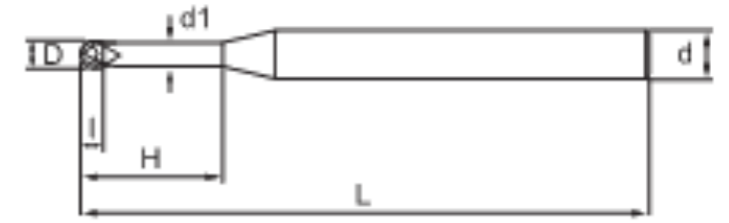


# KERFOLG BALL NOSE MICRO END MILLS Z2



ITEM: A4430

**Material** Micro-grain carbide  
**Standard** Factory standard  
**Tolerance** D ≤ 1mm ~ 0.005/0.025mm  
 D > 1 ~ 4mm ~ 0.001/0.025mm  
**Shank** Cylindrical with neck  
**Helix** 30° right-hand  
**Surface treatment** WIND +  
**Application** Finishing and semi-finishing on materials up to 60 HRC.



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

## FACTORY STANDARD

A4430	Tech. Code	D mm	L mm	l mm	H mm	d mm	d1 mm	Z	
2T - 30°	A44300,52	0.5	50	1	2	4	0.45	2	
	A44300,54				4				
	A44300,56				6				
	A44300,64	0.6		1.2	4		0.55		
	A44300,66				6				
	A44300,86				8				
	A44300,88	0.8		1.5	6		0.95		
	A443016				8				
	A443018				10				
	A4430110	1		2	12		1.15		
	A4430112				8				
	A44301,28				12				
	A44301,212	1.2		2.5	8		1.44		
	A44301,58				12				
	A44301,512				16				
	A44301,516	1.5		3	20		1.55		
	A44301,520				8				
	A44301,68				12				
	A44301,612	1.6		4	16		1.95		
	A44301,616				8				
	A443028				12				
	A4430212	2		5	16		2.9		
	A4430216				20				
	A4430220				8				
	A443038	3		60	10		3.9		
	A4430310				16				
	A4430316				20				
	A4430320	4		75	25		1		
	A4430325				10				
	A4430410				15				
A4430415	4	75	20	1					
A4430420			25						
A4430425			30						
A4430430									

		Profiling		Slotting		RANGE												
						A4430												
Material	Feature	Ap	Ae	Ap	Vc m/min. min.	Vc m/min. max.	mm	D/mm 0.2	D/mm 0.4	D/mm 0.6	D/mm 0.8	D/mm 1.0	D/mm 1.2	D/mm 1.5	D/mm 2.0	D/mm 2.5	D/mm 3.0	D/mm 4.0
CARBON STEEL	< 850 N/mm²	0.05 x D	0.05 x D	0.25 x D	200	320	fz/mm	0.009	0.010	0.016	0.020	0.025	0.032	0.038	0.052	0.065	0.080	0.110
	< 1200 N/mm²	0.05 x D	0.05 x D	0.25 x D	180	260	fz/mm	0.008	0.009	0.012	0.015	0.023	0.030	0.036	0.048	0.060	0.072	0.100
HARDENED	< 45 HRC	0.05 x D	0.05 x D	0.25 x D	75	140	fz/mm	0.006	0.006	0.008	0.010	0.015	0.023	0.028	0.036	0.050	0.062	0.085
	< 60 HRC	0.05 x D	0.05 x D	0.25 x D	50	115	fz/mm	0.005	0.005	0.006	0.008	0.012	0.018	0.024	0.032	0.041	0.050	0.075

Recommended "fz" values for side milling with H < 3 x D sized tools.  
 As for H > 3 x D, adjust cutting parameters (ex. fz x 0.7)  
 For slotting, adjust the cutting parameters. (ex: fz x 0.8)