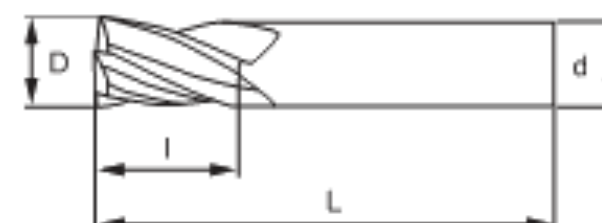


KERFOG END MILLS Z4



ITEM: A4050

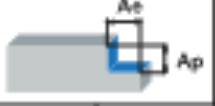
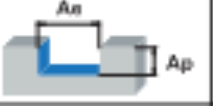
Material Micro-grain carbide
Standard Factory standard
Tolerance D ≤ 1mm - ~0.019mm
D 1~ 6mm - ~ 0.02mm
D > 6 ~20mm - ~ 0.025mm
Shank Cylindrical / Weldon
Helix 35° right-hand
Surface treatment WIND
Application Side milling on materials up to 55 HRC



< 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 (A4050....) Weldon shank (A4050...W)

FACTORY STANDARD								
A4050	Tech. Code		D mm	L mm	l mm	d mm	Z	
4T - 35°	A4050375		3	75	8	4	4	1
	A4050475		4		11			
	A4050575		5		13	6		
	A4050675		6		16			
	A4050875		8		20			
	A40504100		4	100	11	4		
	A40506100		6		16	6		
	A40508100		8		20	8		
	A405010100		10		25	10		
	A405012100		12		30	12		
	A40501210050				50			
	A40506150		6	150	16	6		
	A40508150		8		20	8		
	A405010150		10		25	10		
	A405012150		12		30	12		
	A405014150		14		50	16		
	A405016150		16		60			
	A405020200		20	200	90	20		

		Side Milling		Slotting	RANGE												
					A4050												
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)