


HOLEX CleverDrill HSS jobber drill N, uncoated, Ø DC h8 (mm or inch): 1,1

Order data

Order number	114031 1,1
GTIN	4062406743512
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 : 12.4 mm

Flute length L_c : 14 mm

Overall length L: 36 mm

Shank Ø D_s : 1.1 mm

Feed f in steel < 750 N/mm²: 0.03 mm/rev.

Technical description

recommended maximum drilling depth L_2	12.4 mm
Number of cutting edges Z	2

Flute length L_c	14 mm
Tolerance nominal \varnothing	h8
Shank $\varnothing D_s$	1.1 mm
Feed f in steel $< 750 \text{ N/mm}^2$	0.03 mm/rev.
Point angle	118 °
Nominal $\varnothing D_c$	1.1 mm
Overall length L	36 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_c	ISO code
Alu plastics	suitable	80 m/min	N
Aluminium (short chipping)	suitable	60 m/min	N
Alu $> 10\% \text{ Si}$	suitable	50 m/min	N
Steel $< 500 \text{ N/mm}^2$	suitable	35 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	32 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	22 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	18 m/min	P
GG(G)	suitable	30 m/min	K
CuZn	suitable	40 m/min	N

Oil	suitable
wet maximum	suitable

Accessories

HOLEX CleverDrill HSS jobber drill set No. 114031 as a refill set Type 1-6	115056 1-6
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