



## HOLEX CleverDrill HSS jobber drill N, uncoated, Ø DC h8 (mm or inch): 6,8



### Order data

|              |               |
|--------------|---------------|
| Order number | 114030 6,8    |
| GTIN         | 4045197850904 |
| 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  $L_2$ : 58.8 mm

Flute length  $L_c$ : 69 mm

Overall length L: 109 mm

Shank Ø  $D_s$ : 6.8 mm

Feed f in steel < 750 N/mm<sup>2</sup>: 0.07 mm/rev.

### Technical description

|                  |         |
|------------------|---------|
| Standard         | DIN 338 |
| Shank Ø $D_s$    | 6.8 mm  |
| Overall length L | 109 mm  |

|  |                   |
|--|-------------------|
| Number of cutting edges Z                | 2                 |
| Flute length $L_c$                       | 69 mm             |
| Nominal $\varnothing D_c$                | 6.8 mm            |
| Tolerance nominal $\varnothing$          | h8                |
| recommended maximum drilling depth $L_2$ | 58.8 mm           |
| Feed f in steel < 750 N/mm <sup>2</sup>  | 0.07 mm/rev.      |
| 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 <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        |

## Data sheet

|             |   |          |   |
|-------------|---|----------|---|
| GG(G)       | suitable only under restricted conditions | 30 m/min | K |
| CuZn        | suitable                                  | 40 m/min | N |
| Oil         | suitable                                  |          |   |
| wet maximum | suitable                                  |          |   |