

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

Order number	GG2491 3,9
GTIN	4067263086468
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 $L_c = L_2 + 1.5 \times D_c$.**Technical description**

Contents	5
Overall length L	66 mm
Standard	DIN 6537 K
Number of cutting edges Z	2
Flute length L_c	24 mm

Tolerance nominal \varnothing	m7
Nominal $\varnothing D_c$	3.9 mm
Feed f in stainless steel < 900 N/mm ²	0.06 mm/rev.
recommended maximum drilling depth L ₂	18.2 mm
Shank $\varnothing D_s$	6 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	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

AccessoriesHOLEX Pro INOX solid carbide high-performance drill, plain
shankDIN 6535 HB Ø DC m7 3,9 mm

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

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