



**Value pack HOLEX Pro Steel solid carbide drill plain shank DIN 6535 HA, 5 pieces, Ø DC h7: 13mm**



## Order data

|              |               |
|--------------|---------------|
| Order number | GG1672 13     |
| GTIN         | 4045197988102 |
| 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.

With relieved cone.

**Same as No. 122776.**

Form HB available at the same price, using No. GG1673.

### Note:

Flute length  $L_c = L_2 + 1.5 \times D_c$ .

## Technical description

|                                                   |              |
|---------------------------------------------------|--------------|
| Number of cutting edges Z                         | 2            |
| Feed f in steel < 900 N/mm <sup>2</sup>           | 0.26 mm/rev. |
| Tolerance nominal Ø                               | h7           |
| recommended maximum drilling depth L <sub>2</sub> | 57.5 mm      |
| Overall length L                                  | 124 mm       |

|                           |                   |
|---------------------------|-------------------|
| Nominal $\varnothing D_c$ | 13 mm             |
| Standard                  | DIN 6537          |
| Flute length $L_c$        | 77 mm             |
| Shank $\varnothing D_s$   | 14 mm             |
| Contents                  | 5                 |
| Series                    | Pro Steel         |
| Coating                   | TiAlN             |
| Tool material             | Solid carbide     |
| Version                   | 6xD               |
| 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) 13

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