


**HOLEX CleverDrill HSS jobber drill, long N, uncoated, Ø DC h8: 3,9mm**

**Order data**

Order number	116051 3,9
GTIN	4062406745189
Item class	12B

**Description**
**Version:**

**HOLEX CleverDrill** – Sturdy drill 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:**

Suitable NC spotting drills No. 112120, 112140 and 112170 with **142° tip angle** for enhanced process reliability

**Successor product to No. 116050.**

**Technical description**

Number of cutting edges Z	2
Flute length $L_c$	78 mm
Shank Ø $D_s$	3.9 mm
Tolerance nominal Ø	h8
Overall length L	119 mm
Feed f in steel < 750 N/mm <sup>2</sup>	0.02 mm/rev.
Nominal Ø $D_c$	3.9 mm
Standard	DIN 340
recommended maximum drilling depth $L_2$	72.2 mm

Point angle	118 degrees
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 <sub>c</sub>	ISO code
Alu plastics	suitable	64 m/min	N
Aluminium (short chipping)	suitable	52 m/min	N
Alu > 10% Si	suitable	40 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	26 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	26 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	20 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	15 m/min	P
GG(G)	suitable	24 m/min	K
CuZn	suitable	32 m/min	N
Oil	suitable		
wet maximum	suitable		