

**HOLEX**
**HOLEX Pro Steel high-precision countersink with unequal spacing and 3 drive flats 90°, TiAlN, External Ø Dc: 6,3mm**

**Order data**

Order number	150184 6,3
GTIN	4062406524371
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**

Number of cutting edges Z	3
Feed f in steel < 500 N/mm <sup>2</sup>	0.09 mm/rev.
External Ø	6.3 mm
for countersunk screws DIN 7991	M3
smallest countersink Ø for holes from	1.5 mm

Shank tolerance	h9
Shank $\varnothing D_s$	5 mm
Overall length L	45 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 <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		