



HOLEX Pro Steel solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 17,7mm



Order data

| | |
|--------------|---------------|
| Order number | GG1669 17,7 |
| GTIN | 4062406207403 |
| 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

| | |
|---|--------------|
| Tolerance nominal Ø | h7 |
| Nominal Ø D _c | 17.7 mm |
| Feed f in steel < 900 N/mm ² | 0.28 mm/rev. |
| Standard | DIN 6537 K |
| Overall length L | 123 mm |

| | |
|--|-------------------|
| Flute length L_c | 73 mm |
| Shank $\varnothing D_s$ | 18 mm |
| recommended maximum drilling depth L_2 | 46.5 mm |
| Number of cutting edges Z | 2 |
| 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 ² | suitable | 115 m/min | P |
| Steel < 750 N/mm ² | suitable | 105 m/min | P |
| Steel < 900 N/mm ² | suitable | 85 m/min | P |
| Steel < 1100 N/mm ² | suitable | 80 m/min | P |
| Steel < 1400 N/mm ² | suitable | 60 m/min | P |
| INOX < 900 N/mm ² | suitable | 30 m/min | M |
| INOX > 900 N/mm ² | 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

| | |
|--|-------------|
| Shank grinding Type HB | 129100 HB |
| HOLEX Pro Steel solid carbide drill, plain shankDIN 6535 HA Ø DC h7 (mm or inch) 17,7 | 122501 17,7 |