



Value pack HOLEX Pro Steel solid carbide drill Weldon shank DIN 6535 HB, 5 pieces, Ø DC h7: 18mm



Order data

Order number	GG1669 18
GTIN	4045197987037
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

Nominal Ø D _c	18 mm
Standard	DIN 6537 K
Overall length L	123 mm
Shank Ø D _s	18 mm
Flute length L _c	73 mm
Number of cutting edges Z	2

Tolerance nominal \varnothing	h7
Feed f in steel < 900 N/mm ²	0.28 mm/rev.
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

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

122501 18

Shank grinding Type HB

129100 HB