

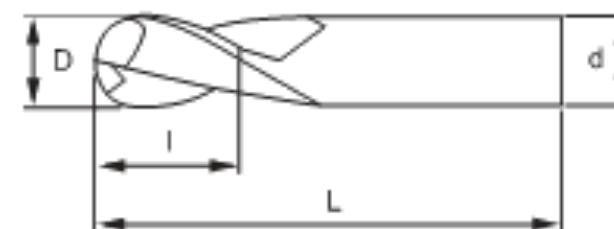
KERFOLG® BALL NOSE END MILLS Z2



HD

ITEM: A4330

Material Micro-grain carbide
Standard Factory standard
Tolerance D ≤ 1mm - ~ 0.019mm
D 1~ 6mm - ~ 0.02mm
D > 6 ~20mm - ~ 0.025mm
Shank Cylindrical
Helix 30° right-hand
Surface treatment WIND X
Application Copying, semi-finishing and finishing on materials up to 65 HRC.



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

FACTORY STANDARD

A4330	Tech. Code		D mm	L mm	l mm	d mm	Z	
2T - 30°	A43301		1	50	1.5	4	2	1
	A43301,5		1.5		2.5			
	A43302		2		3			
	A43302,5		2.5		4			
	A43303		3		5			
	A43304		4		6			
	A43305		5		8			
	A43306		6		9			
	A43307		7	14	8			
	A43308		8	16				
	A43309		9	18	10			
	A433010		10	20				
	A433012		12	24	12			
	A433014		14		16			
	A433016		16					

		Profiling		Slotting	RANGE										
					A4330										
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	D/mm 16
CARBON STEEL	< 1200 N/mm²	0.03 x D	0.02 x D	-	280	380	fz/mm	0.022	0.030	0.040	0.060	0.080	0.100	0.150	0.200
HARDENED	< 45 HRC	0.03 x D	0.02 x D	-	210	250	fz/mm	0.020	0.028	0.037	0.056	0.075	0.090	0.135	0.175
	< 65 HRC	0.02 x D	0.02 x D	-	130	165	fz/mm	0.016	0.022	0.030	0.050	0.062	0.080	0.100	0.150

Recommended "fz" values for finishing.
For semi-finishing, adjust the cutting parameters. (ex: Ap = 0.1 x D Ae = 0.1 x D fz x 1.5)