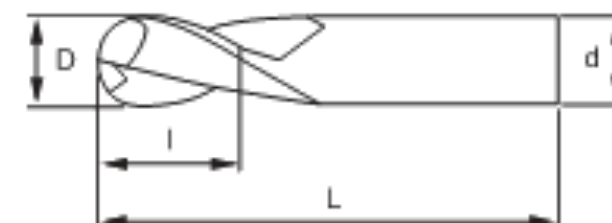


BALL NOSE END MILLS Z2



ITEM: A4315

Material Micro-grain carbide
Standard Factory standard
Tolerance D ≤ 1mm - ~0.019mm
D 1~ 6mm - ~ 0.02mm
D > 6 ~20mm - ~ 0.025mm
Shank Cylindrical / Weldon
Helix 30° right-hand
Surface treatment WIND
Application Copying, semi-finishing and finishing.



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

On request available with Weldon shank at a cost of € 2.
Cylindrical shank (A4315....) Weldon shank (A4315...W)

FACTORY STANDARD

A4315	Tech. Code	D mm	L mm	I mm	d mm	Z	
2T - 30°	A43151	1	50	2	6	2	1
	A43151,5	1,5		3			
	A43152	2		4			
	A43152,5	2,5		5			
	A43153	3		6			
	A43154	4		8			
	A43155	5		10			
	A43156	6		12			

		Profiling		Slotting	RANGE									
					A4315									
Material	Feature	Ap	Ae	Ap	Vc m/min. min.	Vc m/min. max.	mm	D/mm 2	D/mm 3	D/mm 4	D/mm 6	D/mm 8	D/mm 10	D/mm 12
CARBON STEEL	< 500 N/mm²	0.05 x D	0.05 x D	0.4 x D	90	115	fz/mm	0.012	0.016	0.025	0.031	0.042	0.053	0.063
	< 850 N/mm²	0.05 x D	0.05 x D	0.4 x D	80	110	fz/mm	0.010	0.015	0.023	0.027	0.035	0.050	0.059
	< 1200 N/mm²	0.05 x D	0.05 x D	-	70	95	fz/mm	0.008	0.010	0.018	0.025	0.032	0.044	0.052
STAINLESS STEEL	< 600 N/mm²	0.05 x D	0.05 x D	0.3 x D	70	85	fz/mm	0.008	0.015	0.023	0.027	0.035	0.050	0.059
	< 800 N/mm²	0.05 x D	0.05 x D	-	55	70	fz/mm	0.007	0.010	0.018	0.025	0.032	0.044	0.052
CAST IRON	< 240 HB	0.05 x D	0.05 x D	0.4 x D	80	105	fz/mm	0.010	0.016	0.022	0.030	0.042	0.053	0.063
	< 300 HB	0.05 x D	0.05 x D	0.3 x D	70	90	fz/mm	0.008	0.015	0.020	0.029	0.040	0.050	0.059
HARDENED	< 45 HRC	0.03 x D	0.03 x D	-	35	45	fz/mm	0.006	0.010	0.016	0.025	0.032	0.039	0.048

Recommended "fz" values for finishing.

For semi-finishing, adjust the cutting parameters. (ex: Ap = 0.2 x D Ae = 0.1 x D fz x 1.8)