



HOLEX Pro Steel high-precision countersink with unequal spacing and 3 drive flats 90°, TiAlN, External Ø Dc: 12,4mm



Order data

Order number	150184 12,4
GTIN	4062406524432
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

Overall length L	56 mm
Shank tolerance	h9
External Ø	12.4 mm
smallest countersink Ø for holes from	2.8 mm
Shank Ø D _s	8 mm

Number of cutting edges Z	3
for countersunk screws DIN 7991	M6
Feed f in steel < 500 N/mm ²	0.12 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	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		