

HOLEX®
Solid carbide high performance drill Weldon shank DIN 6535 HB, TiN, Ø h7: 8,2 mm

Order data

Order number	123307 8,2
GTIN	4045197450074
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**.

Recommendation:
Maximum drilling depth:

Flute length (see table) less 1.5×nominal Ø.

Note:

For process reliability when using the 12×D deep-hole drill, an initial centre drilling with No. 121068– 121130 or 3×D pilot drilling operation with No.122736 is necessary.

Pilot drill required: yes, pilot drill

Norm: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

Flute length: 120 mm

Overall length L_{tot} : 162 mm

Shank Ø: 10 mm

Feed f in steel < 1100 N/mm²: 0.15 mm/rev.

Technical description

Number of cutting edges Z	2
Shank tolerance	h6
Flute length	120 mm

Nominal Ø	8.2 mm
Feed f in steel < 1100 N/mm ²	0.15 mm/rev.
Tolerance nominal Ø	h7
Shank Ø	10 mm
Overall length L _{tot}	162 mm
Norm	Manufacturer's standard
recommended maximum drilling depth	107.7 mm
Coating	TiN
Tool material	Solid carbide
Drill depth up to	12xD
Point angle	135 degrees
Skaft	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Pilot drill required	yes, pilot drill
Colour ring	green