



## HOLEX Pro INOX solid carbide high-performance drill, plain shank DIN 6535 HB, AlTiN, Ø DC m7: 8mm



### Order data

|              |               |
|--------------|---------------|
| Order number | 122391 8      |
| GTIN         | 4067263006794 |
| 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  $L_c = L_2 + 1.5 \times D_c$ .

### Technical description

|   |             |
|---|-------------|
| Number of cutting edges Z                         | 2           |
| Tolerance nominal Ø                               | m7          |
| Nominal Ø $D_c$                                   | 8 mm        |
| Feed f in stainless steel < 900 N/mm <sup>2</sup> | 0.1 mm/rev. |
| Overall length L                                  | 79 mm       |
| Flute length $L_c$                                | 41 mm       |
| recommended maximum drilling depth $L_2$          | 29 mm       |
| Standard  | DIN 6537 K  |
| Shank Ø $D_s$                                     | 8 mm        |
| Series  | Pro Inox    |
| Coating   | AlTiN       |

|                 |                   |
|-----------------|-------------------|
| Tool material   | Solid carbide     |
| Version         | 4xD               |
| Point angle     | 140 degrees       |
| Shank           | DIN 6535 HB to h6 |
| Through-coolant | no                |
| 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                                  | 80 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup> | suitable                                  | 75 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup> | suitable                                  | 65 m/min       | P        |
| INOX < 900 N/mm <sup>2</sup>  | suitable                                  | 35 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>  | suitable                                  | 30 m/min       | M        |
| wet maximum                   | suitable                                  |                |          |
| wet minimum                   | suitable only under restricted conditions |                |          |