

HOLEX
HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 18mm

Order data

Order number	GG1668 18
GTIN	4045197986641
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

Feed f in steel $< 900 \text{ N/mm}^2$	0.28 mm/rev.
Flute length L_c	73 mm
Standard	DIN 6537 K
Overall length L	123 mm
Shank $\varnothing D_s$	18 mm

Nominal $\varnothing D_c$	18 mm
Tolerance nominal \varnothing	h7
recommended maximum drilling depth L_2	46 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 HA 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
Uni	suitable		
wet maximum	suitable		
dry	suitable		

Accessories

HOLEX Pro Steel solid carbide drill, plain shankDIN 6535 HA
Ø DC h7 (mm or inch) 18

122501 18