



HOLEX Pro Inox solid carbide high-performance drill, plain shank DIN 6535 HA, AlTiN, Ø DC m7: 19mm



Order data

| | |
|--------------|---------------|
| Order number | 122685 19 |
| GTIN | 4067263006077 |
| 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

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|---|--------------|
| Feed f in stainless steel < 900 N/mm ² | 0.19 mm/rev. |
| Nominal Ø D _c | 19 mm |
| Standard | DIN 6537 |
| Overall length L | 153 mm |
| Tolerance nominal Ø | m7 |
| Shank Ø D _s | 20 mm |
| Number of cutting edges Z | 2 |
| recommended maximum drilling depth L ₂ | 72.5 mm |
| Flute length L _c | 101 mm |

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|-----------------|-------------------|
| 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 _c | 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 ² | suitable | 120 m/min | P |
| Steel < 750 N/mm ² | suitable | 110 m/min | P |
| Steel < 900 N/mm ² | suitable | 90 m/min | P |
| Steel < 1100 N/mm ² | suitable | 80 m/min | P |
| INOX < 900 N/mm ² | suitable | 55 m/min | M |
| INOX > 900 N/mm ² | suitable | 45 m/min | M |
| Ti > 850 N/mm ² | suitable | 35 m/min | S |
| wet maximum | suitable | | |
| wet minimum | suitable only under restricted conditions | | |