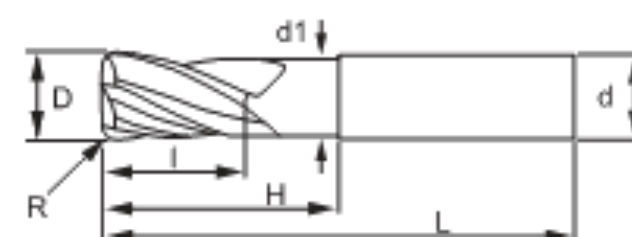


KERFOLG CORNER RADIUS END MILLS Z4



ITEM: A4131

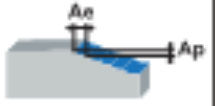
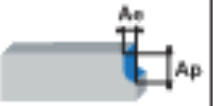
Material Sub micro-grain carbide 0,4
Standard Factory standard
Tolerance h10
Shank Cylindrical / Weldon with neck reduction
Helix 30° right-hand
Surface treatment WIND
Application Slot and profiling on materials up to 62 HRC.



< 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 (A4131....) Weldon shank (A4131...W)

FACTORY STANDARD											
A4131	Tech. Code		D mm	R mm	l mm	d1 mm	H mm	L mm	d mm	Z	
4T - 30°	A413160,5		6	0.5	6	5.8	45	90	6	4	1
	A413161			1							
	A413180,5		8	0.5	8	7.8	55	100	8		
	A413181			1							
	A4131100,5		10	0.5	10	9.7		10			
	A4131101,5			1.5							
	A4131120,5		12	0.5	12	11.7	75	120	12		
	A4131121			1							
	A4131121,5			1.5							

		Profiling		Side Milling		RANGE							
						A4131							
Material	Feature	Ap	Ae	Ap	Ae	Vc m/min. min.	Vc m/min. max	mm	D/mm 6	D/mm 8	D/mm 10	D/mm 12	D/mm 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	0.095	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	0.086	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	0.095	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 Ap = 1 x D Ae = 0,1 x D. Adjust cutting parameters (ex. Vc x 0.6 fz x 0.75)