

**HOLEX****Value pack HOLEX Pro Inox solid carbide high-performance drill plain shank  
DIN 6535 HB, 5 pieces, Ø DC m7: 6,9mm****Order data**

Order number	GG2491 6,9
GTIN	4067263087366
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**

Standard	DIN 6537 K
Shank Ø $D_s$	8 mm
Flute length $L_c$	34 mm
Nominal Ø $D_c$	6.9 mm
Overall length L	79 mm

recommended maximum drilling depth $L_2$	23.7 mm
Contents	5
Tolerance nominal $\varnothing$	m7
Feed $f$ in stainless steel < 900 N/mm <sup>2</sup>	0.09 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 <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 6,9 mm

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