

**HOLEX**
**HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 9,7mm**

**Order data**

Order number	123103 9,7
GTIN	4045197960597
Item class	12F

**Description**
**Version:**

**Straight major cutting edges** and a **special flute profile** ensure good chip evacuation. The robust cutter geometry ensures high-performance 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 coating.

**Note:**

Flute length  $L_c = L_2 + 1.5 \times D_c$ .

Versions with HB and HE shank available at the same price as HA.

For **HB shanks**: use order **No. 123104**.

For **HE shanks**: use order **no. 123109**.

**Technical description**

Feed $f$ in steel $< 900 \text{ N/mm}^2$	0.2 mm/rev.
Number of cutting edges $Z$	2
Overall length $L$	142 mm
recommended maximum drilling depth $L_2$	80.5 mm
Standard	Manufacturer's standard
Flute length $L_c$	95 mm
Nominal $\varnothing D_c$	9.7 mm
Shank $\varnothing D_s$	10 mm
Tolerance nominal $\varnothing$	h7

Series	Pro Steel
Coating	TiAlN
Tool material	Solid carbide
Version	8×D
Point angle	135 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

## User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable only under restricted conditions	250 m/min	N
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/mm <sup>2</sup>	suitable	125 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	115 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	95 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	65 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	35 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	30 m/min	M
GG	suitable	100 m/min	K
GGG	suitable	65 m/min	K

Uni	suitable
wet maximum	suitable
wet minimum	suitable