter geometry with **special point geometry** and 4 cutting edges ensures 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** and **heat-resistant coating.**
Note:
Flute length $L_c = L_2 + 1.5 \times D_c$.
Through-coolant: no
Standard: DIN 6537
Tolerance nominal Ø: m7
Number of cutting edges Z: 2
recommended maximum drilling depth L_2: 53 mm
Tolerance nominal Ø: m7
Overall length L: 118 mm
Shank Ø D_s: 12 mm
Feed f in steel < 900 N/mm^2: 0.2 mm/rev.

Technical description

Tolerance nominal Ø	m7
Feed f in steel < 900 N/mm^2	0.2 mm/rev.
Flute length L_c	71 mm
Shank Ø D_s	12 mm

Standard	DIN 6537
recommended maximum drilling depth L_2	53 mm
Number of cutting edges Z	2
Overall length L	118 mm
Nominal $\varnothing$ D_c	12 mm
Coating	TiAlN
Tool material	Solid carbide
Version	6×D
Point angle	140 °
Shank	DIN 6535 HE to h6
Through-coolant	no
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
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/mm²	suitable	110 m/min	P
Steel < 750 N/mm²	suitable	90 m/min	P
Steel < 900 N/mm²	suitable	80 m/min	P
Steel < 1100 N/mm²	suitable	70 m/min	P
Steel < 1400 N/mm²	suitable only under restricted conditions	60 m/min	P
GG	suitable	90 m/min	K
GGG	suitable only under restricted conditions	60 m/min	K
Uni	suitable		

wet maximum	suitable
dry	suitable only under restricted conditions