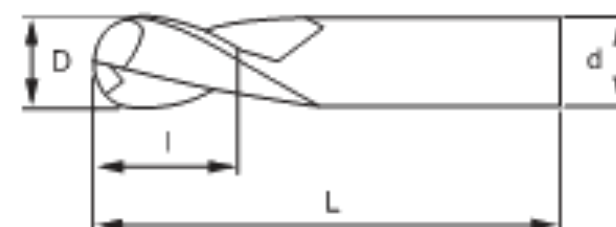


KERFOLG® BALL NOSE END MILLS Z2



ITEM: A4318

Material Micro-grain carbide
Standard Factory standard
Tolerance h10
Shank Cylindrical
Helix Right-hand 30°
Surface treatment TiAlN
Application Copying, semi-finishing and finishing on materials up to 55 HRC.



< 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 (A4318....) Weldon shank (A4318...W)

FACTORY STANDARD								
A4318	Tech. Code		D mm	L mm	l mm	d mm	Z	
2T - 30°	A431802		2	38	7	3	2	1
	A431803		3	57	8	6		
	A431804		4		11			
	A431805		5		13			
	A431806		6					
	A431808		8	63	19	8		
	A431810		10	72	22	10		
	A431812		12	83	26	12		
	A431816		16	92	32	16		
	A431820		20	104	38	20		

		Profiling		Slotting	RANGE									
					A4318									
Material	Feature	Ap	Ae	Ap	Vc m/min. min.	Vc m/min. max.	mm	D/mm 3	D/mm 4	D/mm 6	D/mm 8	D/mm 10	D/mm 12	D/mm 16
CARBON STEEL	< 850 N/mm²	0.3 x D	0.7 x D	0.2 x D	100	120	fz/mm	0.010	0.019	0.031	0.037	0.046	0.060	0.069
	< 1200 N/mm²	0.3 x D	0.7 x D	0.2 x D	80	100	fz/mm	0.008	0.015	0.025	0.030	0.037	0.041	0.047
CAST IRON	< 240 HB	0.3 x D	0.7 x D	-	140	160	fz/mm	0.020	0.030	0.050	0.060	0.074	0.084	0.120
	< 300 HB	0.3 x D	0.7 x D	-	100	140	fz/mm	0.016	0.024	0.040	0.048	0.059	0.064	0.095
HARDENED	< 55 HRC	0.3 x D	0.7 x D	-	30	60	fz/mm	0.008	0.012	0.020	0.025	0.030	0.035	0.040

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)