

HOLEX
**HOLEX Pro Steel solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC
h7: 8,6 mm**

Order data

Order number	123104 8,6
GTIN	4045197961723
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 $L_c = L_2 + 1.5 \times D_c$.

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 : 82.1 mm

Overall length L: 142 mm

Shank Ø D_s : 10 mm

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

Technical description

Flute length L_c	95 mm
Standard	Manufacturer's standard

Tolerance nominal \varnothing	h7
recommended maximum drilling depth L_2	82.1 mm
Shank $\varnothing D_s$	10 mm
Overall length L	142 mm
Number of cutting edges Z	2
Nominal $\varnothing D_c$	8.6 mm
Feed f in steel < 900 N/mm ²	0.18 mm/rev.
Series	HOLEX Pro Steel
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	8xD
Point angle	135 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Colour ring	green
Type of product	Jobber drill