

KERFOLG FLAT MICRO END MILLS Z2



HD

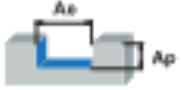
ITEM: A4415

Material Micro-grain carbide
Standard Factory standard
Tolerance D ≤ 1mm - ~ 0.005/0.025mm
D > 1mm - ~ 0.001/0.025mm
Shank Cylindrical
Helix 35° right-hand
Surface treatment WIND X
Application Finishing and semi-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								
A4415	Tech. Code		D mm	L mm	l mm	d mm	Z	
2T - 35°	A44150,2		0.2	50	0.4	4	2	1
	A44150,3		0.3		0.6			
	A44150,4		0.4		0.8			
	A44150,5		0.5		1.0			
	A44150,6		0.6		1.2			
	A44150,7		0.7		1.4			
	A44150,8		0.8		1.6			
	A44150,9		0.9		1.8			
	A44151		1		2.0			
	A44151,1		1.1		2.5			
	A44151,2		1.2					
	A44151,3		1.3		3.0			
	A44151,4		1.4					
	A44151,5		1.5		3.5			
	A44151,6		1.6					
	A44151,7		1.7		4.0			
	A44151,8		1.8					
	A44151,9		1.9		5.0			
	A44152		2					
	A44152,5		2.5		6.0			
	A44153		3					

		Side Milling		Slotting	RANGE												
					A4415												
Material	Feature	Ap	Ae	Ap	Vc m/min. min.	Vc m/min. max.	mm	D/mm 0.2	D/mm 0.4	D/mm 0.6	D/mm 0.8	D/mm 1.0	D/mm 1.2	D/mm 1.5	D/mm 2.0	D/mm 2.5	D/mm 3.0
CARBON STEEL	< 1200 N/mm²	1 x D	0.05 x D	0.025 x D	250	375	fz/mm	0.002	0.006	0.011	0.015	0.018	0.019	0.023	0.030	0.038	0.046
HARDENED	< 45 HRC	1 x D	0.05 x D	0.025 x D	140	230	fz/mm	0.002	0.005	0.010	0.013	0.016	0.017	0.021	0.027	0.034	0.041
	< 65 HRC	1 x D	0.05 x D	0.025 x D	100	155	fz/mm	0.002	0.004	0.009	0.011	0.014	0.015	0.018	0.024	0.030	0.036

Recommended "fz" values for side milling.
For slotting, adjust the cutting parameters. (ex: fz x 0.8)