# HOLEX

# HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAIN, Ø DC h7: 12mm

max and a co

# Order data

| Order number | 123303 12     |  |
|--------------|---------------|--|
| GTIN         | 4045197961242 |  |
| 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**

| Overall length L                        | 204 mm                  |  |  |
|---|-------------------------|--|--|
| Flute length L <sub>c</sub>             | 156 mm                  |  |  |
| Feed f in steel < 900 N/mm <sup>2</sup> | 0.2 mm/rev.             |  |  |
| Nominal Ø D <sub>c</sub>                | 12 mm                   |  |  |
| Standard                                | Manufacturer's standard |  |  |
| Shank Ø D <sub>s</sub>                  | 12 mm                   |  |  |
| Number of cutting edges Z               | 2                       |  |  |

# Data sheet

| Tolerance nominal $\varnothing$          | h7                |  |  |
|--|-------------------|--|--|
| recommended maximum drilling depth $L_2$ | 138 mm            |  |  |
| Series                                   | Pro Steel         |  |  |
| Coating                                  | TiAIN             |  |  |
| Tool material                            | Solid carbide     |  |  |
| Version                                  | 12×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      | Ν        |
| Aluminium (short<br>chipping)  | suitable only under restricted conditions | 200 m/min      | Ν        |
| Alu > 10% Si                   | suitable only under restricted conditions | 160 m/min      | Ν        |
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 125 m/min      | Р        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 115 m/min      | Р        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 95 m/min       | Р        |
| Steel < 1100 N/mm²             | suitable                                  | 90 m/min       | Р        |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 65 m/min       | Р        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 35 m/min       | Μ        |
| INOX > 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 30 m/min       | М        |

| GG          | suitable | 100 m/min | К |
|-------------|----------|-----------|---|
| GGG         | suitable | 65 m/min  | К |
| Uni         | suitable |           |   |
| wet maximum | suitable |           |   |
| wet minimum | suitable |           |   |