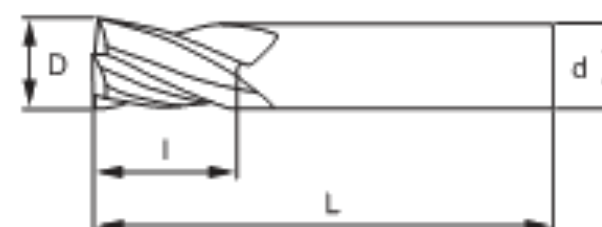


END MILLS Z4



ITEM: A4055

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 45° 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 (A4055....) Weldon shank (A4055...W)

FACTORY STANDARD								
A4055	Tech. Code		D mm	L mm	l mm	d mm	Z	
4T - 45°	A40551		1	50	3	4	4	1
	A40552		2		6	6		
	A40553		3		8			
	A40554		4		11			
	A40555		5		13			
	A40556		6		16			
	A40558		8	60	20	8		
	A405510		10	75	25	10		
	A405512		12		30	12		
	A405516		16	100	40	16		
	A405520		20		45	20		

		Side Milling		Slotting	RANGE												
					A4055												
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	1.5 x D	0.15 x D	0.25 x D	90	115	fz/mm	0.012	0.015	0.025	0.032	0.040	0.050	0.065	0.075	0.095	0.110
	< 850 N/mm²	1.5 x D	0.15 x D	0.25 x D	80	110	fz/mm	0.012	0.015	0.025	0.032	0.040	0.048	0.058	0.065	0.080	0.095
	< 1200 N/mm²	1.5 x D	0.15 x D	-	70	95	fz/mm	0.010	0.012	0.022	0.025	0.036	0.042	0.052	0.058	0.075	0.085
STAINLESS STEEL	< 600 N/mm²	1.5 x D	0.15 x D	0.25 x D	70	85	fz/mm	0.009	0.009	0.022	0.025	0.032	0.040	0.046	0.050	0.075	0.080
	< 800 N/mm²	1.5 x D	0.15 x D	-	55	70	fz/mm	0.008	0.008	0.020	0.022	0.028	0.035	0.042	0.045	0.055	0.065
CAST IRON	< 240 HB	1.5 x D	0.15 x D	0.25 x D	80	105	fz/mm	0.012	0.015	0.025	0.032	0.040	0.050	0.065	0.075	0.110	0.130
	< 300 HB	1.5 x D	0.15 x D	0.25 x D	70	90	fz/mm	0.012	0.015	0.025	0.032	0.040	0.050	0.065	0.075	0.100	0.115
HARDENED	< 45 HRC	0.5 x D	0.05 x D	-	35	45	fz/mm	0.008	0.008	0.020	0.022	0.028	0.035	0.042	0.045	0.055	0.065

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