HOLEX

HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, ⌀ DC h7: 6,8mm

Order data

Order number	123303 6,8
GTIN	4045197961099
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

Standard	Manufacturer's standard
Tolerance nominal ⌀	h7
Overall length L	146 mm
Nominal ⌀ D_C	6.8 mm
Flute length L_c	108 mm
Feed f in steel < 900 N/mm^2	0.16 mm/rev.
recommended maximum drilling depth L_2	97.8 mm

Shank ∅ D_s	8 mm
Number of cutting edges Z	2
Series	Pro Steel
Coating	TiAlN
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_c	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/mm²	suitable	125 m/min	P
Steel < 750 N/mm²	suitable	115 m/min	P
Steel < 900 N/mm²	suitable	95 m/min	P
Steel < 1100 N/mm²	suitable	90 m/min	P
Steel < 1400 N/mm²	suitable	65 m/min	P
INOX < 900 N/mm²	suitable	35 m/min	M
INOX > 900 N/mm²	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		