



HOLEX CleverDrill HSS jobber drill N, uncoated, Ø DC h8 (mm or inch): 15,75



Order data

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|--------------|---------------|
| Order number | 114030 15,75 |
| GTIN | 4045197851581 |
| 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 : 96.4 mm

Flute length L_c : 120 mm

Overall length L: 178 mm

Shank Ø D_s : 12.7 mm

Feed f in steel < 750 N/mm²: 0.16 mm/rev.

Technical description

| | |
|---|--------------|
| Overall length L | 178 mm |
| Feed f in steel < 750 N/mm ² | 0.16 mm/rev. |
| Number of cutting edges Z | 2 |

Data sheet

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|--|-------------------|
| Standard | DIN 338 |
| Tolerance nominal \varnothing | h8 |
| Flute length L_c | 120 mm |
| Shank $\varnothing D_s$ | 12.7 mm |
| recommended maximum drilling depth L_2 | 96.4 mm |
| Nominal $\varnothing D_c$ | 15.75 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 | | |