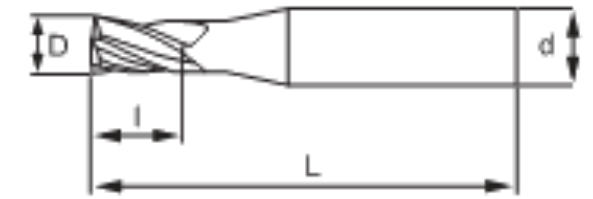


END MILLS Z4



ITEM: A4045

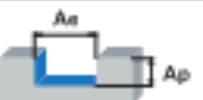
Material Micro-grain carbide
Standard Factory standard
Tolerance D ≤ 1mm - ~ 0.019mm
D 1~ 6mm - ~ 0.02mm
D > 6 -20mm - ~ 0.025mm
Shank Cylindrical / Weldon
Helix 35° right-hand
Surface treatment WIND
Application Side milling on materials up to 55 HRC



< 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 (A4045....) Weldon shank (A4045...W)

FACTORY STANDARD								
A4045	Tech. Code		D mm	L mm	l mm	d mm	Z	
4T - 35°	A40451		1	50	3	4	4	1
	A40451,5		1.5		4			
	A40452		2		6			
	A40452,5		2.5		8			
	A40453		3					
	A40453,5		3.5		10			
	A40454		4		11			
	A40454,5		4.5	13	6			
	A40455		5					
	A40455,5		5.5	16				
	A40456		6					
	A40456,5		6.5	60		8		
	A40457		7					
	A40458		8			20		
	A40458,5		8.5					
	A40459		9	75	10			
	A40459,5		9.5					
	A404510		10		30			
	A404510,5		10.5					
	A404511		11	12				
	A404512		12					
	A404516		16	100	40	16		
	A404518		18		45	20		
	A404520		20					

		Side Milling		Slotting	RANGE												
					A4045												
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)