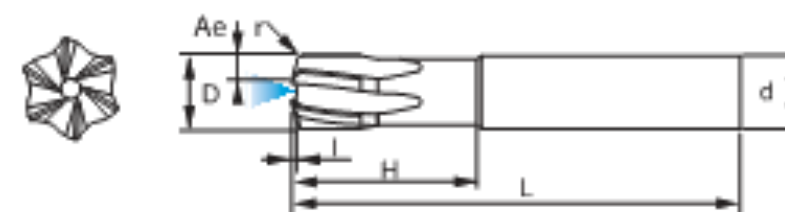



HD
ITEM: A4138

Material Micro-grain carbide
Standard Factory standard
Tolerance e8
Shank Cylindrical with neck reduction
Helix 15° right-hand
Surface treatment WIND X
Application Pocketing and side milling on hardened materials up to 65 HRC.



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

FACTORY STANDARD

A4138	Tech. Code	D mm	L mm	r mm	l max mm	Ae max mm	H mm	d mm	Z	
6T - 15°	A41386	6	63	0.63	0.32	1.32	18	6	6	1
	A41388	8	76	0.83	0.42	1.76	24	8		
	A413810	10	89	1.04	0.53	2.20	30	10		
	A413812	12	100	0.75	0.63	2.64	36	12		
	A413816	16	110	1.00	0.84	3.52	48	16		

D mm	Rp mm	Ap max mm	
6	0.63	0.32	
8	0.83	0.42	
10	1.04	0.53	
12	1.24	0.63	
16	1.66	0.84	

		Profiling		Slotting	RANGE							
					A4138							
Material	Feature	Ap	Ae	Ap	Vc m/min. min.	Vc m/min. max.	fz/mm	D/mm 6	D/mm 8	D/mm 10	D/mm 12	D/mm 16
CARBON STEEL	< 850 N/mm²	0.025 x D	0.5 x D	0.025 x D	120	145	fz/mm	0.136	0.210	0.290	0.360	0.450
	< 1200 N/mm²	0.025 x D	0.5 x D	0.025 x D	95	125	fz/mm	0.136	0.210	0.290	0.360	0.450
HARDENED	< 56 HRC	0.025 x D	0.5 x D	0.025 x D	60	70	fz/mm	0.105	0.165	0.215	0.265	0.340
	< 62 HRC	0.025 x D	0.5 x D	0.025 x D	35	55	fz/mm	0.105	0.165	0.215	0.265	0.340

Recommended "fz" values for profiling. For slotting $Ap < 0,025 \times D$ $Ae = 1 \times D$. Adjust cutting parameters. (ex: Vc X 0,8 fz X 0,75)