



HOLEX Pro Steel solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 13



Order data

Order number	122501 13
GTIN	4045197825131
Item class	12F

Description

Version:

Straight major cutting edges and a **special flute profile** ensure a 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 an extremely wear-resistant coating.

Up to Ø 1.9 with 4 facets, from Ø 2 with relieved cone.

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. **Straight major cutting edges** with slightly honed edges and special flute profile produce **short chips**.

Note:

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

Versions with HB and HE shank available at the same price as HA.

For **HB shanks**: use order **no. 122502**.

For **HE shanks**: use order **No. 122503**.

Standard: DIN 6537 K

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth L_2 : 40.5 mm

Overall length L: 107 mm

Shank Ø D_s : 14 mm

Feed f in steel < 900 N/mm²: 0.26 mm/rev.

Technical description

Number of cutting edges Z	2
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Overall length L	107 mm
Standard	DIN 6537 K
recommended maximum drilling depth L ₂	40.5 mm
Tolerance nominal Ø	h7
Feed f in steel < 900 N/mm ²	0.26 mm/rev.
Nominal Ø D _c	13 mm
Shank Ø D _s	14 mm
Flute length L _c	60 mm
Series	Pro Steel
Coating	TiAlN
Tool material	Solid carbide
Version	4×D
Point angle	140 °
Shank	DIN 6535 HA to h6
Through-coolant	no
Machining strategy	HPC
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Steel < 500 N/mm ²	suitable	115 m/min	P
Steel < 750 N/mm ²	suitable	105 m/min	P
Steel < 900 N/mm ²	suitable	85 m/min	P
Steel < 1100 N/mm ²	suitable	80 m/min	P
Steel < 1400 N/mm ²	suitable	60 m/min	P
INOX < 900 N/mm ²	suitable	30 m/min	M

INOX > 900 N/mm ²	suitable only under restricted conditions	25 m/min	M
GG	suitable	90 m/min	K
GGG	suitable	55 m/min	K
Uni	suitable		
wet maximum	suitable		
dry	suitable		