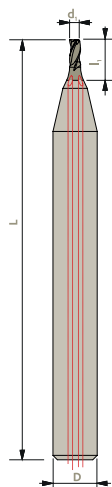


# 1520H

## 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  $d_1 \leq 1 \text{ mm} \rightarrow 0/-0.01$   $D: h5$  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 mm<sup>2</sup>/s at 40°C**  
 $d_1 = D \rightarrow d_1: e8$   $L_i: +0.1/0$  Filtration level: **maximum 0.02 mm**

Available  
uncoated or coated



**Z3**



$\lambda$   
30°

$\gamma$   
8°

**CARB**



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

| Art. n°    | $d_1$ | $l_1$ | D | L  |
|------------|-------|-------|---|----|
| 1520Hd0.30 | 0.30  | 0.60  | 4 | 38 |
| 1520Hd0.40 | 0.40  | 0.80  | 4 | 38 |
| 1520Hd0.50 | 0.50  | 1.00  | 4 | 38 |
| 1520Hd0.60 | 0.60  | 1.20  | 4 | 38 |
| 1520Hd0.70 | 0.70  | 1.40  | 4 | 38 |
| 1520Hd0.80 | 0.80  | 1.60  | 4 | 38 |
| 1520Hd0.90 | 0.90  | 1.80  | 4 | 38 |
| 1520Hd1.00 | 1.00  | 2.00  | 4 | 38 |
| 1520Hd1.10 | 1.10  | 2.20  | 4 | 38 |
| 1520Hd1.20 | 1.20  | 2.40  | 4 | 38 |
| 1520Hd1.30 | 1.30  | 2.60  | 6 | 50 |
| 1520Hd1.40 | 1.40  | 2.80  | 6 | 50 |
| 1520Hd1.50 | 1.50  | 3.00  | 6 | 50 |
| 1520Hd1.60 | 1.60  | 3.20  | 6 | 50 |
| 1520Hd1.70 | 1.70  | 3.40  | 6 | 50 |
| 1520Hd1.80 | 1.80  | 3.60  | 6 | 50 |

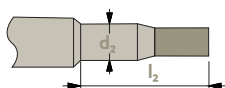
| Art. n°    | $d_1$ | $l_1$ | D | L  |
|------------|-------|-------|---|----|
| 1520Hd1.90 | 1.90  | 3.80  | 6 | 50 |
| 1520Hd2.00 | 2.00  | 4.00  | 6 | 50 |
| 1520Hd2.10 | 2.10  | 4.20  | 6 | 50 |
| 1520Hd2.20 | 2.20  | 4.40  | 6 | 50 |
| 1520Hd2.30 | 2.30  | 4.60  | 6 | 50 |
| 1520Hd2.40 | 2.40  | 4.80  | 6 | 50 |
| 1520Hd2.50 | 2.50  | 5.00  | 6 | 50 |
| 1520Hd2.60 | 2.60  | 5.20  | 6 | 50 |
| 1520Hd2.70 | 2.70  | 5.40  | 6 | 50 |
| 1520Hd2.80 | 2.80  | 5.60  | 6 | 50 |
| 1520Hd2.90 | 2.90  | 5.80  | 6 | 50 |
| 1520Hd3.00 | 3.00  | 6.00  | 6 | 50 |
| 1520Hd4.00 | 4.00  | 8.00  | 6 | 50 |
| 1520Hd5.00 | 5.00  | 10.00 | 6 | 50 |
| 1520Hd6.00 | 6.00  | 12.00 | 6 | 50 |



Recommendations / coating

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

Upon request



///CYCLON X