



## HOLEX Pro Steel solid carbide drill, Whistle-Notch shank DIN 6535 HE, TiAlN, Ø DC h7: 6,8 mm



### Order data

Order number	123309 6,8
GTIN	4045197963536
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  $L_2$ : 97.8 mm

Overall length L: 146 mm

Shank Ø  $D_s$ : 8 mm

Feed  $f$  in steel < 900 N/mm<sup>2</sup>: 0.16 mm/rev.

### Technical description

Shank Ø $D_s$	8 mm
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Feed f in steel < 900 N/mm <sup>2</sup>	0.16 mm/rev.
Number of cutting edges Z	2
Overall length L	146 mm
Tolerance nominal Ø	h7
Standard	Manufacturer's standard
recommended maximum drilling depth L <sub>2</sub>	97.8 mm
Nominal Ø D <sub>c</sub>	6.8 mm
Flute length L <sub>c</sub>	108 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