



## HOLEX Pro Steel solid carbide roughing end mill HPC, TiAlN, Ø DC: 18mm



### Order data

Order number	203052 18
GTIN	4045197712851
Item class	12X

### Description

#### Version:

For **roughing and finishing**.

Up to 1×D into solid material **at very high feed rates** with smooth cutting action.

At maximum machining depths, ensure compliance with the ratio dimension  $L_c$  (cutting length) /  $\varnothing D_c$  (cutting  $\varnothing$ )!

#### Advantage:

Optimised flute form, eccentric relief ground, wide chip space.

### Technical description

Feed $f_z$ for slot milling in steel < 900 N/mm <sup>2</sup>	0.1 mm
Feed $f_z$ for side milling in steel < 900 N/mm <sup>2</sup>	0.13 mm
Corner chamfer width at 45°	0.4 mm
No. of teeth Z	4
Cutting edge $\varnothing D_c$	18 mm
Shank $\varnothing D_s$	18 mm
Overall length L	84 mm
Flute length $L_c$	24 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HB to h6
Tolerance nominal $\varnothing$	0 / -0.03

Helix angle	38 degrees
Corner chamfer angle	45 degrees
Series	Pro Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width $a_e$ for milling operation	0.5×D for side milling
Cutting width $a_e$ for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Machining strategy	HPC
Colour ring	green
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	260 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	240 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	180 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	160 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	80 m/min	M
GG(G)	suitable	250 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		

dry	suitable
Air	suitable