



HOLEX Pro Steel solid carbide drill, Whistle-Notch shank DIN 6535 HE, TiAlN, Ø DC h7: 12 mm



Order data

Order number	123309 12
GTIN	4045197963680
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 : 138 mm

Overall length L: 204 mm

Shank Ø D_s : 12 mm

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

Technical description

Number of cutting edges Z	2
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Feed f in steel < 900 N/mm ²	0.2 mm/rev.
Nominal Ø D _c	12 mm
recommended maximum drilling depth L ₂	138 mm
Shank Ø D _s	12 mm
Tolerance nominal Ø	h7
Overall length L	204 mm
Flute length L _c	156 mm
Standard	Manufacturer's standard
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