


HOLEX Pro UNI solid carbide torus cutter, TiSiN, Ø DC / R1: 6/1,0mm

Order data

Order number	206368 6/1,0
GTIN	4067263047155
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 outstanding production results and very long tool life with a variety of materials. Unequal spacing gives **high intrinsic stability** and smooth cutting action. Tolerance: corner radius $R_1 = \pm 0.005 \text{ mm}$.

Dimensions similar to **DIN 6527**.

Technical description

Shank	DIN 6535 HB to h6
Corner radius R_1	1 mm
Cutting edge $\varnothing D_c$	6 mm
Shank $\varnothing D_s$	6 mm
Helix angle	42 degrees
Feed f_z for copy milling in stainless steel $> 900 \text{ N/mm}^2$	0.04 mm
Feed f_z for copy milling in steel $< 900 \text{ N/mm}^2$	0.058 mm
Overhang length L_1 incl. recess	19 mm
Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.05 mm
No. of teeth Z	4
Flute length L_c	13 mm

Recess $\varnothing D_1$	5.8 mm
Feed f_z for side milling in INOX $> 900 \text{ N/mm}^2$	0.035 mm
Overall length L	57 mm
Series	Pro Uni
Coating	TiSiN
Tool material	Solid carbide
Standard	Works standard
Type	N
Tolerance nominal \varnothing	e8
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	$0.3 \times D$ for side milling
Cutting width a_e for milling operation	$0.3 \times D$ for side milling
Cutting width a_e for milling operation	$0.05 \times D$ for copy milling
Through-coolant	no
Machining strategy	HPC
Type of product	Torus cutter

User data

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

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