

**HOLEX CleverDrill HSS jobber drill N, uncoated, Ø DC h8 (mm or inch): 19,5****Order data**

Order number	114031 19,5
GTIN	4062406744984
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 to No. 114030.**

Size 13.2 – 20: With stepped shank Ø 12.7 mm.

Through-coolant: no

Standard: DIN 338

Tolerance nominal Ø: h8

Point angle: 118 °

Shank: Plain shank

Number of cutting edges Z: 2

recommended maximum drilling depth L_2 : 110.8 mm

Flute length L_c : 140 mm

Overall length L: 205 mm

Shank Ø D_s : 12.7 mm

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

Technical description

Tolerance nominal Ø	h8
Number of cutting edges Z	2

Flute length L_c	140 mm
Feed f in steel $< 750 \text{ N/mm}^2$	0.2 mm/rev.
Point angle	118 °
Nominal $\varnothing D_c$	19.5 mm
recommended maximum drilling depth L_2	110.8 mm
Shank $\varnothing D_s$	12.7 mm
Standard	DIN 338
Overall length L	205 mm
Shank	Plain shank
Series	CleverDrill
Coating	uncoated
Tool material	HSS
Type	N
Through-coolant	no
Colour ring	without
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Alu plastics	suitable	80 m/min	N
Aluminium (short chipping)	suitable	60 m/min	N
Alu $> 10\% \text{ Si}$	suitable	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	18 m/min	P
GG(G)	suitable	30 m/min	K
CuZn	suitable	40 m/min	N

Oil	suitable
wet maximum	suitable