HOLEX

# Solid carbide high performance drill, plain shank DIN 6535 HA, TiN, ⌀ DC h7 (mm or inch): 9,1

## Order data

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|---|---|
| Order number | 122340 9,1 |
| GTIN | 4045197044907 |
| Item class | 12E |

## Description

**Version:**
Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry. Straight major cutting edges** with slightly honed edges and special flute profile produce **short chips.**
**Note:**
Flute length $L_C = L_2 + 1.5 \times D_C$.
**NEW GENERATION AVAILABLE!**
**Recommended successor product is No. 122504.**
Versions with HB and HE shank available at the same price as HA.
**HB shank:** use order **No. 122345**.
**HE shank:** use order **No. 122355**.

## Technical description

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|---|---|
| Nominal ⌀ $D_C$ | 9.1 mm |
| Feed f in steel < 900 N/mm$^2$ | 0.22 mm/rev. |
| Number of cutting edges Z | 2 |
| Flute length $L_c$ | 47 mm |
| Shank tolerance | h6 |
| Tolerance nominal ⌀ | h7 |
| Shank ⌀ $D_s$ | 10 mm |
| Overall length L | 89 mm |

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| Standard | DIN 6537 K |
| recommended maximum drilling depth $L_2$ | 33.4 mm |
| Coating | TiN |
| Tool material | Solid carbide |
| Version | 4×D |
| Point angle | 140 degrees |
| Shank | DIN 6535 HA to h6 |
| Through-coolant | yes, with 25 bar |
| Semi-Standard | yes |
| Colour ring | green |
| Type of product | Jobber drill |

## User data

| | Suitability | $V_c$ | ISO code |
|---|---|---|---|
| Aluminium (short chipping) | suitable only under restricted conditions | 240 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 only under restricted conditions | 65 m/min | P |
| Steel < 1400 N/mm² | suitable only under restricted conditions | 35 m/min | P |
| INOX < 900 N/mm² | suitable | 35 m/min | M |
| INOX > 900 N/mm² | suitable | 30 m/min | M |
| Ti > 850 N/mm² | suitable | 30 m/min | S |
| Uni | suitable | | |
| wet maximum | suitable | | |
| wet minimum | suitable | | |

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| Air | suitable only under restricted conditions |