


HOLEX CleverDrill HSS jobber drill N, uncoated, Ø DC h8 (mm or inch): 9,6

Order data

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|--------------|---------------|
| Order number | 114031 9,6 |
| GTIN | 4062406744526 |
| 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 : 72.6 mm

Flute length L_c : 87 mm

Overall length L: 133 mm

Shank Ø D_s : 9.6 mm

Feed f in steel < 750 N/mm²: 0.1 mm/rev.

Technical description

| | |
|---------------------------|-------|
| Point angle | 118 ° |
| Number of cutting edges Z | 2 |

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|--|--------------|
| Flute length L_c | 87 mm |
| Nominal $\varnothing D_c$ | 9.6 mm |
| Feed f in steel $< 750 \text{ N/mm}^2$ | 0.1 mm/rev. |
| Overall length L | 133 mm |
| Tolerance nominal \varnothing | h8 |
| Standard | DIN 338 |
| Shank $\varnothing D_s$ | 9.6 mm |
| recommended maximum drilling depth L_2 | 72.6 mm |
| 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 |

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|-------------|----------|
| Oil | suitable |
| wet maximum | suitable |

Accessories

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|---|-------------|
| HOLEX CleverDrill jobber drill set HSS No. 114031 in a case Type 6-10 | 115051 6-10 |
| HOLEX CleverDrill HSS jobber drill set No. 114031 as a refill set Type 6-10 | 115056 6-10 |