



HOLEX Pro Steel solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 3,5mm



Order data

| | |
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| Order number | 123304 3,5 |
| GTIN | 4045197963017 |
| Item class | 12F |

Description

Version:

HOLEX Pro Steel:

Straight major cutting edges and a **special flute profile** ensure good chip evacuation. The robust cutting edge 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 12xD drill, an initial centre drilling with NC spotting drills No. 121068 - 121130 or HOLEX Pro Steel No. 122501 is necessary.

Technical description

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| Tolerance nominal Ø | h7 |
| Overall length L | 92 mm |
| Flute length L_c | 54 mm |
| Nominal Ø D_c | 3.5 mm |
| recommended maximum drilling depth L_2 | 48.8 mm |
| Shank Ø D_s | 6 mm |
| Feed f in steel < 900 N/mm ² | 0.13 mm/rev. |
| Standard | Manufacturer's standard |
| Number of cutting edges Z | 2 |

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| Series | Pro Steel |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 12×D |
| Point angle | 135 degrees |
| Shank | DIN 6535 HB |
| 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/mm ² | suitable | 125 m/min | P |
| Steel < 750 N/mm ² | suitable | 115 m/min | P |
| Steel < 900 N/mm ² | suitable | 95 m/min | P |
| Steel < 1100 N/mm ² | suitable | 90 m/min | P |
| Steel < 1400 N/mm ² | suitable | 65 m/min | P |
| INOX < 900 N/mm ² | suitable | 35 m/min | M |
| INOX > 900 N/mm ² | suitable only under restricted conditions | 30 m/min | M |
| GG | suitable | 100 m/min | K |
| GGG | suitable | 65 m/min | K |

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|-------------|----------|
| Uni | suitable |
| wet maximum | suitable |
| wet minimum | suitable |