

# 4 FLUTES EXPERT END MILL FOR STAINLESS STEEL WITH COOLANT-THROUGH

**REF 1620H**



**Exceptional performance and unequalled  
machining quality in stainless steels**



# 1620H

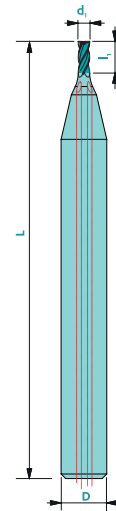
# EXPERT end mill stainless steel Z4 with coolant-through



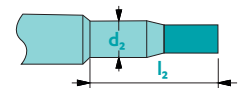
Material	Vc uncoated [m/min]	Vc coated [m/min]	Uncoated	Coated	Rec. Coating*
Steel < 700 N/mm <sup>2</sup>	-	180	-	■	Tisi (BQ)
Steel > 700 N/mm <sup>2</sup>	-	160	-	■	Tisi (BQ)
<b>Stainless steel</b>	-	<b>200</b>	-	■	<b>Tisi (BQ)</b>
Cast iron	-	200	-	■	Tisi (BQ)
Copper	-	250	-	■	Solo (DA)
Brass - Bronze	-	190	-	□	Solo (DA)
Aluminium	-	350	-	■	Solo (DA)
Gold - Silver	-	180	-	■	Solo (DA)
Platinum - Palladium	-	60	-	□	Solo (DA)
Superalloys	-	100	-	■	Trio (PO)
Titanium	60	100	□	■	Tisi (BN)

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	L: +0.5
	$d_1 = D$	▶ $d_1: e8$	$L_1: +0.1/0$



Upon request



Art. n°	$d_1$	$L_1$	$\lambda$	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

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

Available uncoated or coated



CARB



$$ap = 0.25 \times d_1 \quad ap = l_1 \max. \quad ae = \frac{d_1^2}{4 \times Ap}$$

Option: Weldon flat

