

**HOLEX**
**Solid carbide high performance drill Weldon shank DIN 6535 HB, TiN, Ø DC  
h7: 8,5 mm**

**Order data**

Order number	123307 8,5
GTIN	4045197450081
Item class	12E

**Description**
**Version:**

**Strong core and special point geometry** ensure the cutting chisel edges maintain **high self-centring accuracy**.

**Straight cutting edges** with slight edge hone and a special flute profile produce **short chips**.

**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 deep-hole drill, an initial centre drilling with No. 121068 – 121130 or 3×D pilot drilling operation with No. 122736 is necessary.

Pilot drill required: yes, pilot drill

Standard: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 107.3 mm

Overall length L: 162 mm

Shank Ø  $D_s$ : 10 mm

Feed f in steel < 1100 N/mm<sup>2</sup>: 0.15 mm/rev.

**Technical description**

Shank tolerance	h6
Feed f in steel < 1100 N/mm <sup>2</sup>	0.15 mm/rev.

Nominal $\varnothing D_c$	8.5 mm
Number of cutting edges Z	2
Flute length $L_c$	120 mm
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	10 mm
Overall length L	162 mm
Standard	Manufacturer's standard
recommended maximum drilling depth $L_2$	107.3 mm
Coating	TiN
Tool material	Solid carbide
Drill depth up to	12×D
Point angle	135 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Pilot drill required	yes, pilot drill
Colour ring	green
Type of product	Jobber drill