



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



Order data

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|--------------|---------------|
| Order number | 122390 8,4 |
| GTIN | 4067263003342 |
| 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 flutes 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. 122391**.

For **HE shanks**: use order **no. 122392**.

Technical description

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|---|--------------|
| Nominal Ø D_c | 8.4 mm |
| Number of cutting edges Z | 2 |
| Overall length L | 89 mm |
| recommended maximum drilling depth L_2 | 34.4 mm |
| Tolerance nominal Ø | m7 |
| Feed f in stainless steel < 900 N/mm ² | 0.11 mm/rev. |
| Flute length L_c | 47 mm |
| Standard | DIN 6537 K |
| Shank Ø D_s | 10 mm |

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