


HOLEX CleverDrill HSS jobber drill N, uncoated, Ø DC h8 (mm or inch): 1,9

Order data

Order number	114030 1,9
GTIN	4045197850355
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 for No. 114050 and No. 114160.

Size 13.2 – 20: With stepped shank Ø 12.7 mm.

Through-coolant: no

Standard: DIN 338

Tolerance nominal Ø: h8

Point angle: 130 °

Number of cutting edges Z: 2

recommended maximum drilling depth L_2 : 19.2 mm

Flute length L_c : 22 mm

Overall length L: 46 mm

Shank Ø D_s : 1.9 mm

Feed f in steel < 750 N/mm²: 0.03 mm/rev.

Technical description

Tolerance nominal Ø	h8
Number of cutting edges Z	2
Feed f in steel < 750 N/mm ²	0.03 mm/rev.

Data sheet

Shank Ø D _s	1.9 mm
recommended maximum drilling depth L ₂	19.2 mm
Nominal Ø D _c	1.9 mm
Standard	DIN 338
Overall length L	46 mm
Flute length L _c	22 mm
Point angle	130 °
Series	HOLEX CleverDrill
Coating	uncoated
Tool material	HSS
Type	N
Shank	Plain shank
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

Data sheet

CuZn	suitable	40 m/min	N
Oil	suitable		
wet maximum	suitable		