

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

Order data

Order number	122491 9,9
GTIN	4067263008057
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

Tolerance nominal Ø	m7
Feed f in stainless steel $< 900 \text{ N/mm}^2$	0.12 mm/rev.
Number of cutting edges Z	2
Standard	DIN 6537 K
Shank Ø D_s	10 mm
Nominal Ø D_c	9.9 mm
Flute length L_c	47 mm
Overall length L	89 mm
recommended maximum drilling depth L_2	32.2 mm
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 _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	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		