

**HOLEX**
**HOLEX Pro Steel solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 18,5mm**

**Order data**

Order number	GG1669 18,5
GTIN	4045197987044
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**

Flute length $L_c$	79 mm
Feed $f$ in steel $< 900 \text{ N/mm}^2$	0.28 mm/rev.
Shank $\varnothing D_s$	20 mm
Standard	DIN 6537 K
Nominal $\varnothing D_c$	18.5 mm

Number of cutting edges Z	2
Overall length L	131 mm
Tolerance nominal $\varnothing$	h7
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) 18,5	122501 18,5
Shank grinding Type HB	129100 HB