



## HOLEX Pro UNI solid carbide roughing end mill HPC, TiSiN, Ø e8 DC: 12mm



### Order data

Order number	203074 12
GTIN	4067263092087
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

Overall length L	93 mm
Feed $f_z$ for slot milling in stainless steel $> 900 \text{ N/mm}^2$	0.035 mm
Feed $f_z$ for slot milling in steel $< 900 \text{ N/mm}^2$	0.06 mm
Feed $f_z$ for side milling in INOX $> 900 \text{ N/mm}^2$	0.04 mm
Shank	DIN 6535 HB to h6
Corner chamfer width at $45^\circ$	0.3 mm
Recess $\varnothing D_1$	11.6 mm
Overhang length $L_1$ incl. recess	46 mm
Helix angle	42 degrees
Shank $\varnothing D_s$	12 mm
Flute length $L_c$	36 mm
Tolerance nominal $\varnothing$	e8

No. of teeth Z	4
Corner chamfer angle	45 degrees
Direction of infeed	horizontal, oblique and vertical
Feed $f_z$ for side milling in steel < 900 N/mm <sup>2</sup>	0.08 mm
Cutting edge $\varnothing D_c$	12 mm
Series	Pro Uni
Coating	TiSiN
Tool material	Solid carbide
Standard	Works standard
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
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
Through-coolant	no
Machining strategy	HPC
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 <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	170 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	140 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	90 m/min	M

INOX > 900 N/mm <sup>2</sup>	suitable	80 m/min	M
Ti > 850 N/mm <sup>2</sup>	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		