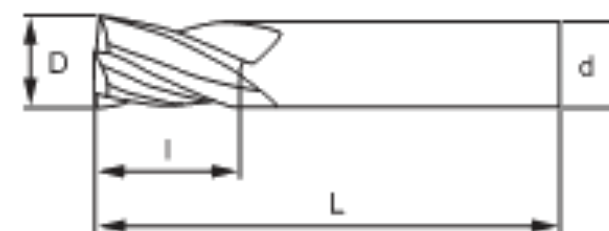


KERFOLG END MILLS LONG SERIES Z4



ITEM: A4048

Material Micro-grain carbide
Standard Factory standard
Tolerance h10
Shank Cylindrical / Weldon
Helix 30° right
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 (A4048....) Weldon shank (A4048...W)

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

FACTORY STANDARD

A4048	Tech. Code		D mm	L mm	l mm	d mm	Z	
4T - 30°	A404804060		4	60	20	4	4	1
	A404805060		5			5		
	A404806065		6	65	24	6		
	A404806080			80	40			
	A404808080		8		32	8		
	A404808100			100	42			
	A404810080		10	80	32	10		
	A404810100			100	45			
	A404812100		12		50	12		
	A404812150			150	75			
	A404816120		16	120	60	16		
	A404816150			150	75			
	A404820130		20	130	60	20		
	A404820150			150	75			

		Side Milling		Slotting	RANGE										
					A4048										
Material	Feature	Ap	Ae	Ap	Vc m/min. min.	Vc m/min. max.	mm	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	2.5 x D	0.15 x D	-	90	130	fz/mm	0.015	0.020	0.025	0.035	0.045	0.056	0.080	0.100
	< 850 N/mm²	2.5 x D	0.15 x D	-	80	120	fz/mm	0.015	0.020	0.025	0.035	0.045	0.056	0.080	0.100
	< 1200 N/mm²	2.5 x D	0.15 x D	-	80	110	fz/mm	0.010	0.012	0.015	0.021	0.027	0.033	0.045	0.060
STAINLESS STEEL	< 600 N/mm²	2.5 x D	0.15 x D	-	70	90	fz/mm	0.010	0.012	0.015	0.021	0.027	0.033	0.045	0.060
CAST IRON	< 240 HB	2.5 x D	0.15 x D	-	70	110	fz/mm	0.015	0.020	0.025	0.035	0.045	0.056	0.080	0.100
HARDENED	< 45 HRC	2.5 x D	0.10 x D	-	70	100	fz/mm	0.010	0.012	0.015	0.021	0.027	0.033	0.045	0.060

Recommended "fz" values for side milling.