



## Solid carbide high performance drill plain shank DIN 6535 HA, TiN, Ø DC h7: 8,5mm



### Order data

Order number	123306 8,5
GTIN	4045197448651
Item class	12E

### Description

#### Version:

**Strong core and special point geometry** –ensure the cutting chisel edges maintain **high self-centring accuracy**.

**Straight cutting edges** with slight edge hone and a special flute profile produce **short chips**.

#### 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.

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 123307**.

Form **HE**: order with **No. 123308**.

**NEW GENERATION AVAILABLE!**

**Recommended successor product is No. 123303.**

### Technical description

Number of cutting edges Z	2
Nominal Ø D <sub>c</sub>	8.5 mm
Feed f in steel < 1100 N/mm <sup>2</sup>	0.15 mm/rev.
Shank tolerance	h6
Flute length L <sub>c</sub>	120 mm
Tolerance nominal Ø	h7
Shank Ø D <sub>s</sub>	10 mm

Overall length L	162 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L <sub>2</sub>	107.3 mm
Coating	TiN
Tool material	Solid carbide
Version	12xD
Point angle	135 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Colour ring	green
Type of product	Jobber drill

## User data

	Suitability	V <sub>c</sub>	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	175 m/min	N
Alu > 10% Si	suitable only under restricted conditions	135 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable only under restricted conditions	105 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	85 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	75 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	45 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	30 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	35 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	30 m/min	M
GG(G)	suitable	65 m/min	K
Uni	suitable		

wet maximum

suitable