


HOLEX Pro UNI solid carbide milling cutter HPC, TiSiN, Ø e8 DC: 4mm

Order data

Order number	203068 4
GTIN	4062406569099
Item class	12Y

Description
Version:

For **roughing and finishing at very high feed rates** with smooth cutting action. **Newly developed geometry and high-performance coating** for excellent production results with maximum tool life in various materials. **High intrinsic stability** and smooth cutting action due to unequal spacing.

Technical description

Helix angle	42 degrees
Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.025 mm
Overall length L	57 mm
Shank $\varnothing D_s$	6 mm
No. of teeth Z	4
Corner chamfer width at 45°	0.08 mm
Tolerance nominal \varnothing	e8
Corner chamfer angle	45 degrees
Cutting edge $\varnothing D_c$	4 mm
Overhang length L_1 incl. recess	17 mm
Flute length L_c	11 mm
Shank	DIN 6535 HB to h6

Feed f_z for side milling in INOX > 900 N/mm ²	0.015 mm
Direction of infeed	horizontal, oblique and vertical
Feed f_z for slot milling in stainless steel > 900 N/mm ²	0.012 mm
Feed f_z for slot milling in steel < 900 N/mm ²	0.02 mm
Recess $\varnothing D_1$	3.8 mm
Series	Pro Uni
Coating	TiSiN
Tool material	solid carbide
Standard	Manufacturer's standard
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	Full slot cutting depth 1×D
Cutting width a_e for milling operation	0.3×D for side milling
Through-coolant	no
Machining strategy	MTC
Colour ring	green
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	250 m/min	N
Steel < 500 N/mm ²	suitable	240 m/min	P
Steel < 750 N/mm ²	suitable	220 m/min	P
Steel < 900 N/mm ²	suitable	180 m/min	P
Steel < 1100 N/mm ²	suitable	170 m/min	P
Steel < 1400 N/mm ²	suitable	140 m/min	P
INOX < 900 N/mm ²	suitable	90 m/min	M

INOX > 900 N/mm ²	suitable	80 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	35 m/min	S
GG(G)	suitable	240 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		