



## HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 8,5mm



### Order data

Order number	123303 8,5
GTIN	4045197961150
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  $L_c = L_2 + 1.5 \times D_c$ .

For process reliability when using the 12×D drill, an initial centre drilling with NC spotting drills No. 121068 - 121130 or HOLEX Pro Steel No. 122501 is necessary.

HB and HE shanks are available at the same price as HA.

For **HB shanks**: use order **no. 123304**.

For **HE shanks**: use order **no. 123309**.

### Technical description

Tolerance nominal Ø	h7
Shank Ø $D_s$	10 mm
Overall length L	162 mm
Flute length $L_c$	120 mm
Standard	Manufacturer's standard
recommended maximum drilling depth $L_2$	107.3 mm
Number of cutting edges Z	2
Nominal Ø $D_c$	8.5 mm

Feed f in steel < 900 N/mm <sup>2</sup>	0.18 mm/rev.
Series	Pro Steel
Coating	TiAlN
Tool material	Solid carbide
Version	12xD
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		