


**HOLEX Pro INOX M solid carbide torus cutter HPC, TiSiN, Ø DC / R1: 12/1,0mm**

**Order data**

Order number	206344 12/1,0
GTIN	4067263047391
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**

Feed $f_z$ for copy milling in stainless steel $> 900$ N/mm <sup>2</sup>	0.072 mm
Corner radius $R_1$	1 mm
Helix angle	38 degrees
Recess $\varnothing D_1$	11.6 mm
No. of teeth $Z$	4
Overhang length $L_1$ incl. recess	36 mm
Flute length $L_c$	26 mm
Cutting edge $\varnothing D_c$	12 mm
Shank	DIN 6535 HB to h6
Overall length $L$	83 mm
Shank $\varnothing D_s$	12 mm
Feed $f_z$ for side milling in INOX $> 900$ N/mm <sup>2</sup>	0.06 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 <sup>2</sup>	suitable	240 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	220 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	180 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	180 m/min	P
Steel < 1400 N/mm <sup>2</sup>	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 <sup>2</sup>	suitable	100 m/min	M
INOX > 900 N/mm <sup>2</sup>	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