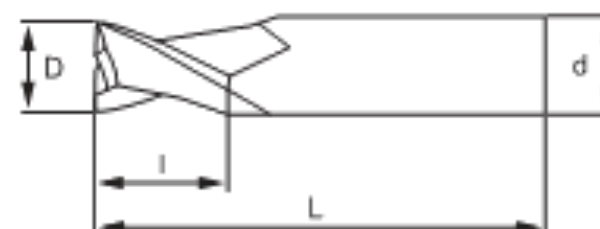


KERFOLG END MILLS FOR SLOTTING Z2



ITEM: A4012

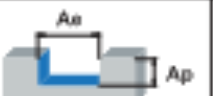
Material Micro-grain carbide
Standard DIN 6528
Tolerance h10
Shank Cylindrical / Weldon
Helix Right-hand 30°
Surface treatment TiAlN
Application Slotting on materials up to 50 HRC



On request available with Weldon shank at a cost of € 2.
Cylindrical shank (A4012....) Weldon shank (A4012...W)

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

DIN 6528								
A4012	Tech. Code		D mm	L mm	l mm	d mm	Z	
2T - 30°	A401202		2	38	6	3	2	1
	A401203		3		7			
	A401204		4	50	8	4		
	A401205		5		10	5		
	A401206		6			6		
	A401208		8	63	16	8		
	A401210		10	72	19	10		
	A401212		12	83	22	12		
	A401214		14			16		
	A401216		16	92	26			
	A401218		18					
	A401220		20	104	32	20		

		Side Milling		Slotting	RANGE												
					A4012												
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 5	D/mm 6	D/mm 8	D/mm 10	D/mm 12	D/mm 16	D/mm 20
CARBON STEEL	< 500 N/mm²	1 x D	0.25 x D	0.5 x D	100	140	fz/mm	0.015	0.023	0.032	0.041	0.050	0.070	0.086	0.099	0.123	0.149
	< 850 N/mm²	1 x D	0.25 x D	0.5 x D	90	125	fz/mm	0.015	0.023	0.032	0.041	0.050	0.070	0.086	0.099	0.123	0.149
	< 1200 N/mm²	1 x D	0.25 x D	0.5 x D	80	115	fz/mm	0.012	0.019	0.025	0.032	0.040	0.056	0.068	0.079	0.099	0.120
STAINLESS STEEL	< 600 N/mm²	1 x D	0.25 x D	0.5 x D	65	90	fz/mm	0.010	0.015	0.021	0.026	0.032	0.046	0.056	0.064	0.080	0.097
	< 800 N/mm²	1 x D	0.25 x D	0.5 x D	60	80	fz/mm	0.009	0.014	0.020	0.025	0.031	0.043	0.053	0.060	0.077	0.093
CAST IRON	< 240 HB	1 x D	0.25 x D	0.5 x D	80	115	fz/mm	0.013	0.021	0.029	0.037	0.045	0.063	0.077	0.089	0.110	0.134
	< 300 HB	1 x D	0.25 x D	0.5 x D	70	100	fz/mm	0.013	0.020	0.027	0.034	0.042	0.059	0.073	0.085	0.105	0.127
SUPER ALLOY	Ti6Al4V	1 x D	0.25 x D	0.5 x D	60	85	fz/mm	0.011	0.017	0.023	0.030	0.036	0.052	0.063	0.073	0.091	0.110
	< 45 HRC	1 x D	0.25 x D	0.5 x D	25	35	fz/mm	0.008	0.014	0.018	0.023	0.029	0.041	0.050	0.057	0.071	0.086

Recommended "fz" values for side milling.
For slotting, adjust the cutting parameters. (ex: fz x 0.8)