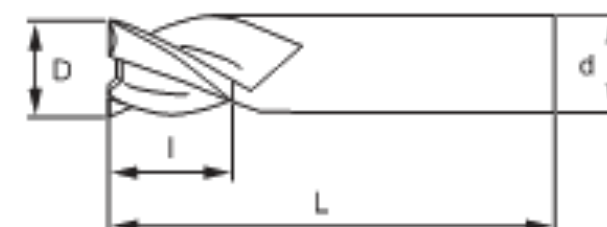


KERFOLG END MILLS FOR SLOTTING Z3



ITEM: A4034

Material Micro-grain carbide
Standard factory standard
Tolerance h10
Shank Cylindrical / Weldon
Helix Right-hand 30°
Surface treatment TiAlN (coated)
Application Slots and side milling on materials up to 50 HRC



On request available with Weldon shank at a cost of € 2.
 Cylindrical shank (A4034....) Weldon shank (A4034...W)

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

FACTORY STANDARD

A4034	Tech. Code	D mm	L mm	I mm	d mm	Z	
3T - 30°	A403402	2	38	6	3	3	1
	A403403	3		7			
	A403404	4	50	8	4		
	A403405	5		10	5		
	A403406	6	57		6		
	A403408	8	63	16	8		
	A403410	10	72	19	10		
	A403412	12	83	22	12		
	A403414	14			14		
	A403416	16	92	26	16		
	A403418	18			18		
	A403420	20	104	32	20		

		Side Milling		Slotting	RANGE												
					A4034												
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 x D	0.25 x D	0.5 x D	100	140	fz/mm	0.015	0.023	0.032	0.041	0.050	0.070	0.086	0.099	0.123	0.149
	< 850 N/mm²	1 x D	0.25 x D	0.5 x D	90	125	fz/mm	0.015	0.023	0.032	0.041	0.050	0.070	0.086	0.099	0.123	0.149
	< 1200 N/mm²	1 x D	0.25 x D	0.5 x D	80	115	fz/mm	0.012	0.019	0.025	0.032	0.040	0.056	0.068	0.079	0.099	0.120
STAINLESS STEEL	< 600 N/mm²	1 x D	0.25 x D	0.5 x D	65	90	fz/mm	0.010	0.015	0.021	0.026	0.032	0.046	0.056	0.064	0.080	0.097
	< 800 N/mm²	1 x D	0.25 x D	0.5 x D	60	80	fz/mm	0.009	0.014	0.020	0.025	0.031	0.043	0.053	0.060	0.077	0.093
CAST IRON	< 240 HB	1 x D	0.25 x D	0.5 x D	80	115	fz/mm	0.013	0.021	0.029	0.037	0.045	0.063	0.077	0.089	0.110	0.134
	< 300 HB	1 x D	0.25 x D	0.5 x D	70	100	fz/mm	0.013	0.020	0.027	0.034	0.042	0.059	0.073	0.085	0.105	0.127
SUPERALLOY	Ti6Al4V	1 x D	0.25 x D	0.5 x D	60	85	fz/mm	0.011	0.017	0.023	0.030	0.036	0.052	0.063	0.073	0.091	0.110
	< 45 HRC	1 x D	0.25 x D	0.5 x D	25	35	fz/mm	0.008	0.014	0.018	0.023	0.029	0.041	0.050	0.057	0.071	0.086

Recommended "fz" values for side milling.
 For slotting, adjust the cutting parameters. (ex: fz x 0.8)