

**HOLEX****HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7:  
4,2mm****Order data**

Order number	GG1672 4,2
GTIN	4045197987907
Item class	GGN

**Description****Version:**

**Straight major cutting edges** and a **special flute profile** ensure good chip evacuation. The robust cutting edge 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. 122776.**

Form HB available at the same price, using No. GG1673.

**Note:**

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

**Technical description**

Tolerance nominal Ø	h7
Overall length L	74 mm
Number of cutting edges Z	2
Standard	DIN 6537
Shank Ø D <sub>s</sub>	6 mm

Flute length $L_c$	36 mm
Nominal $\varnothing D_c$	4.2 mm
Feed $f$ in steel $< 900 \text{ N/mm}^2$	0.14 mm/rev.
recommended maximum drilling depth $L_2$	29.7 mm
Contents	5
Series	Pro Steel
Coating	TiAlN
Tool material	Solid carbide
Version	6xD
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Type of product	Jobber drill

## User data

	Suitability	$V_c$	ISO code
Alu plastics	suitable only under restricted conditions	250 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	200 m/min	N
Alu $> 10\% \text{ Si}$	suitable only under restricted conditions	160 m/min	N
Steel $< 500 \text{ N/mm}^2$	suitable	125 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	115 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	95 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	90 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable	65 m/min	P
INOX $< 900 \text{ N/mm}^2$	suitable	35 m/min	M

INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	30 m/min	M
GG	suitable	100 m/min	K
GGG	suitable	65 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		

## Accessories

HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA  
 Ø DC h7 (mm or inch) 4,2

122776 4,2