



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



### Order data

|              |               |
|--------------|---------------|
| Order number | 123309 8      |
| GTIN         | 4045197963574 |
| 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  $L_2$ : 96 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 |
|---------------|------|

|   |                         |
|---|-------------------------|
| Nominal $\varnothing D_c$                         | 8 mm                    |
| Feed f in steel < 900 N/mm <sup>2</sup>           | 0.16 mm/rev.            |
| recommended maximum drilling depth L <sub>2</sub> | 96 mm                   |
| Flute length L <sub>c</sub>                       | 108 mm                  |
| Overall length L                                  | 146 mm                  |
| Tolerance nominal $\varnothing$                   | h7                      |
| Standard  | Manufacturer's standard |
| Number of cutting edges Z                         | 2                       |
| 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            |