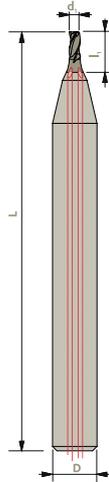


# 1520H

## End mill Z3 $l_1=2xd_1$ with internal coolant



not adapted - adapted  highly adapted



Material	Vc uncoated [m/min]	Vc coated [m/min]	Uncoated	Coated
Steel < 700 N/mm <sup>2</sup>	80	100	<input type="checkbox"/>	<input checked="" type="checkbox"/>
Steel > 700 N/mm <sup>2</sup>	60	80	<input type="checkbox"/>	<input checked="" type="checkbox"/>
Stainless steel	60	80	<input type="checkbox"/>	<input checked="" type="checkbox"/>
Cast iron	50	70	<input type="checkbox"/>	<input checked="" type="checkbox"/>
Copper	80	100	<input type="checkbox"/>	<input checked="" type="checkbox"/>
Brass - Bronze	120	150	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Aluminium	150	190	<input type="checkbox"/>	<input checked="" type="checkbox"/>
Gold - Silver	120	150	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Platinum - Palladium	-	55	-	<input type="checkbox"/>
Superalloys	-	40	-	<input checked="" type="checkbox"/>
Titanium	40	60	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>

Tolerances  $d_1 \leq 1 \text{ mm}$  ▶ 0/-0.01  $D: h5$  Oil pressure in bar: **minimum 20 bar**  
 $d_1 > 1 \text{ mm}$  ▶ 0/-0.02  $L: \pm 0.5$  Oil viscosity: **less than 20 mm<sup>2</sup>/s at 40°C**  
 $d_1 = D$  ▶  $d_1: e8$   $L_1: +0.1/0$  Filtration level: **maximum 0.02 mm**

Available uncoated or coated

**Z3**

**CARB**

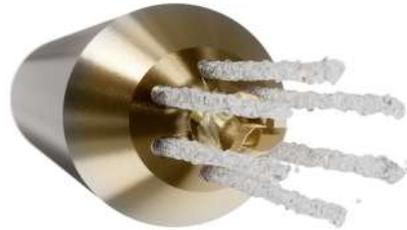
$\lambda$  30°  $\gamma$  8°

$ap$   $ap$

$ae$

Art. n°	$d_1$	$l_1$	D	L	Art. n°	$d_1$	$l_1$	D	L
1520Hd0.30	0.30	0.60	4	38	1520Hd1.90	1.90	3.80	6	50
1520Hd0.40	0.40	0.80	4	38	1520Hd2.00	2.00	4.00	6	50
1520Hd0.50	0.50	1.00	4	38	1520Hd2.10	2.10	4.20	6	50
1520Hd0.60	0.60	1.20	4	38	1520Hd2.20	2.20	4.40	6	50
1520Hd0.70	0.70	1.40	4	38	1520Hd2.30	2.30	4.60	6	50
1520Hd0.80	0.80	1.60	4	38	1520Hd2.40	2.40	4.80	6	50
1520Hd0.90	0.90	1.80	4	38	1520Hd2.50	2.50	5.00	6	50
1520Hd1.00	1.00	2.00	4	38	1520Hd2.60	2.60	5.20	6	50
1520Hd1.10	1.10	2.20	4	38	1520Hd2.70	2.70	5.40	6	50
1520Hd1.20	1.20	2.40	4	38	1520Hd2.80	2.80	5.60	6	50
1520Hd1.30	1.30	2.60	6	50	1520Hd2.90	2.90	5.80	6	50
1520Hd1.40	1.40	2.80	6	50	1520Hd3.00	3.00	6.00	6	50
1520Hd1.50	1.50	3.00	6	50	1520Hd4.00	4.00	8.00	6	50
1520Hd1.60	1.60	3.20	6	50	1520Hd5.00	5.00	10.00	6	50
1520Hd1.70	1.70	3.40	6	50	1520Hd6.00	6.00	12.00	6	50
1520Hd1.80	1.80	3.60	6	50					

$ap=0.25xd_1$   $ap= l_1 \text{ max.}$   
 $ae= \frac{d_1^2}{4xAp}$



Recommendations / coating	< Ø1	> Ø1
	Steel / Stainless Steel	BY
Copper alloys / Brass	DA	DA
Platinum / CFRP	DC	DC
Titanium	ME	ME

Upon request

