



HOLEX CleverDrill HSS jobber drill N, uncoated, Ø DC h8 (mm or inch): 18,5



Order data

Order number	114030 18,5
GTIN	4045197851642
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 : 107.3 mm

Flute length L_c : 135 mm

Overall length L: 198 mm

Shank Ø D_s : 12.7 mm

Feed f in steel < 750 N/mm²: 0.2 mm/rev.

Technical description

Standard	DIN 338
Nominal Ø D_c	18.5 mm
recommended maximum drilling depth L_2	107.3 mm

Data sheet

Flute length L_c	135 mm
Overall length L	198 mm
Shank $\varnothing D_s$	12.7 mm
Number of cutting edges Z	2
Feed f in steel $< 750 \text{ N/mm}^2$	0.2 mm/rev.
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 $> 10\% \text{ Si}$	suitable only under restricted conditions	50 m/min	N
Steel $< 500 \text{ N/mm}^2$	suitable	35 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	32 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	22 m/min	P
Steel $< 1100 \text{ N/mm}^2$	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		