

**HOLEX Pro Steel solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 10,1 mm****Order data**

|              |               |
|--------------|---------------|
| Order number | 123304 10,1   |
| GTIN         | 4062406091781 |
| 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.

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  $L_2$ : 140.85 mm

Overall length L: 204 mm

Shank Ø  $D_s$ : 12 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.2 mm/rev.

**Technical description**

|                  |        |
|------------------|--------|
| Overall length L | 204 mm |
|------------------|--------|

|                                                   |                         |
|---------------------------------------------------|-------------------------|
| Feed f in steel < 900 N/mm <sup>2</sup>           | 0.2 mm/rev.             |
| Nominal Ø D <sub>c</sub>                          | 10.1 mm                 |
| Shank Ø D <sub>s</sub>                            | 12 mm                   |
| Number of cutting edges Z                         | 2                       |
| Tolerance nominal Ø                               | h7                      |
| Flute length L <sub>c</sub>                       | 156 mm                  |
| Standard                                          | Manufacturer's standard |
| recommended maximum drilling depth L <sub>2</sub> | 140.85 mm               |
| Series                                            | HOLEX Pro Steel         |
| Coating                                           | TiAlN                   |
| Tool material                                     | Solid carbide           |
| Drill depth up to                                 | 12xD                    |
| Point angle                                       | 135 degrees             |
| Shank                                             | DIN 6535 HB             |
| Through-coolant                                   | yes, with 25 bar        |
| Machining strategy                                | HPC                     |
| Colour ring                                       | green                   |
| Type of product                                   | Jobber drill            |