

**HOLEX Pro Steel solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC  
h7: 3mm****Order data**

|              |               |
|--------------|---------------|
| Order number | GG1671 3      |
| GTIN         | 4045197987471 |
| 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. 122507.

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

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

**Technical description**

|                                         |              |
|-----------------------------------------|--------------|
| Overall length L                        | 62 mm        |
| Number of cutting edges Z               | 2            |
| Standard                                | DIN 6537 K   |
| Feed f in steel < 900 N/mm <sup>2</sup> | 0.11 mm/rev. |
| Tolerance nominal Ø                     | h7           |

|                           |                   |
|---------------------------|-------------------|
| Flute length $L_c$        | 20 mm             |
| Shank $\varnothing D_s$   | 6 mm              |
| Nominal $\varnothing D_c$ | 3 mm              |
| Contents                  | 5                 |
| Series                    | Pro Steel         |
| Coating                   | TiAlN             |
| Tool material             | Solid carbide     |
| Version                   | 4xD               |
| 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                               | $V_c$     | 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 <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) 3

122504 3

Shank grinding Type HB

129100 HB