

**HOLEX Pro Steel solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 13mm****Order data**

Order number	GG1671 13
GTIN	4045197987716
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. 122507.

Recommendation:**Maximum drilling depth:**

Flute length (see table) less 1.5×nominal Ø.

Technical description

Nominal Ø D _c	13 mm
Standard	DIN 6537 K
Number of cutting edges Z	2
Tolerance nominal Ø	h7
Shank Ø D _s	14 mm
Overall length L	107 mm

Feed f in steel < 900 N/mm ²	0.26 mm/rev.
Flute length L _c	60 mm
Contents	5
Series	Pro Steel
Coating	TiAlN
Tool material	Solid carbide
Version	4xD
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) 13	122504 13
Shank grinding Type HB	129100 HB