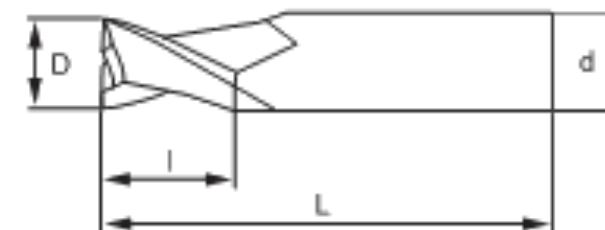


END MILLS Z2



ITEM: A4015

Material Micro-grain carbide
Standard Factory standard
Tolerance D ≤ 1mm - ~0.019mm
D 1~ 6mm - ~ 0.02mm
D > 6 ~20mm - ~ 0.025mm
Shank Cylindrical / Weldon
Helix 35° right-hand
Surface treatment WIND
Application Slotting on materials up to 55 HRC

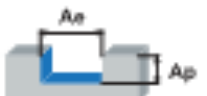


< 500	< 850	< 1200	< 600	< 850	Duplex	< 240	< 300	< 10% Si	> 10% Si	Brass Copper	Ti6Al4V	HTA	< 45	< 60	< 65
●	●	●				●	●						●	○	

On request available with Weldon shank at a cost of € 2.
Cylindrical shank (A4015....) Weldon shank (A4015...W)

FACTORY STANDARD

A4015	Tech. Code		D mm	L mm	l mm	d mm	Z	
2T - 35°	A40151		1	50	3	4	2	1
	A40151,5		1.5		4			
	A40152		2		6			
	A40152,5		2.5		8			
	A40153		3		10			
	A40153,5		3.5		11			
	A40154		4		13			
	A40154,5		4.5					
	A40155		5					
	A40155,5		5.5					
	A40156		6	16				
	A40156,5		6.5					
	A40157		7					
	A40158		8					
	A40158,5		8.5	20				
	A40159		9					
	A40159,5		9.5					
	A401510		10					
	A401510,5		10.5	25				
	A401511		11					
	A401512		12					
	A401516		16					
	A401518		18	40				
	A401520		20					

		Side Milling		Slotting	RANGE													
					A4015													
Material	Feature	Ap	Ae	Ap	Vc m/min. min.	Vc m/min. max.	mm	D/mm 2	D/mm 3	D/mm 4	D/mm 5	D/mm 6	D/mm 8	D/mm 10	D/mm 12	D/mm 16	D/mm 20	
CARBON STEEL	< 500 N/mm²	1.25 x D	0.1 x D	0.5 x D	110	130	fz/mm	0.006	0.009	0.012	0.015	0.020	0.025	0.032	0.040	0.052	0.080	
	< 850 N/mm²	1.25 x D	0.1 x D	0.5 x D	90	120	fz/mm	0.006	0.009	0.011	0.016	0.018	0.023	0.028	0.035	0.048	0.070	
	< 1200 N/mm²	1.25 x D	0.1 x D	0.3 x D	70	100	fz/mm	0.006	0.008	0.010	0.014	0.016	0.020	0.026	0.032	0.043	0.065	
STAINLESS STEEL	< 600 N/mm²	1.25 x D	0.1 x D	0.5 x D	70	95	fz/mm	0.006	0.009	0.011	0.015	0.018	0.023	0.028	0.035	0.045	0.070	
	< 800 N/mm²	1.25 x D	0.1 x D	0.3 x D	50	80	fz/mm	0.006	0.008	0.010	0.013	0.016	0.019	0.025	0.030	0.040	0.065	
CAST IRON	< 240 HB	1.25 x D	0.1 x D	0.5 x D	80	120	fz/mm	0.007	0.011	0.013	0.016	0.020	0.028	0.035	0.045	0.055	0.075	
	< 300 HB	1.25 x D	0.1 x D	0.5 x D	70	100	fz/mm	0.006	0.010	0.012	0.015	0.018	0.025	0.030	0.040	0.050	0.065	

Recommended "fz" values for slotting.

For side milling, adjust the cutting parameters. (ex: fz x 1.25)