



## HOLEX Pro Steel high-precision countersink with unequal spacing 90°, TiAlN, External Ø Dc: 8,3mm



### Order data

Order number	150182 8,3
GTIN	4062406524227
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

smallest countersink Ø for holes from	2 mm
External Ø	8.3 mm
Shank Ø D <sub>s</sub>	6 mm
Overall length L	50 mm
for countersunk screws DIN 7991	M4
Number of cutting edges Z	3

Shank tolerance	h9
Feed f in steel < 500 N/mm <sup>2</sup>	0.09 mm/rev.
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 <sub>c</sub>	ISO code
Alu plastics	suitable	75 m/min	N
Aluminium (short chipping)	suitable	70 m/min	N
Steel < 750 N/mm <sup>2</sup>	suitable	50 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	40 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	20 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	15 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	8 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	18 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	15 m/min	M
Ti > 850 N/mm <sup>2</sup>	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