



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



### Order data

|              |               |
|--------------|---------------|
| Order number | 123309 6      |
| GTIN         | 4045197963499 |
| 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

|  |                         |
|--|-------------------------|
| Nominal Ø $D_c$                          | 6 mm                    |
| Number of cutting edges Z                | 2                       |
| Flute length $L_c$                       | 78 mm                   |
| Feed f in steel < 900 N/mm <sup>2</sup>  | 0.13 mm/rev.            |
| Overall length L                         | 116 mm                  |
| Standard                                 | Manufacturer's standard |
| Tolerance nominal Ø                      | h7                      |
| recommended maximum drilling depth $L_2$ | 69 mm                   |
| Shank Ø $D_s$                            | 6 mm                    |

|                    |                   |
|--------------------|-------------------|
| Series             | Pro Steel         |
| Coating            | TiAlN             |
| Tool material      | Solid carbide     |
| Version            | 12xD              |
| 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 |