


HOLEX CleverDrill HSS jobber drill, long N, uncoated, Ø DC h8: 8,5mm

Order data

Order number	116051 8,5
GTIN	4062406745387
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

Point angle	118 degrees
recommended maximum drilling depth L_2	96.3 mm
Overall length L	165 mm
Flute length L_c	109 mm
Standard	DIN 340
Number of cutting edges Z	2
Shank $\varnothing D_s$	8.5 mm
Feed f in steel < 750 N/mm ²	0.07 mm/rev.
Tolerance nominal \varnothing	h8

Nominal $\varnothing D_c$	8.5 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	64 m/min	N
Aluminium (short chipping)	suitable	52 m/min	N
Alu > 10% Si	suitable	40 m/min	N
Steel < 500 N/mm ²	suitable	26 m/min	P
Steel < 750 N/mm ²	suitable	26 m/min	P
Steel < 900 N/mm ²	suitable	20 m/min	P
Steel < 1100 N/mm ²	suitable	15 m/min	P
GG(G)	suitable	24 m/min	K
CuZn	suitable	32 m/min	N
Oil	suitable		
wet maximum	suitable		