



## HOLEX CleverDrill HSS jobber drill N, uncoated, Ø DC h8 (mm or inch): 6,4



### Order data

|              |               |
|--------------|---------------|
| Order number | 114031 6,4    |
| GTIN         | 4062406744182 |
| 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  $L_2$ : 53.4 mm

Flute length  $L_c$ : 63 mm

Overall length L: 101 mm

Shank Ø  $D_s$ : 6.4 mm

Feed f in steel < 750 N/mm<sup>2</sup>: 0.07 mm/rev.

### Technical description

|  |         |
|--|---------|
| Number of cutting edges Z                | 2       |
| recommended maximum drilling depth $L_2$ | 53.4 mm |

|   |              |
|---|--------------|
| Nominal $\varnothing D_c$               | 6.4 mm       |
| Flute length $L_c$                      | 63 mm        |
| Shank $\varnothing D_s$                 | 6.4 mm       |
| Overall length L                        | 101 mm       |
| Tolerance nominal $\varnothing$         | h8           |
| Standard                                | DIN 338      |
| Feed f in steel < 750 N/mm <sup>2</sup> | 0.07 mm/rev. |
| 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 <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 |

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## Accessories

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