

End mill Z4 - variable helix & pitch

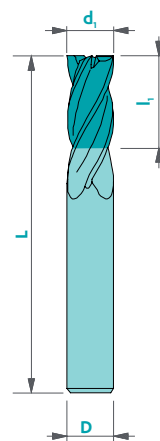
1620

Material	Vc uncoated	Vc coated	Uncoated	Coated	Rec. Coating
Steel < 700 N/mm ²	100	130	□	■	Trio
Steel > 700 N/mm ²	80	100	-	■	Trio
Stainless steel	50	70	□	■	Trio
Cast iron	60	100	□	■	Trio
Copper	150	180	□	■	Solo
Brass - Bronze	140	190	■	□	Solo
Aluminium	200	350	□	■	Rico/Solo
Gold - Silver	140	180	■	□	Solo
Platinum - Palladium	-	35	-	□	Solo
Superalloy	-	40	-	■	Trio
Titanium	40	60	■	■	Rico/Trio

not adapted - adapted □ highly adapted ■

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

D: h5



Available
uncoated or coated
(see page 61)

Art. n°	d_1	l_1	λ	D	L
1620d1.00	1.0	2	0.02	6	51
1620d1.50	1.5	3	0.02	6	51
1620d2.00	2.0	4	0.02	6	51
1620d2.50	2.5	5	0.02	6	51
1620d3.00	3.0	6	0.02	6	51
1620d3.50	3.5	7	0.03	6	51
1620d4.00	4.0	8	0.03	6	51
1620d5.00	5.0	10	0.04	6	51
1620d6.00	6.0	12	0.05	6	51
1620d8.00	8.0	16	0.05	8	61
1620d10.00	10.0	20	0.05	10	72
1620d12.00	12.0	24	0.05	12	83
1620d14.00	14.0	28	0.06	14	83
1620d16.00	16.0	32	0.06	16	92



Z4



λ
35-45°

γ
8°

SUB-CARFINE

N



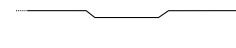
$ap=1 \times d_1$



$ae=1 \times d_1$
 $ap=2.0 \times d_1$

Ø1 and 1.5 to be used only
for peripheral milling and
not for grooving

Option: Weldon flat



Upon request : Z6