



HOLEX Pro Inox solid carbide high-performance drill, plain shank DIN 6535 HA, AlTiN, Ø DC m7: 8,4mm



Order data

Order number	122685 8,4
GTIN	4069515042499
Item class	12F

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 $L_c = L_2 + 1.5 \times D_c$.

HB and HE shanks are available at the same price as HA.

For **HB shanks**: use order **no. 122686**.

For **HE shanks**: use order **no. 122687**.

Technical description

Tolerance nominal Ø	m7
Standard	DIN 6537 L
Flute length L_c	61 mm
Number of cutting edges Z	2
Feed f in stainless steel < 900 N/mm ²	0.11 mm/rev.
Overall length L	103 mm
recommended maximum drilling depth L_2	48.6 mm
Shank Ø D_s	10 mm
Nominal Ø D_c	8.4 mm

Data sheet

Series	Pro Inox
Coating	AlTiN
Tool material	Solid carbide
Version	6×D
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% 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

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