



## HOLEX CleverDrill HSS jobber drill N, uncoated, Ø DC h8 (mm or inch): 15



### Order data

Order number	114031 15
GTIN	4062406744878
Item class	12B

### Description

#### Version:

**HOLEX CleverDrill:** 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. 114030.

Size 13.2 – 20: With stepped shank Ø 12.7 mm.

Through-coolant: no

Standard: DIN 338

Tolerance nominal Ø: h8

Point angle: 118 °

Shank: Plain shank

Number of cutting edges Z: 2

recommended maximum drilling depth  $L_2$ : 91.5 mm

Flute length  $L_c$ : 114 mm

Overall length L: 169 mm

Shank Ø  $D_s$ : 12.7 mm

Feed f in steel < 750 N/mm<sup>2</sup>: 0.16 mm/rev.

### Technical description

Tolerance nominal Ø	h8
Flute length $L_c$	114 mm

Shank $\varnothing D_s$	12.7 mm
Point angle	118 °
Overall length L	169 mm
Nominal $\varnothing D_c$	15 mm
Feed f in steel < 750 N/mm <sup>2</sup>	0.16 mm/rev.
Number of cutting edges Z	2
recommended maximum drilling depth L <sub>2</sub>	91.5 mm
Standard	DIN 338
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	60 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	22 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	18 m/min	P
GG(G)	suitable	30 m/min	K
CuZn	suitable	40 m/min	N

Oil	suitable
wet maximum	suitable