

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

Order number	GG2491 4
GTIN	4067263086475
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 $L_c = L_2 + 1.5 \times D_s$.**Technical description**

Tolerance nominal $\varnothing$	m7
Flute length L_c	24 mm
Number of cutting edges Z	2
Shank $\varnothing D_s$	6 mm
recommended maximum drilling depth L_2	18 mm

Data sheet

Contents	5
Feed f in stainless steel < 900 N/mm ²	0.06 mm/rev.
Standard	DIN 6537 K
Overall length L	66 mm
Nominal Ø D _c	4 mm
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/GG2491-4>