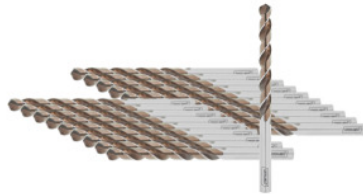



HOLEX CleverDrill HSS jobber drill N, uncoated, Ø DC h8: 6,8mm

Order data

Order number	GG4031 6,8
GTIN	4067263101857
Item class	GGN

Description
Version:

HOLEX CleverDrill: Sturdy drill 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.

Same as No. 114031.

Recommendation:
Maximum drilling depth:

$$L_2 = L_c - 1.5 \times D_c$$

Note:

Successor product to No. 114030.

Size 13.5 – 16: With stepped shank Ø 12.7 mm.

Technical description

Standard	DIN 338
Nominal Ø D _c	6.8 mm
recommended maximum drilling depth L ₂	58.8 mm
Feed f in steel < 750 N/mm ²	0.07 mm/rev.
Overall length L	109 mm
Flute length L _c	69 mm

Number of cutting edges Z	2
Point angle	118 degrees
Tolerance nominal \varnothing	h8
Shank $\varnothing D_s$	6.8 mm
Shank	Plain shank
Contents	20
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 only under restricted conditions	80 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	60 m/min	N
Alu > 10% Si	suitable only under restricted conditions	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 only under restricted conditions	18 m/min	P
GG(G)	suitable only under restricted conditions	30 m/min	K
CuZn	suitable	40 m/min	N

Oil	suitable
wet maximum	suitable

Accessories

HOLEX CleverDrill HSS jobber drillN Ø DC h8 (mm or inch) 6,8	114031 6,8
HOLEX CleverDrill jobber drill set HSS No. 114031 in a case Type 1-10,5	115051 1-10,5
HOLEX CleverDrill jobber drill set HSS No. 114031 in a case Type 1-13	115051 1-13
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 1-10,5	115056 1-10,5
HOLEX CleverDrill HSS jobber drill set No. 114031 as a refill set Type 1-13	115056 1-13
HOLEX CleverDrill HSS jobber drill set No. 114031 as a refill set Type 6-10	115056 6-10