



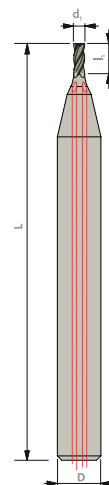
# EXPERT end mill for stainless steel Z4 with internal coolant

1620H

not adapted - adapted ☐ highly adapted ☒

| Material                      | Vc uncoated<br>[m/min] | Vc coated<br>[m/min] | Uncoated                 | Coated                              |
|-------------------------------|------------------------|----------------------|--------------------------|-------------------------------------|
| Steel < 700 N/mm <sup>2</sup> | -                      | 180                  | -                        | <input checked="" type="checkbox"/> |
| Steel > 700 N/mm <sup>2</sup> | -                      | 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 mm<sup>2</sup>/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 |
|---------------------------|-------------------------|------|------|
|                           | Steel / Stainless Steel | BY   | BW   |
|                           | Copper alloys / Brass   | DA   | DA   |
|                           | Platinum / CFRP         | DC   | DC   |
|                           | Titanium                | ME   | ME   |

| Art. n°     | d <sub>1</sub> | L <sub>1</sub> | 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**



$\lambda$  **36-39°**  $\gamma$  **8°**

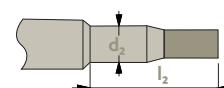
**CARB**



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



Upon request



///CYCLON X