

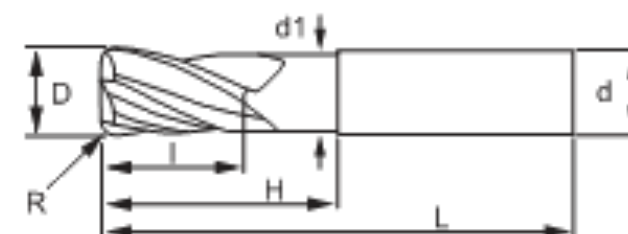
# KERFOLG CORNER RADIUS END MILLS Z4



ITEM: A4126

**Material** Sub micro-grain carbide 0,4  
**Standard** Factory standard  
**Tolerance** h10  
**Shank** Cylindrical / Weldon with neck reduction

**Helix** 30° right-hand  
**Surface treatment** WIND  
**Application** Slotting, pocketing and profiling on materials up to 62 HRC.

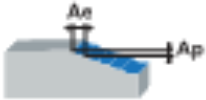
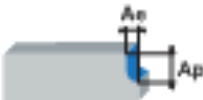


|       |       |        |       |       |        |       |       |          |          |                 |         |     |      |      |      |
|-------|-------|--------|-------|-------|--------|-------|-------|----------|----------|-----------------|---------|-----|------|------|------|
| < 500 | 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

On request available with Weldon shank at a cost of € 2.  
 Cylindrical shank (A4126....) Weldon shank (A4126...W)

## FACTORY STANDARD

|          |            |  |         |         |         |          |         |         |         |   |                                                                                     |
|----------|------------|--|---------|---------|---------|----------|---------|---------|---------|---|-------------------------------------------------------------------------------------|
| A4126    | Tech. Code |  | D<br>mm | R<br>mm | l<br>mm | d1<br>mm | H<br>mm | L<br>mm | d<br>mm | Z |  |
| 4T - 30° | A412660,3  |  | 6       | 0.3     | 6       | 5.8      | 24      | 60      | 6       | 4 | 1                                                                                   |
|          | A412660,5  |  |         | 0.5     |         |          |         |         |         |   |                                                                                     |
|          | A412661    |  |         | 1       |         |          |         |         |         |   |                                                                                     |
|          | A412680,3  |  | 8       | 0.3     | 8       | 7.8      | 29      | 75      | 8       |   |                                                                                     |
|          | A412680,5  |  |         | 0.5     |         |          |         |         |         |   |                                                                                     |
|          | A412681    |  |         | 1       |         |          |         |         |         |   |                                                                                     |
|          | A412681,5  |  |         | 1.5     |         |          |         |         |         |   |                                                                                     |
|          | A412682    |  |         | 2       |         |          |         |         |         |   |                                                                                     |
|          | A4126100,3 |  | 10      | 0.3     | 10      | 9.7      | 35      | 80      | 10      |   |                                                                                     |
|          | A4126100,5 |  |         | 0.5     |         |          |         |         |         |   |                                                                                     |
|          | A4126101   |  |         | 1       |         |          |         |         |         |   |                                                                                     |
|          | A4126101,5 |  |         | 1.5     |         |          |         |         |         |   |                                                                                     |
|          | A4126102   |  |         | 2       |         |          |         |         |         |   |                                                                                     |
|          | A4126120,5 |  | 12      | 0.5     | 12      | 11.7     | 37      | 100     | 12      |   |                                                                                     |
|          | A4126121   |  |         | 1       |         |          |         |         |         |   |                                                                                     |
|          | A4126121,5 |  |         | 1.5     |         |          |         |         |         |   |                                                                                     |
|          | A4126122   |  |         | 2       |         |          |         |         |         |   |                                                                                     |
|          | A4126160,5 |  | 16      | 0.5     | 16      | 15.5     | 42      | 105     | 16      |   |                                                                                     |
|          | A4126161   |  |         | 1       |         |          |         |         |         |   |                                                                                     |
|          | A4126161,5 |  |         | 1.5     |         |          |         |         |         |   |                                                                                     |
|          | A4126162   |  |         | 2       |         |          |         |         |         |   |                                                                                     |

|              |              | Profiling                                                                           |         | Side milling                                                                        |         | RANGE                |                  |       |           |           |            |            |            |
|--------------|--------------|-------------------------------------------------------------------------------------|---------|-------------------------------------------------------------------------------------|---------|----------------------|------------------|-------|-----------|-----------|------------|------------|------------|
|              |              |  |         |  |         | A4126                |                  |       |           |           |            |            |            |
| Material     | Feature      | Ap                                                                                  | Ae      | Ap                                                                                  | Ae      | Vc<br>m/min.<br>min. | Vc m/min.<br>max | mm    | D/mm<br>6 | D/mm<br>8 | D/mm<br>10 | D/mm<br>12 | D/mm<br>16 |
| CARBON STEEL | < 850 N/mm²  | 0.1 x D                                                                             | 0.1 x D | 1 x D                                                                               | 0.1 x D | 200                  | 240              | fz/mm | 0.053     | 0.071     | 0.084      | 0.096      | 0.135      |
|              | < 1200 N/mm² | 0.1 x D                                                                             | 0.1 x D | 1 x D                                                                               | 0.1 x D | 180                  | 215              | fz/mm | 0.048     | 0.064     | 0.076      | 0.088      | 0.125      |
| CAST IRON    | < 240 HB     | 0.1 x D                                                                             | 0.1 x D | 1 x D                                                                               | 0.1 x D | 200                  | 240              | fz/mm | 0.061     | 0.082     | 0.097      | 0.110      | 0.145      |
|              | < 300 HB     | 0.1 x D                                                                             | 0.1 x D | 1 x D                                                                               | 0.1 x D | 180                  | 215              | fz/mm | 0.053     | 0.071     | 0.084      | 0.096      | 0.132      |
| HARDENED     | < 45 HRC     | 0.1 x D                                                                             | 0.1 x D | 1 x D                                                                               | 0.1 x D | 95                   | 120              | fz/mm | 0.043     | 0.057     | 0.067      | 0.076      | 0.105      |
|              | < 62 HRC     | 0.1 x D                                                                             | 0.1 x D | 1 x D                                                                               | 0.1 x D | 65                   | 90               | fz/mm | 0.043     | 0.057     | 0.067      | 0.076      | 0.095      |

Recommended "fz" values for profiling. For side milling  $A_p = 1 \times D$   $A_e = 0.1 \times D$ . Adjust cutting parameters (ex.  $V_c \times 0.6$   $f_z \times 0.75$ )