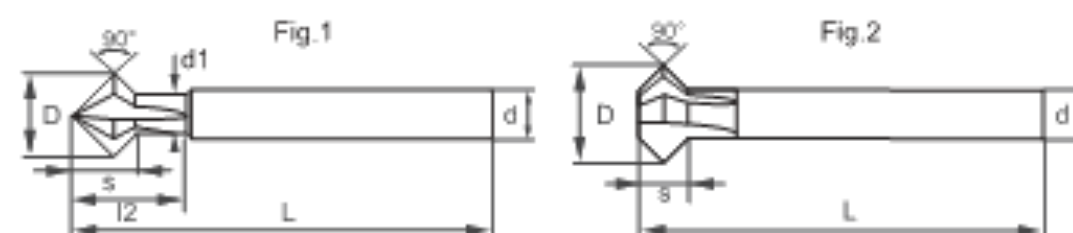


KERFOLG FORWARD AND BACKWARD CHAMFER END MILLS - 45°



ITEM: A4715

Material	Micro-grain carbide
Standard	Factory standard
Shank	Cylindrical / Weldon
Surface treatment	WIND
Application	45° forward and backward chamfering. Circular interpolation applications. For all materials.



On request available with Weldon shank at a cost of € 2.
Cylindrical shank (A4715....) Weldon shank (A4715...W)

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

FACTORY STANDARD

A4715	Tech. Code		D mm	L mm	d1 mm	l2 mm	s mm	d mm	Fig.	Z	
41	A47153		3	75	2.2	12	2	4	1	4	1
	A47154		4		2.9	15,7	2,7				
	A47155		5		3.9	18	3	5			
	A47156		6	19		4	6	2			
	A47158		8	100	-	-			2		
	A471510		10						4		
	A471512		12						6		

		Side Milling		Slotting	RANGE						
				A4715							
Material	Feature	Ap	As	Ap	Vc m/min. min.	Vc m/min. max.	mm	D/mm 6	D/mm 8	D/mm 10	D/mm 12
CARBON STEEL	< 500 N/mm²	0.1 x D	0.1 x D	-	70	80	fz/mm	0.015	0.020	0.025	0.030
	< 850 N/mm²	0.1 x D	0.1 x D	-	55	65	fz/mm	0.015	0.020	0.025	0.030
	< 1200 N/mm²	0.1 x D	0.1 x D	-	45	55	fz/mm	0.012	0.017	0.020	0.026
CAST IRON	< 240 HB	0.1 x D	0.1 x D	-	65	75	fz/mm	0.015	0.020	0.025	0.032
	< 300 HB	0.1 x D	0.1 x D	-	45	60	fz/mm	0.012	0.017	0.020	0.024

Recommended "fz" values for side milling.
Diameter values to be considered as effective work diameters.