

**HOLEX**
**HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 9mm**

**Order data**

Order number	GG1668 9
GTIN	4045197986450
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.

With relieved cone.

**Same as No. 122501.**

Form HB available at the same price, using No. GG1669.

**Note:**

Flute length  $L_c = L_2 + 1.5 \times D_c$ .

**Technical description**

Overall length L	89 mm
Standard	DIN 6537 K
Tolerance nominal Ø	h7
recommended maximum drilling depth $L_2$	33.5 mm
Number of cutting edges Z	2

Feed f in steel < 900 N/mm <sup>2</sup>	0.2 mm/rev.
Flute length L <sub>c</sub>	47 mm
Shank Ø D <sub>s</sub>	10 mm
Nominal Ø D <sub>c</sub>	9 mm
Contents	5
Series	Pro Steel
Coating	TiAlN
Tool material	Solid carbide
Version	4xD
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Machining strategy	HPC
Type of product	Jobber drill

## User data

	Suitability	V <sub>c</sub>	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
Uni	suitable		
wet maximum	suitable		
dry	suitable		

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## Accessories

HOLEX Pro Steel solid carbide drill, plain shankDIN 6535 HA  
Ø DC h7 (mm or inch) 9

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