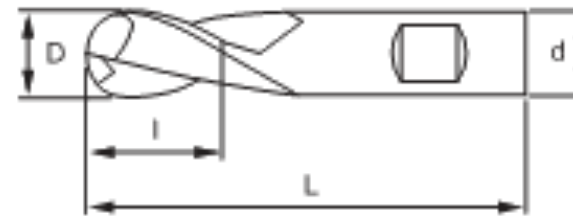


BALL NOSE END MILLS Z2



ITEM: A5040 - A5045

Material High speed steel Co8
Standard DIN 327 B
Tolerance h7
Shank Weldon
Helix 30° right-hand
Surface treatment Bright / Wind
Application Copying



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

DIN 327 B

	Tech. Code A5040			Tech. Code A5045			D mm	L mm	l mm	d mm	Z	
2T - 30°	...2	BRIGHT		...2	WIND		2	49	4	6	2	1
	...3			...3			3		5			
	...4			...4			4		7			
	...5			...5			5	52	8			
	...6			...6			6					
	...8			...8			8	61	11	10		
	...10			...10			10	63	13			
	...12			...12			12	73	16	12		
	...14			...14			14					
	...16			...16			16	79	19	16		
...20		...20		20	88	22	20					

		Profiling		Slotting	RANGE										
					A5040						A5045				
Material	Feature	Ap	Ae	Ap	Vc m/min. min.	Vc m/min. max.	mm	D/mm 2	D/mm 3	D/mm 4	D/mm 6	D/mm 8	D/mm 10	D/mm 12	D/mm 16
CARBON STEEL	< 500 N/mm²	0.3 x D	0.7 x D	-	20	35	fz/mm	0.020	0.024	0.031	0.046	0.062	0.072	0.079	0.097
	< 850 N/mm²	0.3 x D	0.7 x D	-	20	28	fz/mm	0.015	0.019	0.026	0.038	0.052	0.061	0.067	0.084
	< 1200 N/mm²	0.3 x D	0.7 x D	-	15	22	fz/mm	0.012	0.016	0.021	0.031	0.042	0.048	0.054	0.067
STAINLESS STEEL	< 600 N/mm²	0.3 x D	0.7 x D	-	10	14	fz/mm	0.012	0.016	0.021	0.031	0.042	0.048	0.054	0.067
	< 800 N/mm²	0.3 x D	0.7 x D	-	8	10	fz/mm	0.010	0.013	0.018	0.026	0.035	0.040	0.045	0.055

Recommended "fz" values for profiling.