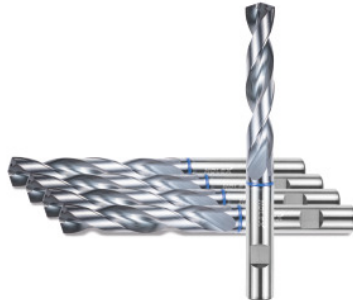


HOLEX
HOLEX Pro INOX solid carbide high-performance drill, plain shank DIN 6535 HB, AlTiN, Ø DC m7: 8,5mm

Order data

Order number	GG1286 8,5
GTIN	4067263106500
Item class	GGN

Description
Version:

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 flutes 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

Number of cutting edges Z	2
Standard	DIN 6537
Feed f in stainless steel < 900 N/mm ²	0.11 mm/rev.
Contents	5
Flute length L_c	61 mm
Shank Ø D_s	10 mm

recommended maximum drilling depth L_2	48.3 mm
Overall length L	103 mm
Tolerance nominal \varnothing	m7
Nominal $\varnothing D_c$	8.5 mm
Series	Pro Inox
Coating	AlTiN
Tool material	Solid carbide
Version	6xD
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	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 shank
DIN 6535 HA Ø DC m7 8,5 mm

122685 8,5