

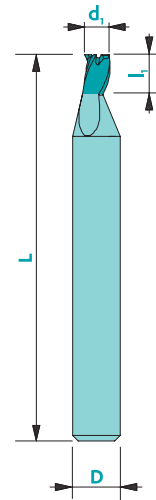
# End mill Z3 $l_1=1.5xd_1$

1515

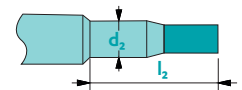
Material	Vc uncoated	Vc coated	Uncoated	Coated	Rec. Coating*
Steel < 700 N/mm <sup>2</sup>	100	130	□	■	Tisi (BQ)
Steel > 700 N/mm <sup>2</sup>	80	100	-	■	Tisi (BQ)
Stainless steel	50	70	□	■	Tisi (BQ)
Cast iron	60	100	□	■	Tisi (BQ)
Copper	130	160	□	■	Solo (DA)
Brass - Bronze	140	190	■	□	Solo (DA)
Aluminium	200	350	□	■	Solo (DA)
Gold - Silver	140	180	■	■	Solo (DA)
Platinum - Palladium	-	35	-	□	Solo (DA)
Superalloys	-	40	-	■	Trio (PO)
Titanium	40	60	■	■	RICO (ZB)

not adapted - adapted □ highly adapted ■

Tolerances  $d_1 \leq 1 \text{ mm}$  ▶ 0/-0.01  $D: h5$   
 $d_1 > 1 \text{ mm}$  ▶ 0/-0.02  
 $d_1 = D$  ▶  $d_1: e8$



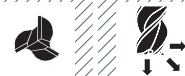
Upon request



Art. n°	$d_1$	$l_1$	D	L			Art. n°	$d_1$	$l_1$	D	L		
					Uncoat.	Trio*						Uncoat.	Trio*
1515d0.30	0.30	0.45	3	38	▲	▲	1515d1.85	1.85	2.80	3	38	▲	▲
1515d0.35	0.35	0.55	3	38	▲	▲	1515d1.90	1.90	2.85	3	38	▲	▲
1515d0.40	0.40	0.60	3	38	▲	▲	1515d1.95	1.95	2.90	3	38	▲	▲
1515d0.45	0.45	0.70	3	38	▲	▲	1515d2.00	2.00	3.00	3	38	▲	▲
1515d0.50	0.50	0.75	3	38	▲	▲	1515d2.05	2.05	3.05	3	38	▲	▲
1515d0.55	0.55	0.85	3	38	▲	▲	1515d2.10	2.10	3.15	3	38	▲	▲
1515d0.60	0.60	0.90	3	38	▲	▲	1515d2.15	2.15	3.20	3	38	▲	▲
1515d0.65	0.65	1.00	3	38	▲	▲	1515d2.20	2.20	3.30	3	38	▲	▲
1515d0.70	0.70	1.05	3	38	▲	▲	1515d2.25	2.25	3.40	3	38	▲	▲
1515d0.75	0.75	1.15	3	38	▲	▲	1515d2.30	2.30	3.45	3	38	▲	▲
1515d0.80	0.80	1.20	3	38	▲	▲	1515d2.35	2.35	3.55	3	38	▲	▲
1515d0.85	0.85	1.30	3	38	▲	▲	1515d2.40	2.40	3.60	3	38	▲	▲
1515d0.90	0.90	1.35	3	38	▲	▲	1515d2.45	2.45	3.70	3	38	▲	▲
1515d0.95	0.95	1.45	3	38	▲	▲	1515d2.50	2.50	3.75	3	38	▲	▲
1515d1.00	1.00	1.50	3	38	▲	▲	1515d2.55	2.55	3.80	3	38	▲	▲
1515d1.05	1.05	1.60	3	38	▲	▲	1515d2.60	2.60	3.90	3	38	▲	▲
1515d1.10	1.10	1.65	3	38	▲	▲	1515d2.65	2.65	3.95	3	38	▲	▲
1515d1.15	1.15	1.70	3	38	▲	▲	1515d2.70	2.70	4.05	3	38	▲	▲
1515d1.20	1.20	1.80	3	38	▲	▲	1515d2.75	2.75	4.15	3	38	▲	▲
1515d1.25	1.25	1.90	3	38	▲	▲	1515d2.80	2.80	4.20	3	38	▲	▲
1515d1.30	1.30	1.95	3	38	▲	▲	1515d2.85	2.85	4.30	3	38	▲	▲
1515d1.35	1.35	2.05	3	38	▲	▲	1515d2.90	2.90	4.35	3	38	▲	▲
1515d1.40	1.40	2.10	3	38	▲	▲	1515d2.95	2.95	4.45	3	38	▲	▲
1515d1.45	1.45	2.15	3	38	▲	▲	1515d3.00	3.00	4.50	6	51	▲	▲
1515d1.50	1.50	2.25	3	38	▲	▲	1515d3.10	3.10	4.65	6	51	▲	▲
1515d1.55	1.55	2.35	3	38	▲	▲	1515d3.20	3.20	4.80	6	51	▲	▲
1515d1.60	1.60	2.40	3	38	▲	▲	1515d3.30	3.30	4.95	6	51	▲	▲
1515d1.65	1.65	2.45	3	38	▲	▲	1515d3.40	3.40	5.10	6	51	▲	▲
1515d1.70	1.70	2.55	3	38	▲	▲	1515d3.50	3.50	5.25	6	51	▲	▲
1515d1.75	1.75	2.65	3	38	▲	▲	1515d3.60	3.60	5.40	6	51	▲	▲
1515d1.80	1.80	2.70	3	38	▲	▲	1515d3.70	3.70	5.55	6	51	▲	▲

