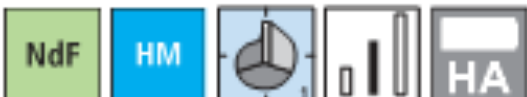


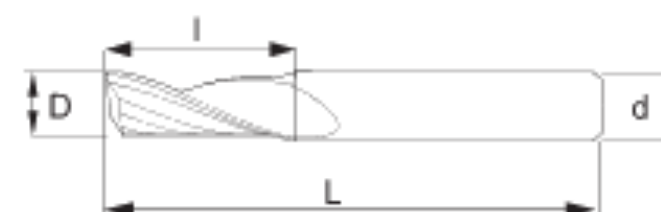
KERFOLG® END MILLS FOR ALUMINUM ALLOYS Z1



ALU

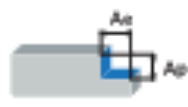
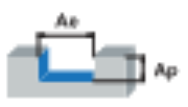
ITEM: A4710

Material: Micro-grain carbide
 Standard: Factory standard
 Shank: Cylindrical
 Helix: 25° right-hand - right-cut
 Surface treatment: Bright
 Application: Machining aluminum alloys and plastic material applications



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

FACTORY STANDARD								
A4710	Tech. Code		D mm	L mm	l mm	d mm	Z	
1T - 25°	A47101,5		1.50	40	6	3	1	1
	A4710210		2.00		60	10		
	A47102			2.50		40		
	A471026		3.00		60			
	A47102,5			4.00		60		
	A47103		5.00		60			
	A4710310			6.00		60		
	A4710312		7.00		60			
	A4710315			8.00		60		
	A47104		9.00		60			
	A4710412			10.00		60		
	A4710415		11.00		60			
	A4710420			12.00		60		
	A47105		13.00		60			
	A4710516			14.00		60		
	A4710528		15.00		60			
	A47106			16.00		60		
	A4710630		17.00		60			
	A4710635			18.00		60		
	A47108		19.00		60			
	A4710830			20.00		60		
	A4710840		21.00		60			
	A471010			22.00		60		
	A47101055		23.00		60			
	A471012			12.00		83		

		Side Milling		Slotting	RANGE									
					A4710									
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
NON FERROUS	ALU < 10% Si	0.5 x D	0.5 x D	0.5 x D	300	500	fz/mm	0.040	0.050	0.060	0.070	0.080	0.085	0.090

Recommended "fz" values for slotting.