



**Value pack HOLEX Pro Steel solid carbide drill Weldon shank DIN 6535 HB, 5 pieces, Ø DC h7: 10mm**



## Order data

|              |               |
|--------------|---------------|
| Order number | GG1669 10     |
| GTIN         | 4045197986863 |
| 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

|                                         |              |
|-----------------------------------------|--------------|
| Overall length L                        | 89 mm        |
| Feed f in steel < 900 N/mm <sup>2</sup> | 0.22 mm/rev. |
| Tolerance nominal Ø                     | h7           |
| Number of cutting edges Z               | 2            |
| Standard                                | DIN 6537 K   |

|                           |                   |
|---------------------------|-------------------|
| Flute length $L_c$        | 47 mm             |
| Nominal $\varnothing D_c$ | 10 mm             |
| Shank $\varnothing D_s$   | 10 mm             |
| 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) 10

122501 10

Shank grinding Type HB

129100 HB