



HOLEX CleverDrill HSS jobber drill, uncoated, Ø DC h8: 8,9mm



Order data

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| Order number | 113006 8,9 |
| GTIN | 4062406743000 |
| 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

| | |
|--|-------------|
| Standard | DIN 1897 |
| Flute length L_c | 40 mm |
| Tolerance nominal \varnothing | h8 |
| Feed f in steel $< 750 \text{ N/mm}^2$ | 0.1 mm/rev. |
| Nominal $\varnothing D_c$ | 8.9 mm |
| Shank $\varnothing D_s$ | 8.9 mm |
| Overall length L | 84 mm |
| Number of cutting edges Z | 2 |
| Point angle | 118 degrees |
| recommended maximum drilling depth L_2 | 26.7 mm |

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|-----------------|--------------|
| 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 | | |