

HOLEX
**HOLEX Pro Steel high-precision countersink with unequal spacing 90°, TiAlN,
External Ø Dc: 25mm**

Order data

Order number	150182 25
GTIN	4062406524326
Item class	12M

Description
Version:

All countersinks have 3 cutting edges, radially relieved.

Flutes are ground from solid.

HOLEX Pro Steel:

- **Exact machining results in manual and machine use.**
- **Chatter-free running through extremely unequal spacing of the cutting edges for high-quality surfaces.**
- **Optimum tool life thanks to TiAlN high-performance coating.**
- **High process reliability due to optimised chip evacuation.**
- **Attractive cost/benefit ratio.**

Application:

High precision countersinks for chatter-free countersinking.

Technical description

Shank Ø D _s	10 mm
Overall length L	67 mm
smallest countersink Ø for holes from	3.8 mm
Number of cutting edges Z	3
External Ø	25 mm
Shank tolerance	h9

Feed f in steel < 500 N/mm ²	0.2 mm/rev.
for countersunk screws DIN 7991	M12
Coating	TiAlN
Countersink tip angle	90 degrees
Tool material	HSS
Spacing of the countersink cutting edges	unequal spacing
Standard	DIN 335 C
Shank	Plain shank with h9
Through-coolant	no
Colour ring	green
Series	Pro Steel
Type of product	Stepped drill and countersink

User data

	Suitability	V _c	ISO code
Alu plastics	suitable	75 m/min	N
Aluminium (short chipping)	suitable	70 m/min	N
Steel < 750 N/mm ²	suitable	50 m/min	P
Steel < 900 N/mm ²	suitable	40 m/min	P
Steel < 1100 N/mm ²	suitable	20 m/min	P
Steel < 1400 N/mm ²	suitable	15 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	8 m/min	H
INOX < 900 N/mm ²	suitable	18 m/min	M
INOX > 900 N/mm ²	suitable	15 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	12 m/min	S
GG(G)	suitable	20 m/min	K
CuZn	suitable	20 m/min	N

Uni	suitable
wet maximum	suitable
dry	suitable only under restricted conditions

Accessories

HOLEX Pro Steel countersink set No. 150182 in a case90°
Number of countersinks 7

150342 7