

**HOLEX**
**HOLEX Pro Steel solid carbide drill, Whistle-Notch shank DIN 6535 HE, TiAlN, Ø DC h7: 6,1mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 123109 6,1    |
| GTIN         | 4045197962379 |
| 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  $L_c = L_2 + 1.5 \times D_c$ .

**Technical description**

|   |                         |
|---|-------------------------|
| Number of cutting edges Z                         | 2                       |
| Feed f in steel < 900 N/mm <sup>2</sup>           | 0.16 mm/rev.            |
| recommended maximum drilling depth L <sub>2</sub> | 66.9 mm                 |
| Tolerance nominal Ø                               | h7                      |
| Shank Ø D <sub>s</sub>                            | 8 mm                    |
| Flute length L <sub>c</sub>                       | 76 mm                   |
| Standard  | Manufacturer's standard |
| Nominal Ø D <sub>c</sub>                          | 6.1 mm                  |
| Overall length L                                  | 114 mm                  |
| Series  | Pro Steel               |

|                    |                   |
|--------------------|-------------------|
| Coating            | TiAlN             |
| Tool material      | Solid carbide     |
| Version            | 8xD               |
| Point angle        | 135 degrees       |
| Shank              | DIN 6535 HE to h6 |
| Through-coolant    | yes, with 25 bar  |
| Machining strategy | HPC               |
| 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