



## HOLEX CleverDrill HSS jobber drill N, uncoated, Ø DC h8 (mm or inch): 10,8



### Order data

|              |               |
|--------------|---------------|
| Order number | 114030 10,8   |
| GTIN         | 4045197851321 |
| 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  $L_2$ : 77.8 mm

Flute length  $L_c$ : 94 mm

Overall length L: 142 mm

Shank Ø  $D_s$ : 10.8 mm

Feed f in steel < 750 N/mm<sup>2</sup>: 0.1 mm/rev.

### Technical description

|  |             |
|--|-------------|
| Number of cutting edges Z                | 2           |
| Feed f in steel < 750 N/mm <sup>2</sup>  | 0.1 mm/rev. |
| recommended maximum drilling depth $L_2$ | 77.8 mm     |

## Data sheet

|                                 |                   |
|---------------------------------|-------------------|
| Shank $\varnothing D_s$         | 10.8 mm           |
| Tolerance nominal $\varnothing$ | h8                |
| Nominal $\varnothing D_c$       | 10.8 mm           |
| Overall length L                | 142 mm            |
| Standard                        | DIN 338           |
| Flute length $L_c$              | 94 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 <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        |

## Data sheet

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