



HOLEX Pro Steel solid carbide drill, Whistle-Notch shank DIN 6535 HE, TiAlN, Ø DC h7: 9,1 mm



Order data

| | |
|--------------|---------------|
| Order number | 123309 9,1 |
| GTIN | 4062406091972 |
| 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 : 106.35 mm

Overall length L: 162 mm

Shank Ø D_s : 10 mm

Feed f in steel < 900 N/mm²: 0.2 mm/rev.

Technical description

| | |
|------------------|--------|
| Overall length L | 162 mm |
|------------------|--------|

| | |
|--|-------------------------|
| Nominal $\varnothing D_c$ | 9.1 mm |
| recommended maximum drilling depth L_2 | 106.35 mm |
| Flute length L_c | 120 mm |
| Standard | Manufacturer's standard |
| Number of cutting edges Z | 2 |
| Shank $\varnothing D_s$ | 10 mm |
| Feed f in steel < 900 N/mm ² | 0.2 mm/rev. |
| Tolerance nominal \varnothing | h7 |
| 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 |