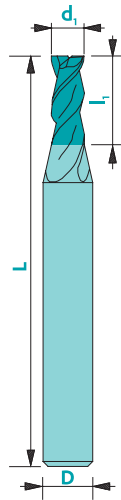
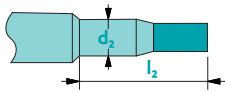


# Finishing end mill Z2



Upon request



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

Available uncoated or coated (see page 308)

**Z2**

**Y**

$\lambda$  45°  $\gamma$  8-10°

**CARB**

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

Art. n°	d <sub>1</sub>	l <sub>1</sub>	D	L			Art. n°	d <sub>1</sub>	l <sub>1</sub>	D	L		
					Uncoat.	Trio*						Uncoat.	Trio*
104d0.30	0.30	1.0	3	38	▲	▲	104d5.00	5.00	15.0	6	51	▲	▲
104d0.35	0.35	1.0	3	38	▲	▲	104d5.50	5.50	15.0	6	51	▲	▲
104d0.40	0.40	1.5	3	38	▲	▲	104d6.00	6.00	18.0	6	51	▲	▲
104d0.45	0.45	1.5	3	38	▲	▲	104d7.00	7.00	20.0	8	61	▲	▲
104d0.50	0.50	2.0	3	38	▲	▲	104d8.00	8.00	20.0	8	61	▲	▲
104d0.55	0.55	2.0	3	38	▲	▲	104d9.00	9.00	20.0	10	72	▲	▲
104d0.60	0.60	2.0	3	38	▲	▲	104d10.00	10.00	22.0	10	72	▲	▲
104d0.65	0.65	2.0	3	38	▲	▲							
104d0.70	0.70	3.0	3	38	▲	▲							
104d0.75	0.75	3.0	3	38	▲	▲							
104d0.80	0.80	3.0	3	38	▲	▲							
104d0.85	0.85	3.0	3	38	▲	▲							
104d0.90	0.90	3.0	3	38	▲	▲							
104d0.95	0.95	3.0	3	38	▲	▲							
104d1.00	1.00	3.0	3	38	▲	▲							
104d1.10	1.10	4.0	3	38	▲	▲							
104d1.20	1.20	4.0	3	38	▲	▲							
104d1.30	1.30	4.0	3	38	▲	▲							
104d1.40	1.40	5.0	3	38	▲	▲							
104d1.50	1.50	5.0	3	38	▲	▲							
104d1.60	1.60	5.0	3	38	▲	▲							
104d1.70	1.70	6.0	3	38	▲	▲							
104d1.80	1.80	6.0	3	38	▲	▲							
104d1.90	1.90	6.0	3	38	▲	▲							
104d2.00	2.00	6.0	3	38	▲	▲							
104d2.50	2.50	8.0	3	38	▲	▲							
104d3.00	3.00	8.0	3	38	▲	▲							
104d3.50	3.50	8.0	6	51	▲	▲							
104d4.00	4.00	12.0	6	51	▲	▲							
104d4.50	4.50	12.0	6	51	▲	▲							

\* Prices for other coatings: contact us!  
 To order a coated tool, add the 2-letter coating code to the article number