



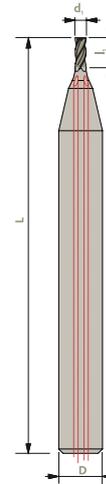
EXPERT end mill for stainless steel Z4 with internal coolant

1620H

not adapted - adapted highly adapted

Material	Vc uncoated [m/min]	Vc coated [m/min]	Uncoated	Coated
Steel < 700 N/mm ²	-	180	-	<input checked="" type="checkbox"/>
Steel > 700 N/mm ²	-	160	-	<input checked="" type="checkbox"/>
Stainless steel	-	200	-	<input checked="" type="checkbox"/>
Cast iron	-	200	-	<input checked="" type="checkbox"/>
Copper	-	250	-	<input checked="" type="checkbox"/>
Brass - Bronze	-	190	-	<input type="checkbox"/>
Aluminium	-	350	-	<input checked="" type="checkbox"/>
Gold - Silver	-	180	-	<input checked="" type="checkbox"/>
Platinum - Palladium	-	60	-	<input type="checkbox"/>
Superalloys	-	100	-	<input checked="" type="checkbox"/>
Titanium	60	100	<input type="checkbox"/>	<input checked="" type="checkbox"/>

Tolerances $d_1 \leq 1 \text{ mm} \rightarrow 0/-0.01$ $D: h5$ Oil pressure in bar: **minimum 20 bar**
 $d_1 > 1 \text{ mm} \rightarrow 0/-0.02$ $L: \pm 0.5$ Oil viscosity: **less than 20 mm²/s at 40°C**
 $d_1 = D \rightarrow d_1: e8$ $L_1: +0.1/0$ Filtration level: **maximum 0.02 mm**



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

Art. n°	d ₁	L ₁	J	D	L
1620Hd1.00	1.0	2	0.02	4	38
1620Hd1.50	1.5	3	0.02	6	50
1620Hd2.00	2.0	4	0.02	6	50
1620Hd2.50	2.5	5	0.02	6	50
1620Hd3.00	3.0	6	0.02	6	50
1620Hd3.50	3.5	7	0.03	6	50
1620Hd4.00	4.0	8	0.03	6	50
1620Hd5.00	5.0	10	0.04	6	50
1620Hd6.00	6.0	12	0.05	6	50
1620Hd8.00	8.0	16	0.05	8	61
1620Hd10.00	10.0	20	0.05	10	72
1620Hd12.00	12.0	24	0.05	12	83

Available uncoated or coated

Z4

CARB

λ 36-39° **Y** 8°

ap ae

$$ap = 0.25 \times d_1 \quad ap = L_1 \times \max \frac{d_1^2}{4 \times Ap}$$

$$ae = \frac{d_1^2}{4 \times Ap}$$



Upon request

