



HOLEX Pro INOX solid carbide torus cutter HPC DIN 6535 HB, AlCrN, Ø DC / R1: 4/1,0mm



Order data

Order number	206348 4/1,0
GTIN	4045197859662
Item class	12X

Description

Version:

Dimensions similar to DIN 6527.

HPC milling cutter with **newly developed high-performance coating**.

For **outstanding tool life** and **optimum metal removal rate** in a very wide range of stainless steels.

For use at **high cutting speeds**, particularly suitable even for steels up to approx. 1100 N/mm².

Technical description

Recess Ø D ₁	3.8 mm
Overall length L	57 mm
Feed f _z for side milling in INOX > 900 N/mm ²	0.025 mm
Corner radius R ₁	1 mm
Flute length L _c	11 mm
Shank	DIN 6535 HB to h6
Cutting edge Ø D _c	4 mm
No. of teeth Z	4
Overhang length L ₁ incl. recess	17 mm
Shank Ø D _s	6 mm
Helix angle	35 degrees

Feed f_z for slot milling in stainless steel $> 900 \text{ N/mm}^2$	0.02 mm
Series	Pro Inox
Coating	AlCrN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Tolerance nominal \varnothing	f8
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	$0.3 \times D$ for side milling
Cutting width a_e for milling operation	$0.05 \times D$ for side milling
Through-coolant	no
Machining strategy	HPC
Shank tolerance	h6
Colour ring	blue
Type of product	Torus cutter

User data

	Suitability	V_c	ISO code
Steel $< 500 \text{ N/mm}^2$	suitable	240 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	220 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	180 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	180 m/min	P
Steel $< 1400 \text{ N/mm}^2$	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 only under restricted conditions		
dry	Suitable only under restricted conditions		
Air	Suitable only under restricted conditions		