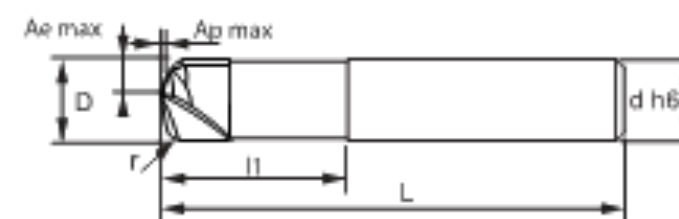




ITEM: A4140

Material Micro-grain carbide
Standard Factory standard
Tolerance e8
Shank Cylindrical with nacked shank
Helix 0° right-hand
Surface treatment PRO 100
Application Roughing of 3D surfaces on hardened materials up to 52 HRC.



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

FACTORY STANDARD

A4140	Tech. Code		D mm	L mm	l1 mm	r mm	Rp mm	Ae max mm	Ap max mm	d mm	Z	
MULTI - 0°	A41400314		3	53	14	0,75	0,70	1,5	0,20	3	2	1
	A41400326				26							
	A41400419		4		19	1,0	0,85	2	0,27	4		
	A41400435				64							
	A41400524		5	53	24	1,25	1,20	2,5	0,34	5		
	A41400544			80	44							
	A41400629		6	53	29	1,50	1,40	3	0,40	6		
	A41400653			80	53							
	A41400838		8	64	38	2,0	1,95	4	0,54	8		
	A41400858			106	58							
	A41401048		10	80	48	2,5	2,30	5	0,68	10		
	A41401060			106	60							
	A41401252		12	80	52	3,0	2,85	6	0,81	12		

D mm	Rp mm	Ap max mm	
3	0.70	0.20	
4	0.85	0.27	
5	1.20	0.34	
6	1.40	0.40	
8	1.95	0.54	
10	2.30	0.68	
12	2.85	0.81	

		Profiling		Slotting	RANGE									
					A4140									
Material	Feature	Ap	Ae	Ap	Vc m/min. min.	Vc m/min. max.	mm	D/mm 3	D/mm 4	D/mm 5	D/mm 6	D/mm 8	D/mm 10	D/mm 12
CARBON STEEL	<850 N/mm²	0,025 x D	0,55 x D	0,025 x D	260	300	fz/mm	0.15	0.15	0.16	0.20	0.28	0.33	0.38
	<1200 N/mm²	0,025 x D	0,55 x D	0,025 x D	190	265	fz/mm	0.14	0.14	0.15	0.18	0.25	0.30	0.35
STAINLESS STEEL	<800 N/mm²	0,025 x D	0,55 x D	0,025 x D	125	150	fz/mm	0.15	0.15	0.16	0.20	0.26	0.30	0.35
	DUPLEX	0,025 x D	0,55 x D	0,025 x D	110	135	fz/mm	0.14	0.14	0.15	0.18	0.24	0.28	0.32
SUPER ALLOY	Ti6Al4V	0,025 x D	0,55 x D	0,025 x D	75	125	fz/mm	0.12	0.12	0.13	0.16	0.20	0.26	0.30
HARDENED	<52 HRC	0,025 x D	0,55 x D	0,025 x D	60	70	fz/mm	0.14	0.14	0.15	0.18	0.22	0.28	0.32

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