

**HOLEX**
**HOLEX Pro INOX solid carbide high-performance drill, plain shank DIN 6535  
HB, AlTiN, Ø DC m7: 9,8mm**

**Order data**

Order number	122391 9,8
GTIN	4067263006978
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**

recommended maximum drilling depth $L_2$	32.3 mm
Standard	DIN 6537 K
Tolerance nominal $\varnothing$	m7
Feed $f$ in stainless steel $< 900 \text{ N/mm}^2$	0.12 mm/rev.
Number of cutting edges $Z$	2
Flute length $L_c$	47 mm
Nominal $\varnothing D_c$	9.8 mm
Overall length $L$	89 mm
Shank $\varnothing D_s$	10 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		