

**HOLEX**
**HOLEX Pro INOX solid carbide high-performance drill, plain shank DIN 6535  
HB, AlTiN, Ø DC m7: 13mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 122491 13     |
| GTIN         | 4067263008194 |
| Item class   | 12F           |

**Description**
**Version:**

Efficient drilling especially for use in **stainless and acid-resistant steels**.

Straight main cutting edges with **optimised cutting edge design** for improved chip breaking behaviour. Enlarged chip grooves for **excellent chip evacuation**. Increased wear resistance due to **improved carbide substrate** and **high temperature resistant coating**.

**Note:**

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

**Technical description**

|  |              |
|--|--------------|
| Shank Ø $D_s$                                      | 14 mm        |
| Standard   | DIN 6537 K   |
| Nominal Ø $D_c$                                    | 13 mm        |
| Feed $f$ in stainless steel $< 900 \text{ N/mm}^2$ | 0.14 mm/rev. |
| Flute length $L_c$                                 | 60 mm        |
| recommended maximum drilling depth $L_2$           | 40.5 mm      |
| Number of cutting edges $Z$                        | 2            |
| Tolerance nominal Ø                                | m7           |
| Overall length $L$                                 | 107 mm       |
| Series   | Pro Inox     |
| Coating  | AlTiN        |

|                 |                   |
|-----------------|-------------------|
| Tool material   | Solid carbide     |
| Version         | 4xD               |
| Point angle     | 140 degrees       |
| Shank           | DIN 6535 HB to h6 |
| Through-coolant | yes, with 25 bar  |
| Colour ring     | blue              |
| Type of product | Twist Drill       |

### User data

|                               | Suitability                               | V <sub>c</sub> | ISO code |
|-------------------------------|---|----------------|----------|
| Aluminium (short chipping)    | suitable only under restricted conditions | 140 m/min      | N        |
| Alu > 10% Si                  | suitable only under restricted conditions | 120 m/min      | N        |
| Steel < 500 N/mm <sup>2</sup> | suitable                                  | 120 m/min      | P        |
| Steel < 750 N/mm <sup>2</sup> | suitable                                  | 110 m/min      | P        |
| Steel < 900 N/mm <sup>2</sup> | suitable                                  | 80 m/min       | P        |
| INOX < 900 N/mm <sup>2</sup>  | suitable                                  | 55 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>  | suitable                                  | 45 m/min       | M        |
| Ti > 850 N/mm <sup>2</sup>    | suitable                                  | 35 m/min       | S        |
| wet maximum                   | suitable                                  |                |          |
| wet minimum                   | suitable only under restricted conditions |                |          |