


HOLEX Pro INOX M solid carbide torus cutter HPC, TiSiN, Ø DC / R1: 4/1,0mm

Order data

Order number	206344 4/1,0
GTIN	4067263046769
Item class	12Y

Description
Version:

Outstanding tool life in its class for machining **corrosion-resistant steels** thanks to **innovative coating and geometry**. Especially for **stainless steels in the high-performance range**, e.g. duplex. **Optimal metal removal rate** due to **high cutting speeds**. Tolerance: corner radius $R_1 = \pm 0.005$ mm. Dimensions similar to DIN 6527.

Technical description

Recess Ø D_1	3.8 mm
Feed f_z for copy milling in stainless steel > 900 N/mm ²	0.019 mm
No. of teeth Z	4
Cutting edge Ø D_c	4 mm
Shank Ø D_s	6 mm
Shank	DIN 6535 HB to h6
Helix angle	38 degrees
Feed f_z for side milling in INOX > 900 N/mm ²	0.015 mm
Corner radius R_1	1 mm
Flute length L_c	11 mm
Overall length L	57 mm
Overhang length L_1 incl. recess	17 mm

Series	Pro Inox
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×D for side milling
Cutting width a_e for milling operation	0.05×D for copy milling
Through-coolant	no
Machining strategy	HPC
Shank tolerance	h6
Type of product	Torus cutter

User data

	Suitability	V_c	ISO code
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	180 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	150 m/min	P
TOOLOX 33	suitable only under restricted conditions	115 m/min	H
TOOLOX 44	suitable only under restricted conditions	80 m/min	H
INOX < 900 N/mm ²	suitable	100 m/min	M
INOX > 900 N/mm ²	suitable	85 m/min	M

Uni	suitable only under restricted conditions
wet maximum	suitable
wet minimum	suitable
dry	suitable only under restricted conditions
Air	suitable only under restricted conditions