

**HOLEX CleverDrill HSS jobber drill, uncoated, Ø DC h8: 8mm****Order data**

Order number	113006 8
GTIN	4062406742911
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**

Nominal Ø D <sub>c</sub>	8 mm
Point angle	118 degrees
recommended maximum drilling depth L <sub>2</sub>	25 mm
Standard	DIN 1897
Shank Ø D <sub>s</sub>	8 mm
Flute length L <sub>c</sub>	37 mm
Tolerance nominal Ø	h8
Number of cutting edges Z	2
Overall length L	79 mm
Feed f in steel < 750 N/mm <sup>2</sup>	0.1 mm/rev.

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		

## Accessories

HOLEX CleverDrill stub drill set HSS No. 113006, type N in a case Type 1-10

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