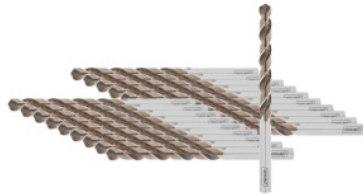


**HOLEX CleverDrill HSS jobber drill N, uncoated, Ø DC h8: 13mm****Order data**

Order number	GG4031 13
GTIN	4067263101994
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**

Flute length $L_c$	101 mm
Tolerance nominal Ø	h8
Point angle	118 degrees
Shank	Plain shank
recommended maximum drilling depth $L_2$	81.5 mm
Shank Ø $D_s$	13 mm

Nominal $\varnothing D_c$	13 mm
Number of cutting edges Z	2
Standard	DIN 338
Feed f in steel < 750 N/mm <sup>2</sup>	0.16 mm/rev.
Overall length L	151 mm
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 <sub>c</sub>	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 <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 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

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## Accessories

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