

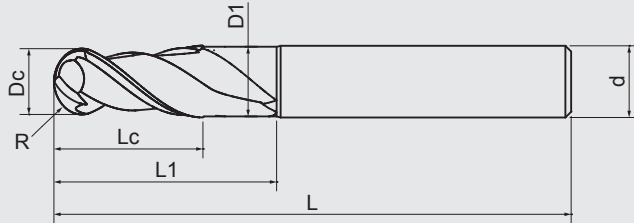
## F618ZX / F620ZX

## Ball Nose End Mills For Aluminium

40° helix with round cutting edge and mirror sharp grinding on side cutting edge.

Various applications on Aluminium for curved profile milling.

Adopting ZrN coating without AlTi in the formula would prevent from chemical affinity with Alu metal and enhance tool life by decreasing friction and gaining better surface hardness and smoothness.



VHM  
Carbide

ZrN  
ZX



Aluminium



Suitable for cutting aluminium.

Application for roughing cutting with high chip removal rate.

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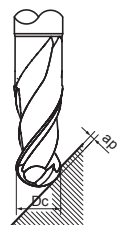
## DIN 6527 Standard Length

Dc 0 -0.02	R ±0.005	Lc mm	L mm	Lc mm	L1 mm	D1 h5	F618ZX ZrN					
3	1.5R	6	57	6	9	2.8	●					
4	2R	8	57	6	12	3.7	●					
5	2.5R	10	57	6	15	4.6	●					
6	3R	12	57	6	20	5.5	●					
8	4R	16	63	8	26	7.4	●					
10	5R	20	72	10	31	9.2	●					
12	6R	24	83	12	37	11.0	●					

## Long Length

Dc 0 -0.02	R ±0.005	Lc mm	L mm	Lc mm	L1 mm	D1 h5		F620ZX ZrN				
3	1.5R	6	70	6	9	2.8		●				
4	2R	8	70	6	12	3.7		●				
5	2.5R	10	80	6	15	4.6		●				
6	3R	12	80	6	20	5.5		●				
8	4R	16	100	8	26	7.4		●				
10	5R	20	100	10	31	9.2		●				
12	6R	24	110	12	37	11.0		●				

## Cutting Conditions

F618ZX F620ZX								
	cutting speed Vc (m/min)	feed per tooth fz (mm)	ae	ap	cutting speed Vc (m/min)	feed per tooth fz (mm)	ap	
Aluminium Steel Materials								
N	GRI0-1 Wrought Aluminium alloys	800	0.021xDc	0.2xDc	0.05xDc	900	0.016xDc	0.02xDc
	GRI0-2 Aluminium cast alloys <10%	800	0.021xDc	0.2xDc	0.05xDc	900	0.014xDc	0.02xDc
	GRI0-3 Aluminium cast alloys >10%	700	0.020xDc	0.2xDc	0.05xDc	800	0.012xDc	0.02xDc

All cutting data serve for orientation only and should be adapted individually to the technical conditions on location

1. Please work with good rigidity / high precision facilities and collet chuck.
2. Please choose proper cutting fluid.
3. The cutting data is reference value only. Please adjust it according to your real working conditions.
4. If RPM is lower the reference value, the Feed rate (fz) and RPM should be reduced by the same proportion.
5. If vibration occurs during cutting, please reduce cutting parameter.