



HOLEX Pro Steel solid carbide drill, Whistle-Notch shank DIN 6535 HE, TiAlN, Ø DC h7: 8,6 mm



Order data

Order number	123309 8,6
GTIN	4062406091934
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 : 107.1 mm

Overall length L: 162 mm

Shank Ø D_s : 10 mm

Feed f in steel < 900 N/mm²: 0.18 mm/rev.

Technical description

Shank Ø D_s	10 mm
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Flute length L_c	120 mm
Nominal $\varnothing D_c$	8.6 mm
Overall length L	162 mm
Tolerance nominal $\varnothing$	h7
Standard	Manufacturer's standard
Feed f in steel $< 900 \text{ N/mm}^2$	0.18 mm/rev.
recommended maximum drilling depth L_2	107.1 mm
Number of cutting edges Z	2
Series	HOLEX Pro Steel
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	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