



HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 18 mm



Order data

Order number	123303 18
GTIN	4062406091002
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.

Recommendation:

Maximum drilling depth:

Flute length (see table) less 1.5×nominal Ø.

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.

Form HB and HE supplied at the same price as HA.

Order form **HB**: state **No. 123304**.

Order form **HE**: state **No. 123309**.

Machining strategy: HPC

Standard: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth L_2 : 207.8 mm

Overall length L: 285 mm

Shank Ø D_s : 18 mm

Feed f in steel < 900 N/mm²: 0.25 mm/rev.

Technical description

Shank $\varnothing D_s$	18 mm
Flute length L_c	234 mm
Nominal $\varnothing D_c$	18 mm
Feed f in steel $< 900 \text{ N/mm}^2$	0.25 mm/rev.
recommended maximum drilling depth L_2	207.8 mm
Number of cutting edges Z	2
Standard	Manufacturer's standard
Tolerance nominal $\varnothing$	h7
Overall length L	285 mm
Series	HOLEX Pro Steel
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	12xD
Point angle	135 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Colour ring	green
Type of product	Jobber drill