

**HOLEX CleverDrill HSS jobber drill, uncoated, Ø DC h8: 8,4mm****Order data**

Order number	113006 8,4
GTIN	4062406742959
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	24.4 mm
Overall length L	79 mm
Flute length L_c	37 mm
Feed f in steel < 750 N/mm ²	0.1 mm/rev.
Point angle	118 degrees
Shank Ø D_s	8.4 mm
Tolerance nominal Ø	h8
Number of cutting edges Z	2
Nominal Ø D_c	8.4 mm
Standard	DIN 1897

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		