



## HOLEX Pro Steel solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 8,6mm



### Order data

Order number	GG1669 8,6
GTIN	4062406207366
Item class	GGN

### Description

#### Version:

**Straight major cutting edges** and a **special flute profile** ensure good chip evacuation. The robust cutter geometry ensures high-performance drilling with good process reliability. A wide range of applications in steel materials thanks to a combination of tough ultra-fine grain carbide and extremely wear-resistant coating.

Same as No. 122502.

#### Recommendation:

##### Maximum drilling depth:

Flute length (see table) less 1.5×nominal Ø.

### Technical description

Number of cutting edges Z	2
Shank Ø D <sub>s</sub>	1 mm
Overall length L	89 mm
Feed f in steel < 900 N/mm <sup>2</sup>	0.2 mm/rev.
recommended maximum drilling depth L <sub>2</sub>	34.1 mm

Nominal $\varnothing D_c$	8.6 mm
Flute length $L_c$	47 mm
Tolerance nominal $\varnothing$	h7
Standard	DIN 6537 K
Contents	5
Series	Pro Steel
Coating	TiAlN
Tool material	Solid carbide
Version	4xD
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Machining strategy	HPC
Type of product	Jobber drill

## User data

	Suitability	$V_c$	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	115 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	105 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	85 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	60 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	30 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	25 m/min	M
GG	suitable	90 m/min	K
GGG	suitable	55 m/min	K
wet maximum	suitable		
dry	suitable		

## Accessories

HOLEX Pro Steel solid carbide drill, plain shankDIN 6535 HA Ø DC h7 (mm or inch) 8,6	122501 8,6
Shank grinding Type HB	129100 HB