

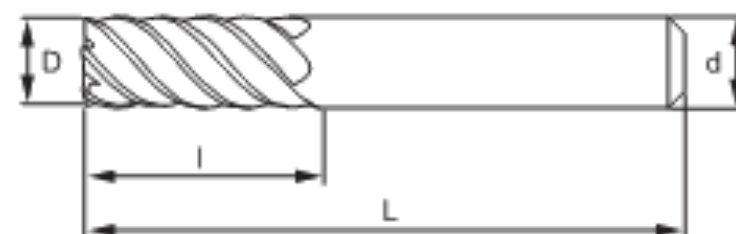
KERFOLG® MULTI FLUTE SUPER FINISHING END MILLS - CENTRE CUTTING



HD

ITEM: A4220

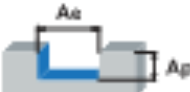
Material Micro-grain carbide
Standard Factory standard
Tolerance H10
Shank Cylindrical
Helix 45° right-hand
Surface treatment WIND
Application Super-finishing side milling on materials up to 64 HRC.



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

FACTORY STANDARD

A4220	Tech. Code		D mm	L mm	l mm	d mm	Z	
MULTI - 45°	A42204		4	63	19	6	6	1
	A42205		5	68	24			
	A42206		6					
	A42208		8	88	38	8	8	
	A422010		10	95	45	10		
	A422012		12	110	53	12		
	A422014		14			14	10	
	A422016		16	123	63	16		
	A422020		20	141	75	20	12	

		Side Milling		Slotting	RANGE										
					A4220										
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.