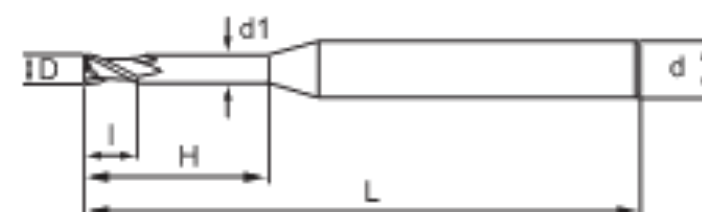


KERFOLG® FLAT MICRO END MILLS Z2



ITEM: A4420

Material Micro-grain carbide
Standard Factory standard
Tolerance D ≤ 1mm - ~ 0.005/0.025mm
D > 1 ~ 4mm - ~ 0.001/0.025mm
Shank Cylindrical with neck
Helix 35° right-hand
Surface treatment WIND +
Application Finishing and semifinishing on materials up to 60 HRC.



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

FACTORY STANDARD

A4420	Tech. Code		D mm	d1 mm	L mm	l mm	H mm	d mm	Z	
2T - 35°	A44200,52		0.5	0.46	50	1	2	4	2	1
	A44200,54						4			
	A44200,56						6			
	A442016		1	0.95		1.5	8			
	A442018						10			
	A4420110						12			
	A4420112		1.5	1.44		2	8			
	A44201,58						10			
	A44201,510						12			
	A44201,512						16			
	A44201,516		2	1.92		3	8			
	A442028						10			
	A4420210						12			
	A4420212						16			
	A4420216						20			
	A4420220						10			
	A44202,510		2.5	2.4		4	12			
	A44202,512						16			
	A44202,516						20			
	A44202,520				10					
	A4420310		3	2.9	60	4	12			
	A4420312						16			
	A4420316						20			
	A4420320						25			
A4420325										

		Side Milling		Slotting	RANGE													
					A4420													
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	D/mm 4.0
CARBON STEEL	< 850 N/mm²	1 x D	0.5 x D	0.025 x D	200	320	fz/mm	0.002	0.006	0.011	0.015	0.018	0.019	0.023	0.030	0.038	0.046	0.055
	< 1200 N/mm²	1 x D	0.5 x D	0.025 x D	180	260	fz/mm	0.002	0.005	0.010	0.013	0.016	0.017	0.021	0.027	0.034	0.041	0.052
HARDENED	< 45 HRC	1 x D	0.5 x D	0.025 x D	75	140	fz/mm	0.002	0.004	0.009	0.011	0.014	0.015	0.018	0.024	0.030	0.036	0.043
	< 60 HRC	1 x D	0.5 x D	0.025 x D	50	115	fz/mm	0.002	0.004	0.008	0.010	0.013	0.014	0.017	0.022	0.028	0.033	0.040

Recommended "fz" values for side milling with H < 3 x D sized tools.
As for H > 3 x D, adjust cutting parameters (ex. fz x 0.7)
For slotting, adjust the cutting parameters. (ex: fz x 0.8)