



Value pack HOLEX Pro Inox solid carbide high-performance drill plain shank DIN 6535 HB, 5 pieces



Order data

Order number	GG2491 6,1
GTIN	4067263087328
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
Standard	DIN 6537 K
Flute length L_c	34 mm
Overall length L	79 mm
recommended maximum drilling depth L_2	24.9 mm

Data sheet

Shank $\varnothing D_s$	8 mm
Tolerance nominal \varnothing	m7
Nominal $\varnothing D_c$	6.1 mm
Feed f in stainless steel < 900 N/mm ²	0.08 mm/rev.
Number of cutting edges Z	2
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

Suitable products

<https://www.hoffmann-group.com/GB/en/hom/p/GG2491-6,1>