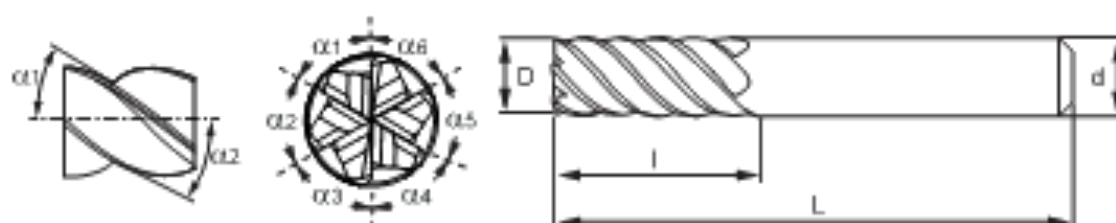


KERFOLG® SUPER FINISHING END MILLS



ITEM: A4240

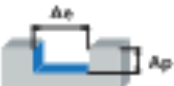
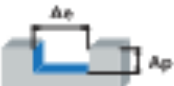
Material Micro-grain Integral hard metal
Standard Factory standard
Tolerance f8
Shank Cylindrical
Helix Right-hand variable angle
Surface treatment TiAlCN
Application Finishing and superfinishing on carbon steel, stainless steel, cast iron and super alloys



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

FACTORY STANDARD

A4240	Tech. Code		D mm	L mm	l mm	d mm	Z	
MULTI - VARIABLE	A424006		6	80	33	6	6	1
	A424008		8	100	40	8		
	A424010		10		55	10		
	A424012		12	120	65	12		
	A424016		16	150	85	16	8	
	A424020		20	160	100	20		

		Side Milling		Slotting	RANGE								
					A4240								
Material	Feature	Ap	Ae	Ap	Vc m/min. min.	Vc m/min. max.	mm	D/mm 6	D/mm 8	D/mm 10	D/mm 12	D/mm 16	D/mm 20
CARBON STEEL	< 500 N/mm²	2 x D	0.05 x D	-	180	220	fz/mm	0.035	0.045	0.060	0.070	0.095	0.110
	< 850 N/mm²	2 x D	0.05 x D	-	155	190	fz/mm	0.030	0.040	0.050	0.060	0.076	0.085
	< 1200 N/mm²	2 x D	0.05 x D	-	120	160	fz/mm	0.025	0.035	0.045	0.050	0.065	0.075
STAINLESS STEEL	< 600 N/mm²	2 x D	0.05 x D	-	90	130	fz/mm	0.025	0.035	0.045	0.050	0.065	0.075
	< 800 N/mm²	2 x D	0.05 x D	-	70	90	fz/mm	0.025	0.035	0.045	0.050	0.065	0.075
	DUPLEX	2 x D	0.05 x D	-	85	100	fz/mm	0.025	0.035	0.045	0.050	0.065	0.075
SUPER ALLOY	Ti6Al4V	2 x D	0.05 x D	-	85	100	fz/mm	0.025	0.035	0.045	0.050	0.065	0.075
	HTA	2 x D	0.05 x D	-	30	55	fz/mm	0.020	0.025	0.030	0.035	0.045	0.055
HARDENED	< 45 HRC	2 x D	0.05 x D	-	80	105	fz/mm	0.025	0.035	0.045	0.050	0.065	0.075

Recommended "fz" values for side milling.