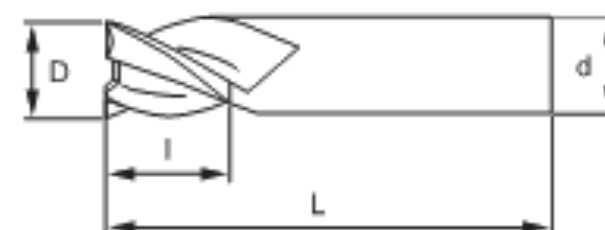


KERFOLG® END MILLS Z3



ITEM: A4036

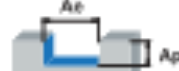
Material Micro-grain carbide
Standard Factory standard
Tolerance h10
Shank Cylindrical / Weldon
Helix 45° right-hand
Surface treatment TiAlN
Application Slotting and side milling extremely finished on materials such as stainless steel and titanium alloys.



< 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 (A4036....) Weldon shank (A4036...W)

FACTORY STANDARD								
A4036	Tech. Code		D mm	L mm	I mm	d mm	Z	
	A40363		3	38	8	3	3	1
	A40364		4	50	11	4		
	A40365		5		13	5		
	A40366		6	57		6		
	A40368		8	63	19	8		
	A403610		10	72	22	10		
	A403612		12	83	26	12		
	A403616		16	92	32	16		
	A403620		20	104	38	20		

		Side Milling		Slotting	RANGE											
					A4036											
Material	Feature	Ap	Ae	Ap	Vc m/min. min.	Vc m/min. max.	mm	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
STAINLESS STEEL	< 600 N/mm²	1 x D	0.25 x D	0.5 x D	75	90	fz/mm	0.013	0.016	0.022	0.026	0.031	0.037	0.045	0.065	0.078
	< 800 N/mm²	1 x D	0.25 x D	0.5 x D	60	80	fz/mm	0.012	0.015	0.021	0.025	0.035	0.043	0.050	0.061	0.075
NON FERROUS	ALU <10% Si	1 x D	0.25 x D	0.5 x D	400	650	fz/mm	0.024	0.032	0.041	0.050	0.071	0.087	0.100	0.125	0.150
	ALU <10% Si	1 x D	0.25 x D	0.5 x D	320	450	fz/mm	0.024	0.032	0.041	0.050	0.071	0.087	0.100	0.125	0.150
SUPER ALLOY	Ti6Al4V	1 x D	0.25 x D	0.5 x D	45	65	fz/mm	0.012	0.014	0.020	0.023	0.033	0.041	0.047	0.059	0.070

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