Available uncoated or coated (see page 308)

Z3



$\lambda$  30°  $\gamma$  8-10°

CARB



$ap=0.25xd_1$   $ae=0.5xd_1$   
 $ap=0.5xd_1$

\* Prices for other coatings: contact us!

To order a coated tool, add the 2-letter coating code to the article number

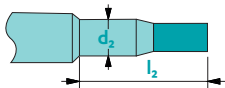


**1515**

Continuation

**End mill Z3  $l_1=1.5xd_1$** 

Upon request

Available  
uncoated or coated  
(see page 308)**Z3** $\lambda$   
**30°**       $\gamma$   
**8-10°****CARB** $ap=0.25xd_1$  $ae=0.5xd_1$   
 $ap=0.5xd_1$ 

Art. n°	$d_1$	$l_1$	D	L		
					Uncoat.	Trio*
1515d3.80	3.80	5.70	6	51	▲	▲
1515d3.90	3.90	5.85	6	51	▲	▲
1515d4.00	4.00	6.00	6	51	▲	▲
1515d4.10	4.10	6.15	6	51	▲	▲
1515d4.20	4.20	6.30	6	51	▲	▲
1515d4.30	4.30	6.45	6	51	▲	▲
1515d4.40	4.40	6.60	6	51	▲	▲
1515d4.50	4.50	6.75	6	51	▲	▲
1515d4.60	4.60	6.90	6	51	▲	▲
1515d4.70	4.70	7.05	6	51	▲	▲
1515d4.80	4.80	7.20	6	51	▲	▲
1515d4.90	4.90	7.35	6	51	▲	▲
1515d5.00	5.00	7.50	6	51	▲	▲
1515d5.10	5.10	7.65	6	51	▲	▲
1515d5.20	5.20	7.80	6	51	▲	▲
1515d5.30	5.30	7.95	6	51	▲	▲
1515d5.40	5.40	8.10	6	51	▲	▲
1515d5.50	5.50	8.25	6	51	▲	▲
1515d5.60	5.60	8.40	6	51	▲	▲
1515d5.70	5.70	8.55	6	51	▲	▲
1515d5.80	5.80	8.70	6	51	▲	▲
1515d5.90	5.90	8.85	6	51	▲	▲
1515d6.00	6.00	9.00	6	51	▲	▲
1515d6.50	6.50	9.75	8	61	▲	▲
1515d7.00	7.00	10.50	8	61	▲	▲
1515d7.50	7.50	11.25	8	61	▲	▲
1515d8.00	8.00	12.00	8	61	▲	▲
1515d8.50	8.50	12.75	10	72	▲	▲
1515d9.00	9.00	13.50	10	72	▲	▲
1515d9.50	9.50	14.25	10	72	▲	▲
1515d10.00	10.00	15.00	10	72	▲	▲
1515d11.00	11.00	16.50	11	83	▲	▲
1515d12.00	12.00	18.00	12	83	▲	▲
1515d13.00	13.00	19.50	13	83	▲	▲
1515d14.00	14.00	21.00	14	83	▲	▲
1515d15.00	15.00	22.50	15	83	▲	▲
1515d16.00	16.00	24.00	16	92	▲	▲

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