

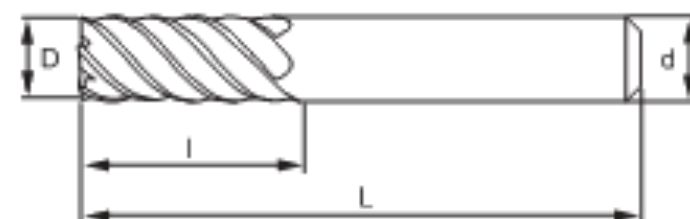
KERFOLG® MULTI FLUTE SUPER FINISHING END MILLS - CENTRE CUTTING



HD

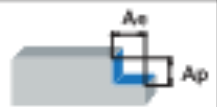
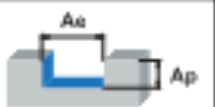
ITEM: A4215

Material Micro-grain carbide
Standard DIN 6527
Tolerance H10
Shank Cylindrical
Helix 45° right-hand
Surface treatment WIND
Application Super-finishing, side milling on materials up to 64 HRC



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

DIN 6527								
A4215	Tech. Code		D mm	L mm	l mm	d mm	Z	
MULTI - 45°	A42156		6	57	13	6	6	1
	A42158		8	63	19	8		
	A421510		10	72	22	10	8	
	A421512		12	83	26	12		
	A421516		16	92	32	16	10	

		Side Milling		Slotting	RANGE										
					A4215										
Material	Feature	Ap	Ae	Ap	Vc m/min. min.	Vc m/min. max.	mm	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	2.0 x D	0.05 x D	-	170	210	fz/mm	0.010	0.020	0.025	0.035	0.044	0.052	0.063	0.080
	< 850 N/mm²	2.0 x D	0.05 x D	-	155	190	fz/mm	0.010	0.020	0.022	0.032	0.038	0.046	0.054	0.066
	< 1200 N/mm²	2.0 x D	0.05 x D	-	95	135	fz/mm	0.007	0.014	0.017	0.024	0.030	0.036	0.045	0.057
STAINLESS STEEL	< 600 N/mm²	2.0 x D	0.05 x D	-	90	115	fz/mm	0.010	0.020	0.024	0.032	0.038	0.046	0.054	0.066
	< 800 N/mm²	2.0 x D	0.05 x D	-	75	95	fz/mm	0.007	0.014	0.017	0.024	0.030	0.036	0.045	0.057
CAST IRON	< 240 HB	2.0 x D	0.05 x D	-	220	270	fz/mm	0.010	0.020	0.025	0.032	0.039	0.048	0.058	0.073
	< 300 HB	2.0 x D	0.05 x D	-	200	250	fz/mm	0.010	0.020	0.024	0.030	0.038	0.046	0.054	0.066
SUPER ALLOY	Ti6Al4V	2.0 x D	0.05 x D	-	65	90	fz/mm	0.006	0.014	0.017	0.024	0.030	0.036	0.045	0.057
	HTA	2.0 x D	0.05 x D	-	45	65	fz/mm	0.004	0.010	0.013	0.019	0.025	0.030	0.038	0.045
HARDENED	< 45 HRC	2.0 x D	0.05 x D	-	55	90	fz/mm	0.003	0.009	0.011	0.016	0.021	0.026	0.032	0.038
	< 64 HRC	1.5 x D	0.03 x D	-	45	65	fz/mm	0.003	0.007	0.009	0.014	0.018	0.022	0.027	0.033

Recommended "fz" values for side milling.