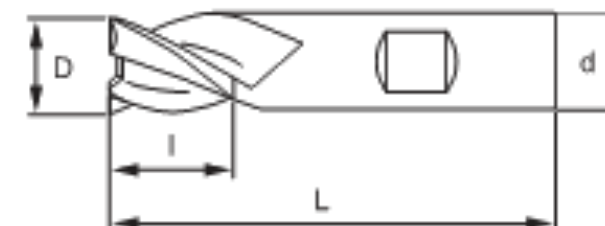




ITEM: A4032

Material Micro-grain carbide
Standard Factory standard
Tolerance e8
Shank Weldon
Helix 30° right-hand
Surface treatment WIND
Application Slotting and side milling on materials up to 50 HRC



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

FACTORY STANDARD

A4032	Tech. Code		D mm	L mm	l mm	d mm	Z	
3T - 30°	A40321		1.00	38	2	3	3	1
	A40321,5		1.50		4	6		
	A40322		2.00		5			
	A40322,5		2.50		6			
	A40323		3.00		7			
	A40323,5		3.50		8			
	A40324		4.00					
	A40324,5		4.50					
	A40325		5.00					
	A40325,5		5.50					
	A40325,75		5.75					
	A40326		6.00					
	A40327		7.00	42	10	8		
	A40327,75		7.75	43	11	10		
	A40328		8.00	48				
	A40328,7		8.70					
	A40329		9.00					
	A40329,7		9.70	50				
	A403210		10.00	55	15	12		
	A403212		12.00	58		14		
	A403214		14.00	62	18	16		
	A403216		16.00	75	22	20		
	A403220		20.00					

		Side Milling		Slotting	RANGE												
					A4032												
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	0.1 x D	0.5 x D	0.5 x D	90	120	fz/mm	0.006	0.009	0.012	0.015	0.020	0.025	0.032	0.040	0.054	0.066
	< 850 N/mm²	0.1 x D	0.5 x D	0.5 x D	80	105	fz/mm	0.006	0.009	0.011	0.016	0.018	0.023	0.028	0.035	0.045	0.057
	< 1200 N/mm²	0.1 x D	0.5 x D	0.3 x D	65	90	fz/mm	0.006	0.008	0.010	0.014	0.016	0.020	0.026	0.032	0.040	0.050
STAINLESS STEEL	< 600 N/mm²	0.1 x D	0.5 x D	0.5 x D	45	60	fz/mm	0.006	0.009	0.011	0.015	0.018	0.023	0.028	0.035	0.045	0.057
	< 800 N/mm²	0.1 x D	0.5 x D	0.3 x D	40	50	fz/mm	0.006	0.008	0.010	0.013	0.016	0.019	0.025	0.030	0.038	0.045
CAST IRON	< 240 HB	0.1 x D	0.5 x D	0.5 x D	110	130	fz/mm	0.007	0.011	0.013	0.016	0.020	0.028	0.035	0.045	0.050	0.057
	< 300 HB	0.1 x D	0.5 x D	0.5 x D	90	110	fz/mm	0.006	0.010	0.012	0.015	0.018	0.025	0.030	0.040	0.045	0.050

Recommended "fz" values for slotting.
 For side milling, adjust the cutting parameters. (ex: fz x 1.25)