

**HOLEX**
**HOLEX Pro INOX solid carbide high-performance drill, plain shank DIN 6535 HA, AlTiN, Ø DC m7: 4,2mm**

**Order data**

Order number	GG2490 4,2
GTIN	4067263086741
Item class	GGN

**Description**
**Version:**
**Same as No. 122490.**

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  $L_c = L_2 + 1.5 \times D_c$ .

Form HB available at the same price, using No. GG2491.

Form HB only available from  $\geq \varnothing 3$  mm.

**Technical description**

Feed $f$ in stainless steel $< 900$ N/mm <sup>2</sup>	0.06 mm/rev.
Shank $\varnothing D_s$	6 mm
Flute length $L_c$	24 mm
recommended maximum drilling depth $L_2$	17.7 mm

Tolerance nominal $\varnothing$	m7
Standard	DIN 6537 K
Nominal $\varnothing D_c$	4.2 mm
Overall length L	66 mm
Number of cutting edges Z	2
Contents	5
Series	Pro Inox
Coating	AlTiN
Tool material	Solid carbide
Version	4xD
Point angle	140 degrees
Shank	DIN 6535 HA 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 <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	90 m/min	P
Steel < 1100 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

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## Accessories

HOLEX Pro INOX solid carbide high-performance drill, plain shankDIN 6535 HA Ø DC m7 4,2 mm	122490 4,2
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