

HOLEX
HOLEX Pro INOX solid carbide high-performance drill, plain shank DIN 6535 HA, AlTiN, Ø DC m7: 3,9mm

Order data

Order number	GG2490 3,9
GTIN	4067263086710
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

Overall length L	66 mm
recommended maximum drilling depth L_2	18.2 mm
Flute length L_c	24 mm
Feed f in stainless steel < 900 N/mm ²	0.06 mm/rev.

Number of cutting edges Z	2
Standard	DIN 6537 K
Tolerance nominal \varnothing	m7
Nominal $\varnothing D_c$	3.9 mm
Shank $\varnothing D_s$	6 mm
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 ²	suitable	120 m/min	P
Steel < 750 N/mm ²	suitable	110 m/min	P
Steel < 900 N/mm ²	suitable	90 m/min	P
Steel < 1100 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

Accessories

HOLEX Pro INOX solid carbide high-performance drill, plain shankDIN 6535 HA Ø DC m7 3,9 mm	122490 3,9
--	------------