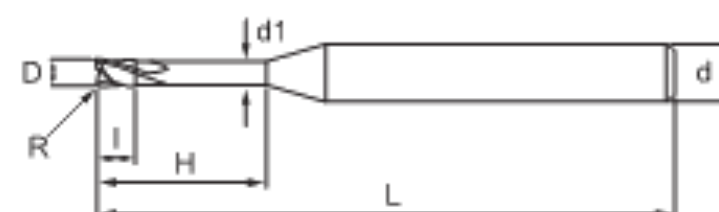


KERFOG CORNER RADIUS MICRO END MILLS Z2



ITEM: A4435

Material Micro-grain carbide
Standard Factory standard
Tolerance h8
Shank Cylindrical with reduced neck
Helix 30° right-hand
Surface treatment WIND
Application Finishing and semi-finishing 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												
A4435	Tech. Code		D mm	R mm	L mm	l mm	H mm	d1 mm	d mm	Z		
2T - 30°	A44350,54		0.5	0.1	50	1	4	0.48	4	2	1	
	A44350,66		0.6				6	0.58				
	A44350,84		0.8				4	0.77				
	A44350,86						6					
	A443516		1			0.8	10	0.95				
	A4435110						16					
	A4435116						20					
	A4435120						55					1.1
	A44351,212		1.2			50	1.35	8				1.44
	A44351,58		1.5			55		12				
	A44351,512			60	20	1.73						
	A44351,520		1.8	0.15	1.6	1.7		1.92				
	A44351,820											
	A443526		2		0.2		6		2.4			
	A443528						8					
	A4435210						10					
	A4435212						12					
	A4435216						16					
	A4435220						20					
	A4435225						25					
	A4435230						30					
	A44352,513		2.5	0.25	58	2	13	2.85				
	A4435310		3	0.3	65	2.5	10					
	A4435312					3	12					
	A4435316					4	16					
	A4435320					20						
	A4435335				80	2.5	35					
	A4435412				4	0.4	58		4.5			12
	A4435420		65	5			20					
	A4435435		80	3			35					
	A4435540		5	3.5			40	4.9				
	A4435650		6	0.5	100	6	50	5.9				

		Profiling		Slotting	RANGE													
					A4435													
Material	Feature	Ap	Ae	Ap	Vc m/min. min.	Vc m/min. max.	mm	D/mm 0.5	D/mm 0.5	D/mm 1.0	D/mm 1.0	D/mm 1.5	D/mm 1.5	D/mm 2.0	D/mm 2.0	D/mm 2.5	D/mm 2.5	D/mm 3.0
CARBON STEEL	< 850 N/mm²	1.0 x D	0.2 x D	0.20 x D	200	320	fz/mm	0.003	0.004	0.005	0.007	0.008	0.010	0.016	0.022	0.048	0.038	0.048
	< 1200 N/mm²	1.0 x D	0.2 x D	0.15 x D	180	260	fz/mm	0.003	0.003	0.004	0.006	0.007	0.009	0.014	0.020	0.045	0.036	0.045
HARDENED	< 45 HRC	0.5 x D	0.2 x D	0.10 x D	75	140	fz/mm	0.002	0.003	0.004	0.006	0.007	0.009	0.011	0.016	0.040	0.030	0.040
	< 60 HRC	0.5 x D	0.2 x d	0.10 x D	50	115	fz/mm	0.002	0.003	0.003	0.005	0.006	0.008	0.010	0.013	0.035	0.026	0.035

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