

**HOLEX**
**HOLEX Pro Steel solid carbide drill, Whistle-Notch shank DIN 6535 HE, TiAlN, Ø DC h7: 3,8 mm**

**Order data**

Order number	123309 3,8
GTIN	4045197963413
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  $L_2$ : 58.3 mm

Overall length L: 102 mm

Shank Ø  $D_s$ : 6 mm

Feed  $f$  in steel < 900 N/mm<sup>2</sup>: 0.13 mm/rev.

**Technical description**

Shank Ø $D_s$	6 mm
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Flute length $L_c$	64 mm
Overall length $L$	102 mm
Tolerance nominal $\varnothing$	h7
Number of cutting edges $Z$	2
Feed $f$ in steel $< 900 \text{ N/mm}^2$	0.13 mm/rev.
Nominal $\varnothing D_c$	3.8 mm
Standard	Manufacturer's standard
recommended maximum drilling depth $L_2$	58.3 mm
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