

**HOLEX**
**HOLEX Pro INOX solid carbide torus cutter HPC DIN 6535 HB, AlCrN, Ø DC / R1: 8/2,5mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 206348 8/2,5  |
| GTIN         | 4045197859761 |
| 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<sup>2</sup>.

**Technical description**

|  |                   |
|--|-------------------|
| Overhang length L <sub>1</sub> incl. recess                          | 25 mm             |
| Shank Ø D <sub>s</sub>   | 8 mm              |
| Flute length L <sub>c</sub>  | 21 mm             |
| Shank  | DIN 6535 HB to h6 |
| Cutting edge Ø D <sub>c</sub>  | 8 mm              |
| Corner radius R <sub>1</sub>   | 2.5 mm            |
| Recess Ø D <sub>1</sub>  | 7.7 mm            |
| Overall length L   | 63 mm             |
| Feed f <sub>z</sub> for side milling in INOX > 900 N/mm <sup>2</sup> | 0.043 mm          |
| No. of teeth Z   | 4                 |
| Helix angle  | 35 degrees        |

|   |                                  |
|---|----------------------------------|
| Feed $f_z$ for slot milling in stainless steel $> 900 \text{ N/mm}^2$ | 0.035 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 <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 only under restricted conditions |           |   |
| dry                          | Suitable only under restricted conditions |           |   |
| Air                          | Suitable only under restricted conditions |           |   |