

**HOLEX**
**HOLEX Pro INOX solid carbide torus cutter HPC DIN 6535 HB, AlCrN, Ø DC / R1: 12/1,5mm**

**Order data**

Order number	206348 12/1,5
GTIN	4045197859860
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**

Flute length L <sub>c</sub>	26 mm
Feed f <sub>z</sub> for side milling in INOX > 900 N/mm <sup>2</sup>	0.062 mm
Overall length L	83 mm
Corner radius R <sub>1</sub>	1.5 mm
Shank	DIN 6535 HB to h6
No. of teeth Z	4
Cutting edge Ø D <sub>c</sub>	12 mm
Recess Ø D <sub>1</sub>	11.6 mm
Overhang length L <sub>1</sub> incl. recess	36 mm
Shank Ø D <sub>s</sub>	12 mm
Helix angle	35 degrees

Feed $f_z$ for slot milling in stainless steel $> 900 \text{ N/mm}^2$	0.05 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		