


HOLEX CleverDrill HSS jobber drill, uncoated, Ø DC h8: 4,2mm

Order data

| | |
|--------------|---------------|
| Order number | 113006 4,2 |
| GTIN | 4062406742539 |
| 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 | 55 mm |
| Standard | DIN 1897 |
| Point angle | 118 degrees |
| Tolerance nominal Ø | h8 |
| Shank Ø D _s | 4.2 mm |
| Number of cutting edges Z | 2 |
| Flute length L _c | 22 mm |
| Feed f in steel < 750 N/mm ² | 0.05 mm/rev. |
| recommended maximum drilling depth L ₂ | 15.7 mm |
| Nominal Ø D _c | 4.2 mm |

| | |
|-----------------|--------------|
| 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 _c | 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 ² | suitable | 35 m/min | P |
| Steel < 750 N/mm ² | suitable | 32 m/min | P |
| Steel < 900 N/mm ² | suitable | 25 m/min | P |
| Steel < 1100 N/mm ² | suitable | 20 m/min | P |
| GG(G) | suitable | 30 m/min | K |
| CuZn | suitable | 40 m/min | N |
| Oil | suitable | | |
| wet maximum | suitable | | |