HOLEX

Solid carbide high performance drill plain shank DIN 6535 HB, TiN, ⌀ DC h7: 8,5mm

Order data

Order number	123307 8,5
GTIN	4045197450081
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 12×D deep-hole drill, an initial centre drilling with No. 121068 – 121130 or 3×D pilot drilling operation with No. 122736 is necessary.

Technical description

Shank tolerance	h6
Feed f in steel < 1100 N/mm^2	0.15 mm/rev.
Nominal ⌀ D_C	8.5 mm
Number of cutting edges Z	2
Flute length L_c	120 mm
Tolerance nominal ⌀	h7
Shank ⌀ D_s	10 mm
Overall length L	162 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	107.3 mm

Coating	TiN
Tool material	Solid carbide
Version	12×D
Point angle	135 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Pilot drill required	yes, pilot drill
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V_c	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/mm²	suitable only under restricted conditions	105 m/min	P
Steel < 750 N/mm²	suitable	85 m/min	P
Steel < 900 N/mm²	suitable	75 m/min	P
Steel < 1100 N/mm²	suitable	45 m/min	P
Steel < 1400 N/mm²	suitable	30 m/min	P
INOX < 900 N/mm²	suitable only under restricted conditions	35 m/min	M
INOX > 900 N/mm²	suitable only under restricted conditions	30 m/min	M
GG(G)	suitable	65 m/min	K
Uni	suitable		
wet maximum	suitable		