

**Value pack HOLEX Pro Steel solid carbide drill Weldon shank DIN 6535 HB, 5 pieces, Ø DC h7: 8,6mm****Order data**

Order number	GG1673 8,6
GTIN	4062406207854
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

recommended maximum drilling depth L_2	48.1 mm
Flute length L_c	61 mm
Nominal Ø D_c	8.6 mm
Feed f in steel $< 900 \text{ N/mm}^2$	0.2 mm/rev.
Shank Ø D_s	10 mm
Standard	DIN 6537
Overall length L	103 mm
Tolerance nominal Ø	h7
Number of cutting edges Z	2
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 _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
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

122776 8,6

Shank grinding Type HB

129100 HB