


**HOLEX CleverDrill HSS jobber drill N, uncoated, Ø DC h8 (mm or inch): 2,8**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 114031 2,8    |
| GTIN         | 4062406743796 |
| 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  $L_2$ : 28.8 mm

Flute length  $L_c$ : 33 mm

Overall length L: 61 mm

Shank Ø  $D_s$ : 2.8 mm

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

**Technical description**

|                  |       |
|------------------|-------|
| Overall length L | 61 mm |
| Point angle      | 118 ° |

|  |              |
|--|--------------|
| Standard                                 | DIN 338      |
| recommended maximum drilling depth $L_2$ | 28.8 mm      |
| Number of cutting edges Z                | 2            |
| Flute length $L_c$                       | 33 mm        |
| Nominal $\varnothing D_c$                | 2.8 mm       |
| Shank $\varnothing D_s$                  | 2.8 mm       |
| Feed f in steel < 750 N/mm <sup>2</sup>  | 0.03 mm/rev. |
| Tolerance nominal $\varnothing$          | 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 | $V_c$    | 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

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