

**HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 8,6mm****Order data**

Order number	GG1670 8,6
GTIN	4062406207526
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. 122504.

Form HB available with No. GG1671 at the same price.

Note:

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

Technical description

Flute length L_c	47 mm
Number of cutting edges Z	2
Shank Ø D_s	10 mm
Feed f in steel < 900 N/mm ²	0.2 mm/rev.
Standard	DIN 6537 K

recommended maximum drilling depth L ₂	34.1 mm
Nominal Ø D _c	8.6 mm
Overall length L	89 mm
Tolerance nominal Ø	h7
Contents	5
Series	Pro Steel
Coating	TiAlN
Tool material	Solid carbide
Version	4xD
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% Si	suitable only under restricted conditions	160 m/min	N
Steel < 500 N/mm ²	suitable	125 m/min	P
Steel < 750 N/mm ²	suitable	115 m/min	P
Steel < 900 N/mm ²	suitable	95 m/min	P
Steel < 1100 N/mm ²	suitable	90 m/min	P
Steel < 1400 N/mm ²	suitable	65 m/min	P
INOX < 900 N/mm ²	suitable	35 m/min	M

INOX > 900 N/mm ²	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 shankDIN 6535 HA
Ø DC h7 (mm or inch) 8,6

122504 8,6