

HOLEX**HOLEX Pro INOX solid carbide high-performance drill, plain shank DIN 6535 HA, AlTiN, Ø DC m7: 8,6mm****Order data**

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|--------------|---------------|
| Order number | GG2490 8,6 |
| GTIN | 4067263086970 |
| 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

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| Overall length L | 89 mm |
| Tolerance nominal \varnothing | m7 |
| Standard | DIN 6537 K |
| Number of cutting edges Z | 2 |

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| Shank $\varnothing D_s$ | 10 mm |
| Flute length L_c | 47 mm |
| recommended maximum drilling depth L_2 | 34.1 mm |
| Contents | 5 |
| Nominal $\varnothing D_c$ | 8.6 mm |
| Feed f in stainless steel $< 900 \text{ N/mm}^2$ | 0.11 mm/rev. |
| 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 $> 10\% \text{ Si}$ | suitable only under restricted conditions | 120 m/min | N |
| Steel $< 500 \text{ N/mm}^2$ | suitable | 120 m/min | P |
| Steel $< 750 \text{ N/mm}^2$ | suitable | 110 m/min | P |
| Steel $< 900 \text{ N/mm}^2$ | suitable | 90 m/min | P |
| Steel $< 1100 \text{ N/mm}^2$ | suitable | 80 m/min | P |
| INOX $< 900 \text{ N/mm}^2$ | suitable | 55 m/min | M |
| INOX $> 900 \text{ N/mm}^2$ | suitable | 45 m/min | M |
| Ti $> 850 \text{ N/mm}^2$ | suitable | 35 m/min | S |

| | |
|-------------|---|
| wet maximum | suitable |
| wet minimum | suitable only under restricted conditions |

Accessories

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|--|------------|
| HOLEX Pro INOX solid carbide high-performance drill, plain shankDIN 6535 HA Ø DC m7 8,6 mm | 122490 8,6 |
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