

KERFOLG CHAMFER END MILLS Z4 - 90°

Speedy



ITEM: A4723

Material Micro-grain carbide
Standard Factory standard
Shank Cylindrical / Weldon
Helix 0° right-hand
Surface treatment TiAlN
Application Holes, shafts, and straight walls chamfering and deburring. For all materials.



On request available with Weldon shank at a cost of € 2.
 Cylindrical shank (A4723....) Weldon shank (A4723...W)

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

FACTORY STANDARD						
A4723	Tech. Code		D mm	L mm	d mm	Z
4T-0°	A47236		6	60	6	4
	A47238		8	70	8	
	A472310		10	75	10	
	A472312		12		12	
	A472316		16	80	16	

		Side Milling		Slotting	RANGE						
					A4723						
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	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.