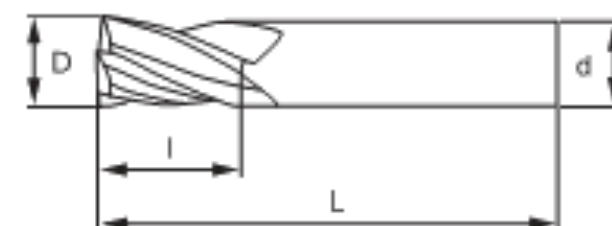


KERFOLG® END MILLS FOR SLOTTING Z4



ITEM: A4042

Material Micro-grain carbide
Standard Factory standard
Tolerance h10
Shank Cylindrical / Weldon
Helix 30° right-hand
Surface treatment TiAlN
Application Side milling on materials up to 50 HRC



On request available with Weldon shank at a cost of € 2.
 Cylindrical shank (A4042....) Weldon shank (A4042...W)

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

FACTORY STANDARD

A4042	Tech. Code	D mm	L mm	I mm	d mm	Z	
4T - 30°	A404202	2	38	7	3	4	1
	A404203	3		8			
	A404204	4	50	11	4		
	A404205	5		13	5		
	A404206	6	57		6		
	A404208	8	63	19	8		
	A404210	10	72	22	10		
	A404212	12	83	26	12		
	A404214	14			14		
	A404216	16	92	32	16		
	A404218	18			18		
	A404220	20	104	38	20		

		Side Milling		Slotting	RANGE												
					A4042												
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)