



HOLEX Pro INOX solid carbide high-performance drill, plain shank DIN 6535 HB, AlTiN, Ø DC m7: 13,8mm



Order data

Order number	122491 13,8
GTIN	4067263008217
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

Overall length L	107 mm
recommended maximum drilling depth L_2	39.3 mm
Nominal Ø D_c	13.8 mm
Standard	DIN 6537 K
Shank Ø D_s	14 mm
Feed f in stainless steel < 900 N/mm ²	0.15 mm/rev.
Number of cutting edges Z	2
Flute length L_c	60 mm
Tolerance nominal Ø	m7
Series	Pro Inox
Coating	AlTiN

Tool material	Solid carbide
Version	4×D
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 _c	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 ²	suitable	120 m/min	P
Steel < 750 N/mm ²	suitable	110 m/min	P
Steel < 900 N/mm ²	suitable	80 m/min	P
INOX < 900 N/mm ²	suitable	55 m/min	M
INOX > 900 N/mm ²	suitable	45 m/min	M
Ti > 850 N/mm ²	suitable	35 m/min	S
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		