


**HOLEX CleverDrill HSS jobber drill, uncoated, Ø DC h8: 11,5mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 113006 11,5   |
| GTIN         | 4062406743154 |
| 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**

|   |             |
|---|-------------|
| Overall length L                                  | 95 mm       |
| Flute length L <sub>c</sub>                       | 47 mm       |
| Point angle                                       | 118 degrees |
| Feed f in steel < 750 N/mm <sup>2</sup>           | 0.1 mm/rev. |
| Standard  | DIN 1897    |
| Nominal Ø D <sub>c</sub>                          | 11.5 mm     |
| Shank Ø D <sub>s</sub>                            | 11.5 mm     |
| Number of cutting edges Z                         | 2           |
| recommended maximum drilling depth L <sub>2</sub> | 29.8 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    |                |          |