


HOLEX Pro UNI solid carbide roughing end mill HPC, TiSiN, Ø e8 DC: 6mm

Order data

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|--------------|---------------|
| Order number | 203074 6 |
| GTIN | 4067263092056 |
| 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

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|--|----------------------------------|
| Overhang length L_1 incl. recess | 24 mm |
| No. of teeth Z | 4 |
| Feed f_z for side milling in steel < 900 N/mm ² | 0.04 mm |
| Feed f_z for slot milling in stainless steel > 900 N/mm ² | 0.02 mm |
| Corner chamfer angle | 45 degrees |
| Feed f_z for side milling in INOX > 900 N/mm ² | 0.025 mm |
| Cutting edge Ø D_c | 6 mm |
| Feed f_z for slot milling in steel < 900 N/mm ² | 0.03 mm |
| Recess Ø D_1 | 5.8 mm |
| Shank | DIN 6535 HB to h6 |
| Corner chamfer width at 45° | 0.1 mm |
| Direction of infeed | horizontal, oblique and vertical |

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|---|------------------------|
| Overall length L | 65 mm |
| Shank $\varnothing D_s$ | 6 mm |
| Flute length L_c | 18 mm |
| Tolerance nominal \varnothing | e8 |
| Helix angle | 42 degrees |
| 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 |
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| 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 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 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 | | |