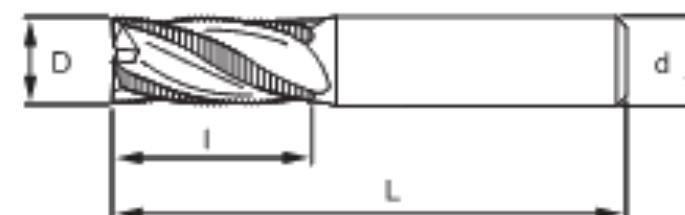




ITEM: A4507

Material Micro-grain carbide
 Standard Factory standard
 Tolerance h11
 Shank Cylindrical / Weldon
 Helix 45° right-hand
 Surface treatment WIND
 Application Roughing and side milling on carbon steels up to 55 HRC, stainless steel, titanium alloy and HTA.



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

On request available with Weldon shank at a cost of € 2.

Cylindrical shank (A4507....) Weldon shank (A4507...W)

FACTORY STANDARD

A4507	Tech. Code		D mm	L mm	l mm	d mm	Z	
MULTI - 45°	A450703		3	57	8	6	3	1
	A450704		4		12		4	
	A450705		5					
	A450706		6	13		8		
	A450707		7		63			
	A450708		8					
	A450709		9	70		16	10	
	A450710		10					
	A450711		11		75			
	A450712		12					
	A450714		14	92		32	16	
	A450715		15					
	A450716		16		6			
	A450720		20	104		38	20	

		Side Milling		Slotting	RANGE											
					A4507											
Material	Feature	Ap	Ae	Ap	Vc m/min. min.	Vc m/min. max.	mm	D/mm 3	D/mm 4	D/mm 5	D/mm 6	D/mm 8	D/mm 10	D/mm 12	D/mm 16	D/mm 20
CARBON STEEL	< 500 N/mm²	1.5 x D	0.3 x D	1.0 x D	115	160	fz/mm	0.016	0.020	0.026	0.031	0.042	0.059	0.072	0.088	0.100
	< 850 N/mm²	1.5 x D	0.3 x D	1.0 x D	80	125	fz/mm	0.015	0.018	0.025	0.029	0.035	0.053	0.063	0.079	0.090
	< 1200 N/mm²	1.5 x D	0.3 x D	0.5 x D	70	105	fz/mm	0.012	0.016	0.022	0.027	0.032	0.050	0.059	0.072	0.080
STAINLESS STEEL	< 600 N/mm²	1.0 x D	0.3 x D	0.5 x D	45	75	fz/mm	0.016	0.018	0.025	0.031	0.035	0.054	0.063	0.080	0.090
	< 800 N/mm²	1.0 x D	0.3 x D	0.5 x D	35	70	fz/mm	0.012	0.014	0.022	0.027	0.032	0.050	0.052	0.072	0.082
CAST IRON	< 240 HB	1.5 x D	0.3 x D	1.0 x D	80	120	fz/mm	0.016	0.019	0.026	0.033	0.047	0.060	0.074	0.090	0.110
	< 300 HB	1.5 x D	0.3 x D	1.0 x D	70	100	fz/mm	0.015	0.018	0.024	0.029	0.045	0.054	0.065	0.082	0.100
SUPERALLOY	Ti6Al4V	0.5 x D	0.3 x D	0.3 x D	35	50	fz/mm	0.010	0.015	0.022	0.027	0.035	0.044	0.052	0.063	0.080
	HTA	0.5 x D	0.3 x D	0.3 x D	15	30	fz/mm	0.009	0.013	0.020	0.025	0.032	0.039	0.046	0.058	0.072

Recommended "fz" values for side milling.

For slotting, adjust the cutting parameters. (ex: fz x 0.8)