

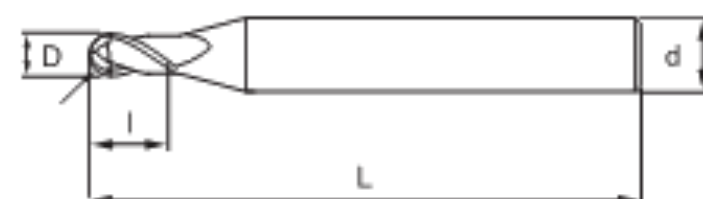
KERFOLG® BALL NOSE MICRO END MILLS Z2



HD

ITEM: A4427

Material Micro-grain carbide
Standard Factory standard
Tolerance D ≤ 1mm - ~ 0.005/0.025mm
D 1~ 4mm - ~ 0.001/0.025mm
Shank Cylindrical
Helix 30° 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

A4427	Tech. Code	D mm	L mm	l mm	d mm	Z	
2T - 30°	A44270,3	0.3	50	0.6	4	2	1
	A44270,4	0.4		0.8			
	A44270,5	0.5		1			
	A44270,6	0.6		1.2			
	A44270,7	0.7		1.4			
	A44270,8	0.8		1.6			
	A44270,9	0.9		1.8			
	A44271	1		2			
	A44271,2	1.2		2.4			
	A44271,5	1.5		3			
	A44272	2		4			
	A44273	3		6			
	A44274	4		8			

		Profiling		Slotting	RANGE													
					A4427													
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	< 1200 N/mm²	0.05 x D	0.05 x D	0.25 x D	250	375	fz/mm	0.008	0.009	0.012	0.015	0.023	0.030	0.036	0.048	0.060	0.072	0.100
HARDENED	< 45 HRC	0.05 x D	0.05 x D	0.25 x D	140	230	fz/mm	0.006	0.006	0.008	0.010	0.015	0.023	0.028	0.036	0.050	0.062	0.085
	< 60 HRC	0.05 x D	0.05 x D	0.25 x D	100	155	fz/mm	0.005	0.005	0.006	0.008	0.012	0.018	0.024	0.032	0.041	0.050	0.075

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)