


HOLEX Pro UNI solid carbide roughing end mill HPC, TiSiN, Ø e8 DC: 3mm

Order data

Order number	203068 3
GTIN	4062406569082
Item class	12Y

Description
Version:

For **roughing and finishing** up to $1.5 \times D$ into solid material **at very high feed rates** with smooth cutting action.

For cutting force reduction and better surface quality due to **45° helix**.

Tolerance nominal Ø: e8

No. of teeth Z: 4

Helix angle: 42 °

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HB to h6

No. of teeth Z: 4

Flute length L_c : 8 mm

Overhang length L_1 incl. recess: 13 mm

Recess Ø D_1 : 2.8 mm

Overall length L: 57 mm

Shank Ø D_s : 6 mm

Technical description

Flute length L_c	8 mm
Shank Ø D_s	6 mm
Feed f_z for side milling in steel < 900 N/mm ²	0.025 mm
Recess Ø D_1	2.8 mm
Direction of infeed	horizontal, oblique and vertical
Overall length L	57 mm

Tolerance nominal \varnothing	e8
Helix angle	42°
Cutting edge $\varnothing D_c$	3 mm
Corner chamfer width at 45°	0.06 mm
Shank	DIN 6535 HB to h6
No. of teeth Z	4
Feed f_z for side milling in INOX > 900 N/mm ²	0.015 mm
Corner chamfer angle	45°
Overhang length L_1 incl. recess	13 mm
Feed f_z for slot milling in stainless steel > 900 N/mm ²	0.012 mm
Feed f_z for slot milling in steel < 900 N/mm ²	0.02 mm
Coating	TiSiN
Tool material	solid carbide
Standard	Manufacturer's standard
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	Full slot cutting depth 1xD
Cutting width a_e for milling operation	0.3xD for side milling
Through-coolant	no
Machining strategy	MTC
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		