



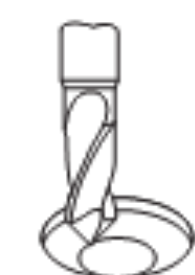
ITEM: A4725

Material Micro-grain carbide
Standard Factory standard
Tolerance h7
Shank Cylindrical
Helix 30° right-hand - 90° peak
Surface treatment WIND +
Application Multi-function

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

FACTORY STANDARD

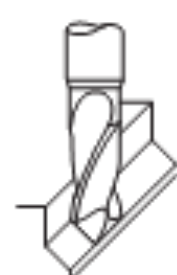
A4725	Tech. Code	D mm	t mm	L mm	l mm	d mm	Z		A4725	Tech. Code	D mm	t mm	L mm	l mm	d mm	Z	
2T - 30°	A472501	1,0	0,10	40	2	3	2	1	2T - 30°	A472505	5,0	0,50	50	10	6	2	1
	A472501,5	1,5	0,15		3					A472506	6,0	0,60	60	12	8		
	A472502	2,0	0,20		4					A472508	8,0	0,80	70	16	10		
	A472503	3,0	0,30	50	6	4				A472510	10,0	1,00	75	18	12		
	A472504	4,0	0,40		8	5				A472512	12,0	1,20		20			



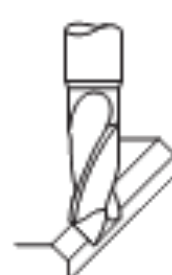
Interpolation
counterboring



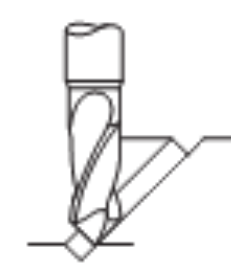
Engraving



Side milling



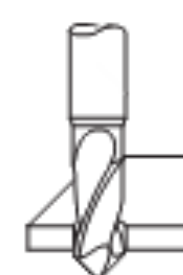
Longitudinal
chamfer



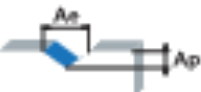
V grooving



Spotting



Drilling

		Side Milling		Slotting	RANGE											
				A4725												
Material	Feature	Ap	Aa	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	
CARBON STEEL	< 500 N/mm²	0.3 x D	0.3 x D	0.5 x D	70	75	fz/mm	0.008	0.010	0.012	0.015	0.018	0.023	0.030	0.040	
	< 850 N/mm²	0.3 x D	0.3 x D	0.5 x D	40	60	fz/mm	0.008	0.010	0.012	0.015	0.018	0.023	0.030	0.040	
	< 1200 N/mm²	0.3 x D	0.3 x D	0.5 x D	35	45	fz/mm	0.006	0.008	0.010	0.012	0.015	0.018	0.025	0.035	
STAINLESS STEEL	< 600 N/mm²	0.3 x D	0.3 x D	0.5 x D	35	45	fz/mm	0.006	0.008	0.010	0.012	0.015	0.018	0.023	0.030	
	< 800 N/mm²	0.3 x D	0.3 x D	0.5 x D	30	40	fz/mm	0.006	0.008	0.010	0.012	0.015	0.018	0.023	0.030	
CAST IRON	< 240 HB	0.3 x D	0.3 x D	0.5 x D	40	60	fz/mm	0.008	0.010	0.012	0.015	0.018	0.023	0.030	0.040	
	< 300 HB	0.3 x D	0.3 x D	0.5 x D	30	35	fz/mm	0.006	0.008	0.010	0.012	0.015	0.018	0.025	0.035	
NON FERROUS	ALU <10% Si	0.3 x D	0.3 x D	0.5 x D	130	150	fz/mm	0.008	0.010	0.012	0.015	0.018	0.023	0.030	0.040	
	ALU >10% Si	0.3 x D	0.3 x D	0.5 x D	90	120	fz/mm	0.008	0.010	0.012	0.015	0.018	0.023	0.030	0.040	
HARDENED	< 45 HRC	0.3 x D	0.3 x D	0.5 x D	25	35	fz/mm	0.006	0.008	0.010	0.012	0.015	0.018	0.023	0.030	

Recommended "fz" values for side milling.