


HOLEX Pro UNI solid carbide torus cutter, TiSiN, Ø DC / R1: 6/0,5mm

Order data

Order number	206368 6/0,5
GTIN	4067263047148
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

Cutting edge Ø D _c	6 mm
Helix angle	42 degrees
No. of teeth Z	4
Feed f _z for copy milling in steel < 900 N/mm ²	0.058 mm
Overhang length L ₁ incl. recess	19 mm
Feed f _z for side milling in INOX > 900 N/mm ²	0.035 mm
Feed f _z for copy milling in stainless steel > 900 N/mm ²	0.04 mm
Feed f _z for side milling in steel < 900 N/mm ²	0.05 mm
Flute length L _c	13 mm
Shank Ø D _s	6 mm
Recess Ø D ₁	5.8 mm

Shank	DIN 6535 HB to h6
Overall length L	57 mm
Corner radius R ₁	0.5 mm
Series	Pro Uni
Coating	TiSiN
Tool material	Solid carbide
Standard	Works standard
Type	N
Tolerance nominal Ø	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×D for side milling
Cutting width a _e for milling operation	0.3×D for side milling
Cutting width a _e for milling operation	0.05×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 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	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		