

**HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 9,5mm****Order data**

|              |               |
|--------------|---------------|
| Order number | GG1670 9,5    |
| GTIN         | 4045197987242 |
| 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**

|                                          |              |
|------------------------------------------|--------------|
| Shank Ø $D_s$                            | 10 mm        |
| Feed $f$ in steel $< 900 \text{ N/mm}^2$ | 0.22 mm/rev. |
| Overall length $L$                       | 89 mm        |
| Standard                                 | DIN 6537 K   |
| Nominal Ø $D_c$                          | 9.5 mm       |

|                                          |                   |
|------------------------------------------|-------------------|
| Tolerance nominal Ø                      | h7                |
| Flute length $L_c$                       | 47 mm             |
| recommended maximum drilling depth $L_2$ | 32.8 mm           |
| Number of cutting edges Z                | 2                 |
| 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 <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 |
| 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) 9,5

122504 9,5