


HOLEX CleverDrill HSS jobber drill N, uncoated, Ø DC h8 (mm or inch): 18

Order data

Order number	114031 18
GTIN	4062406744953
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 : 103 mm

Flute length L_c : 130 mm

Overall length L: 191 mm

Shank Ø D_s : 12.7 mm

Feed f in steel < 750 N/mm²: 0.2 mm/rev.

Technical description

recommended maximum drilling depth L_2	103 mm
Feed f in steel < 750 N/mm ²	0.2 mm/rev.

Flute length L_c	130 mm
Nominal $\varnothing D_c$	18 mm
Tolerance nominal \varnothing	h8
Number of cutting edges Z	2
Standard	DIN 338
Shank $\varnothing D_s$	12.7 mm
Overall length L	191 mm
Point angle	118°
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% 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	22 m/min	P
Steel < 1100 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