

**HOLEX**
**HOLEX Pro INOX solid carbide high-performance drill, plain shank DIN 6535 HA, AlTiN, Ø DC m7: 3,9mm**

**Order data**

Order number	122490 3,9
GTIN	4067263004066
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**

Feed f in stainless steel < 900 N/mm <sup>2</sup>	0.06 mm/rev.
recommended maximum drilling depth L <sub>2</sub>	18.2 mm
Tolerance nominal Ø	m7
Shank Ø D <sub>s</sub>	6 mm
Overall length L	66 mm
Number of cutting edges Z	2
Nominal Ø D <sub>c</sub>	3.9 mm
Flute length L <sub>c</sub>	24 mm
Standard	DIN 6537 K

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		