HOLEX

HOLEX Pro INOX solid carbide torus cutter HPC DIN 6535 HB, AlCrN, ⌀ DC / R1: 8/1,5mm

Order data

Order number	206348 8/1,5
GTIN	4045197859747
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/mm^2.

Technical description

Feed f_z for side milling in INOX > 900 N/mm^2	0.043 mm
Flute length L_c	21 mm
Corner radius R_1	1.5 mm
Recess ⌀ D_1	7.7 mm
Shank	DIN 6535 HB to h6
Overhang length L_1 incl. recess	25 mm
Cutting edge ⌀ D_C	8 mm
No. of teeth Z	4
Shank ⌀ D_s	8 mm
Overall length L	63 mm
Helix angle	35 degrees

Feed f_z for slot milling in stainless steel > 900 N/mm²	0.035 mm
Series	Pro Inox
Coating	AlCrN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Tolerance nominal ∅	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×D for side milling
Cutting width a_e for milling operation	0.05×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 N/mm²	suitable	240 m/min	P
Steel < 750 N/mm²	suitable	220 m/min	P
Steel < 900 N/mm²	suitable	180 m/min	P
Steel < 1100 N/mm²	suitable	180 m/min	P
Steel < 1400 N/mm²	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/mm²	suitable	100 m/min	M
INOX > 900 N/mm²	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		