



**Value pack HOLEX Pro Steel solid carbide drill Weldon shank DIN 6535 HB, 5 pieces, Ø DC h7: 11mm**



## Order data

|              |               |
|--------------|---------------|
| Order number | GG1669 11     |
| GTIN         | 4045197986894 |
| 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

|                             |        |
|-----------------------------|--------|
| Nominal Ø D <sub>c</sub>    | 11 mm  |
| Overall length L            | 102 mm |
| Number of cutting edges Z   | 2      |
| Flute length L <sub>c</sub> | 55 mm  |
| Shank Ø D <sub>s</sub>      | 12 mm  |

|                                         |                   |
|-----------------------------------------|-------------------|
| Feed f in steel < 900 N/mm <sup>2</sup> | 0.22 mm/rev.      |
| Tolerance nominal Ø                     | h7                |
| Standard                                | DIN 6537 K        |
| Contents                                | 5                 |
| Series                                  | Pro Steel         |
| Coating                                 | TiAlN             |
| Tool material                           | Solid carbide     |
| Version                                 | 4×D               |
| Point angle                             | 140 degrees       |
| Shank                                   | DIN 6535 HB to h6 |
| Machining strategy                      | HPC               |
| Type of product                         | Jobber drill      |

## User data

|                                | Suitability                               | V <sub>c</sub> | 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) 11

122501 11

Shank grinding Type HB

129100 HB