



## HOLEX CleverDrill HSS jobber drill N, uncoated, Ø DC h8 (mm or inch): 7,7



### Order data

Order number	114030 7,7
GTIN	4045197851000
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  $L_2$ : 63.5 mm

Flute length  $L_c$ : 75 mm

Overall length L: 117 mm

Shank Ø  $D_s$ : 7.7 mm

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

### Technical description

Overall length L	117 mm
recommended maximum drilling depth $L_2$	63.5 mm
Number of cutting edges Z	2

Shank $\varnothing D_s$	7.7 mm
Feed f in steel < 750 N/mm <sup>2</sup>	0.07 mm/rev.
Flute length $L_c$	75 mm
Nominal $\varnothing D_c$	7.7 mm
Standard	DIN 338
Tolerance nominal $\varnothing$	h8
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		