


**HOLEX CleverDrill HSS jobber drill, uncoated, Ø DC h8: 9,4mm**

**Order data**

Order number	113006 9,4
GTIN	4062406743055
Item class	12B

**Description**
**Version:**

Sturdy drills for all standard applications. Improved spot drilling behaviour due to cross-ground form. Standard core thickness and core taper. Profile ground. Surface: Bronze-coloured tempered helical flutes.

**Recommendation:**
**Maximum drilling depth:**

$$L_2 = L_c - 1.5 \times D_c.$$

**Note:**

**Successor product to No. 113005.**

**Technical description**

recommended maximum drilling depth $L_2$	25.9 mm
Shank Ø $D_s$	9.4 mm
Point angle	118 degrees
Number of cutting edges $Z$	2
Feed $f$ in steel $< 750 \text{ N/mm}^2$	0.1 mm/rev.
Nominal Ø $D_c$	9.4 mm
Flute length $L_c$	40 mm
Standard	DIN 1897
Overall length $L$	84 mm
Tolerance nominal Ø	h8

Shank	Plain shank
Series	CleverDrill
Coating	uncoated
Tool material	HSS
Type	N
Through-coolant	no
Colour ring	without
Type of product	Jobber drill

### User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable	80 m/min	N
Aluminium (short chipping)	suitable	63 m/min	N
Alu > 10% Si	suitable	50 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	35 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	32 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	25 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	20 m/min	P
GG(G)	suitable	30 m/min	K
CuZn	suitable	40 m/min	N
Oil	suitable		
wet maximum	suitable		