

**HOLEX**
**HOLEX Pro Inox solid carbide high-performance drill, plain shank DIN 6535  
HA, AlTiN, Ø DC m7: 8,5mm**

**Order data**

Order number	122685 8,5
GTIN	4067263005650
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. 122686**.

For **HE shanks**: use order **no. 122687**.

**Technical description**

Standard	DIN 6537
Nominal Ø $D_c$	8.5 mm
Shank Ø $D_s$	10 mm
Feed $f$ in stainless steel < 900 N/mm <sup>2</sup>	0.11 mm/rev.
Number of cutting edges $Z$	2
Overall length $L$	103 mm
recommended maximum drilling depth $L_2$	48.3 mm
Tolerance nominal Ø	m7
Flute length $L_c$	61 mm

Series	Pro Inox
Coating	AlTiN
Tool material	Solid carbide
Version	6xD
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		