

HOLEX

HOLEX Pro Steel high-precision countersink with unequal spacing and 3 drive flats 90°, TiAlN, External Ø Dc: 31 mm



Order data

| | |
|--------------|---------------|
| Order number | 150184 31 |
| GTIN | 4062406524500 |
| 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.

Three drive flats on the shank for use in a 3-jaw chuck.

Application:

High precision countersinks for chatter-free countersinking.

Technical description

| | |
|---------------------------------|-------|
| for countersunk screws DIN 7991 | M16 |
| Shank tolerance | h9 |
| Overall length L | 71 mm |
| Shank Ø D _s | 12 mm |
| Number of cutting edges Z | 3 |

| | |
|------------------------------------------|-------------------------------|
| Feed f in steel < 500 N/mm ² | 0.2 mm/rev. |
| External Ø | 31 mm |
| smallest countersink Ø for holes from | 4.2 mm |
| Coating | TiAlN |
| Countersink tip angle | 90 degrees |
| Tool material | HSS |
| Spacing of the countersink cutting edges | unequal spacing |
| Standard | DIN 335 C |
| Shank | Three clamping flats to 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 | | |