

KERFOLG® BALL NOSE END MILLS FOR ALUMINUM Z2

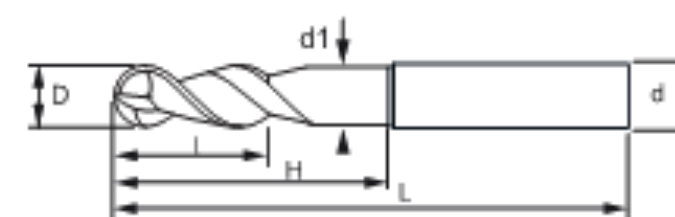
Alufly



ALU

ITEM: A4622

Material Micro-grain carbide
Standard Factory standard
Tolerance f8
Shank Cylindrical
Helix 45° right-hand variable pitch
Surface treatment WIND Z
Application Finishing and semi-finishing on aluminum alloys up to 12% Silicon content.



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

FACTORY STANDARD

A4622	Tech. Code	D mm	L mm	H mm	d1 mm	l mm	d mm	Z	
2T - 45°	A462203	3	50	16	2,7	6	3	2	1
	A462204	4	54	17	3,7	7	4		
	A462205	5		18	4,6	8	5		
	A462206	6		21	5,5	10	6		
	A462208	8	59	27	7,5	12	8		
	A462210	10	67	32	9,4	13	10		
	A462212	12	73	38	11,4	16	12		
	A462216	16	83	44	15	20	16		
	A462220	20		50	19	25	20		

		Profiling		Slotting	RANGE											
					A4622											
Material	Feature	Ap	Ae	Ap	Vc m/min. min.	Vc m/min. max.	mm	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
NON FERROUS	ALU < 10% Si	0.1 x D	0.1 x D	0.25 x D	350	1000	fz/mm	0.030	0.040	0.045	0.050	0.060	0.070	0.080	0.120	0.170
	ALU > 10% Si	0.1 x D	0.1 x D	0.25 x D	350	750	fz/mm	0.030	0.040	0.045	0.050	0.060	0.070	0.080	0.120	0.170

Recommended "fz" values for profiling.
 For slotting, adjust the cutting parameters. (ex: fz x 0.6)