

**HOLEX**
**HOLEX Pro INOX solid carbide high-performance drill, plain shank DIN 6535 HB, AlTiN, Ø DC m7: 8,4mm**

**Order data**

Order number	122491 8,4
GTIN	4067263007906
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
Overall length L	89 mm
Flute length $L_c$	47 mm
Tolerance nominal Ø	m7
Nominal Ø $D_c$	8.4 mm
recommended maximum drilling depth $L_2$	34.4 mm
Standard	DIN 6537 K
Shank Ø $D_s$	10 mm
Feed f in stainless steel < 900 N/mm <sup>2</sup>	0.11 mm/rev.
Series	Pro Inox
Coating	AlTiN

Tool material	Solid carbide
Version	4xD
Point angle	140 degrees
Shank	DIN 6535 HB 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		