


**HOLEX CleverDrill HSS jobber drill N, uncoated, Ø DC h8 (mm or inch): 1,8**

**Order data**

Order number	114031 1,8
GTIN	4062406743659
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  $L_2$ : 19.3 mm

Flute length  $L_c$ : 22 mm

Overall length L: 46 mm

Shank Ø  $D_s$ : 1.8 mm

Feed f in steel < 750 N/mm<sup>2</sup>: 0.03 mm/rev.

**Technical description**

Number of cutting edges Z	2
Point angle	118 °

Feed f in steel < 750 N/mm <sup>2</sup>	0.03 mm/rev.
Standard	DIN 338
Nominal Ø D <sub>c</sub>	1.8 mm
Overall length L	46 mm
Shank Ø D <sub>s</sub>	1.8 mm
Flute length L <sub>c</sub>	22 mm
recommended maximum drilling depth L <sub>2</sub>	19.3 mm
Tolerance nominal Ø	h8
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

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## Accessories

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