



## HOLEX Pro INOX solid carbide milling cutter with through-coolant HPC, AlCrN, Ø f8 DC: 4mm



### Order data

Order number	203027 4
GTIN	4062406094591
Item class	12X

### Description

#### Version:

HPC milling cutters with **newly developed high-performance coating** for **outstanding tool working life** and **optimum metal removal rates** in a wide range of stainless steels. For use at **high cutting speeds**, particularly suitable even for steels up to approx. 1100 N/mm<sup>2</sup>. With **internal coolant supply** for reliable swarf evacuation.

### Technical description

No. of teeth Z	4
Tolerance nominal Ø	f8
Helix angle	35 degrees
Corner chamfer width at 45°	0.1 mm
Cutting edge Ø D <sub>c</sub>	4 mm
Recess Ø D <sub>1</sub>	3.8 mm
Overall length L	57 mm
Feed f <sub>z</sub> for side milling in INOX > 900 N/mm <sup>2</sup>	0.015 mm
Shank Ø D <sub>s</sub>	6 mm
Feed f <sub>z</sub> for slot milling in stainless steel > 900 N/mm <sup>2</sup>	0.012 mm
Overhang length L <sub>1</sub> incl. recess	17 mm
Shank	DIN 6535 HB to h6

Flute length $L_c$	11 mm
Direction of infeed	horizontal, oblique and vertical
Corner chamfer angle	45 degrees
Series	Pro Inox
Coating	AlCrN
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	0.4×D for side milling
Cutting width $a_e$ for milling operation	Full slot cutting depth 1×D
Through-coolant	yes
Machining strategy	HPC
Colour ring	blue
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Steel < 500 N/mm <sup>2</sup>	Suitable	240 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	220 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	180 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	180 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	150 m/min	P
TOOLOX 33	Suitable only under restricted conditions	115 m/min	H
TOOLOX 44	suitable only under restricted conditions	80 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	100 m/min	M

INOX > 900 N/mm <sup>2</sup>	suitable	85 m/min	M
Uni	suitable only under restricted conditions		
wet maximum	suitable		
Air	suitable		