

**HOLEX**
**HOLEX Pro Steel solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC  
h7: 8,5mm**

**Order data**

Order number	GG1673 8,5
GTIN	4045197988386
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.

Same as No. 122777.

**Recommendation:**
**Maximum drilling depth:**

Flute length (see table) less 1.5×nominal Ø.

**Technical description**

Number of cutting edges Z	2
Flute length L <sub>c</sub>	61 mm
Overall length L	103 mm
Tolerance nominal Ø	h7
Standard	DIN 6537

Feed f in steel < 900 N/mm <sup>2</sup>	0.2 mm/rev.
Shank Ø D <sub>s</sub>	10 mm
Nominal Ø D <sub>c</sub>	8.5 mm
Contents	5
Series	Pro Steel
Coating	TiAlN
Tool material	Solid carbide
Version	6×D
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Type of product	Jobber drill

## User data

	Suitability	V <sub>c</sub>	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% Si	suitable only under restricted conditions	160 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	125 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	115 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	95 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	65 m/min	P
INOX < 900 N/mm <sup>2</sup>	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
wet maximum	suitable		
wet minimum	suitable		

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## Accessories

HOLEX Pro Steel solid carbide drill, plain shankDIN 6535 HA Ø DC h7 (mm or inch) 8,5	122776 8,5
Shank grinding Type HB	129100 HB