

KERFOLG CORNER - ROUNDING END MILLS



ITEM: A4720

Material Micro-grain carbide
Standard Factory standard
Shank Cylindrical / Weldon
Surface treatment WIND
Application Corner rounding operations on all materials.



On request available with Weldon shank at a cost of € 2.
 Cylindrical shank (A4720....) Weldon shank (A4720...W)

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

FACTORY STANDARD

A4720	Tech. Code		D mm	R mm	L mm	d mm	Z	
4T	A4720101		10	1.0	50	10	4	1
	A4720101,5			1.5				
	A4720102			2.0				
	A4720102,5			2.5				
	A4720123		12	3.0	60			
	A4720124			4.0				
	A4720165		16	5.0	75			
	A4720166			6.0				

		Side Milling		Slotting	RANGE						
					A4720						
Material	Feature	Ap	Ae	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	1 x r	1 x r	-	70	80	fz/mm	0.015	0.020	0.025	0.030
	< 850 N/mm²	1 x r	1 x r	-	55	65	fz/mm	0.015	0.020	0.025	0.030
	< 1200 N/mm²	1 x r	1 x r	-	45	55	fz/mm	0.012	0.017	0.020	0.026
CAST IRON	< 240 HB	1 x r	1 x r	-	65	75	fz/mm	0.015	0.020	0.025	0.032
	< 300 HB	1 x r	1 x r	-	45	60	fz/mm	0.012	0.017	0.020	0.024

Recommended "fz" values for side milling.