

**HOLEX**
**HOLEX Pro INOX solid carbide high-performance drill, plain shank DIN 6535 HA, AlTiN, Ø DC m7: 3mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 122490 3      |
| GTIN         | 4067263003977 |
| Item class   | 12F           |

**Description**
**Version:**

Efficient drilling especially for use in **stainless and acid-resistant steels**. Straight main cutting edges with **optimised cutting edge design** for improved chip breaking behaviour. Enlarged flutes for **excellent chip evacuation**. Increased wear resistance due to **improved carbide substrate** and **high temperature resistant coating**.

**Note:**

Flute length  $L_c = L_2 + 1.5 \times D_c$ .

HB and HE shanks are available at the same price as HA.

For **HB shanks**: use order **no. 122491**.

For **HE shanks**: use order **no. 122492**.

**Technical description**

|   |              |
|---|--------------|
| Nominal Ø $D_c$                                   | 3 mm         |
| Tolerance nominal Ø                               | m7           |
| Number of cutting edges Z                         | 2            |
| recommended maximum drilling depth $L_2$          | 15.5 mm      |
| Overall length L                                  | 62 mm        |
| Feed f in stainless steel < 900 N/mm <sup>2</sup> | 0.05 mm/rev. |
| Standard  | DIN 6537 K   |
| Flute length $L_c$                                | 20 mm        |
| Shank Ø $D_s$                                     | 6 mm         |

|                 |                   |
|-----------------|-------------------|
| Series          | Pro Inox          |
| Coating         | AlTiN             |
| Tool material   | Solid carbide     |
| Version         | 4xD               |
| Point angle     | 140 degrees       |
| Shank           | DIN 6535 HA to h6 |
| Through-coolant | yes, with 25 bar  |
| Colour ring     | blue              |
| Type of product | Twist Drill       |

### User data

|                                | Suitability                               | V <sub>c</sub> | ISO code |
|--------------------------------|---|----------------|----------|
| Aluminium (short chipping)     | suitable only under restricted conditions | 140 m/min      | N        |
| Alu > 10% Si                   | suitable only under restricted conditions | 120 m/min      | N        |
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 120 m/min      | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 110 m/min      | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 90 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 80 m/min       | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 55 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable                                  | 45 m/min       | M        |
| Ti > 850 N/mm <sup>2</sup>     | suitable                                  | 35 m/min       | S        |
| wet maximum                    | suitable                                  |                |          |
| wet minimum                    | suitable only under restricted conditions |                |          |