



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



### Order data

Order number	122492 3,9
GTIN	4067263010647
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 chip grooves 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

Shank Ø $D_s$	6 mm
Flute length $L_c$	24 mm
Overall length $L$	66 mm
Nominal Ø $D_c$	3.9 mm
Standard	DIN 6537 K
recommended maximum drilling depth $L_2$	18.2 mm
Number of cutting edges $Z$	2
Tolerance nominal Ø	m7
Feed $f$ in stainless steel < 900 N/mm <sup>2</sup>	0.06 mm/rev.

Series	Pro Inox
Coating	AlTiN
Tool material	Solid carbide
Version	4xD
Point angle	140 degrees
Shank	DIN 6535 HE 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	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		