



## HOLEX CleverDrill HSS jobber drill, long N, uncoated, Ø DC h8: 15mm



### Order data

Order number	116051 15
GTIN	4062406745509
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

Tolerance nominal Ø	h8
Number of cutting edges Z	2
Overall length L	220 mm
Shank Ø D <sub>s</sub>	15 mm
Nominal Ø D <sub>c</sub>	15 mm
Standard	DIN 340
Flute length L <sub>c</sub>	144 mm
recommended maximum drilling depth L <sub>2</sub>	121.5 mm
Feed f in steel < 750 N/mm <sup>2</sup>	0.11 mm/rev.

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		