



**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	GG1286 6,9
GTIN	4067263106456
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
Contents	5
Standard	DIN 6537
Shank Ø D _s	8 mm
Tolerance nominal Ø	m7
Flute length L _c	53 mm

Nominal $\varnothing D_c$	6.9 mm
Overall length L	91 mm
recommended maximum drilling depth L_2	42.7 mm
Feed f in stainless steel < 900 N/mm ²	0.09 mm/rev.
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	Jobber 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
shankDIN 6535 HA Ø DC m7 6,9 mm

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