

KERFOLG® 90° SHOULDERING FLUTED MILLS

Helix

ITEM: B4F41

General, multi-task end mills for square shouldering

Coupling type

Bore type

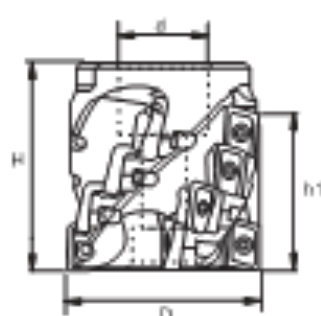
Applicable inserts

APKT 1604

Application

Square shoulder milling

Ø50 - 80 mm



SHELL MILL

B4F41	Tech. Code	Z	D mm	d mm	H mm	K	h1 mm	h2	Air hole	Insert	Insert screw
Bore	B4F4150Z3	6	50	27	50	3	30	-	With	APKT 1604	BRICA003
	B4F4163Z4	12	63		60	4	44				
	B4F4180Z5	15	80	32		5					

KERFOLG®

RECOMMENDED GEOMETRIES AND APPLICATIONS

Wall



• RECOMMENDED FOR... ◊ USABLE FOR...

FINISH		Description	Grade	Tech. Code	P			M		K		N	S	H
					<500 N/mm²	<850 N/mm²	<1200 N/mm²	<600 N/mm²	<850 N/mm²	<240 HB	<300 HB	Alu	HTA	<60 HRC
MEDIUM CUT	MF	APKT 1604PDR - MF	MT35	B4F1116MFMT35	●	○	○	●	●	○	○		○	
			PT35	B4F1116MFPT35	●	●	○	○	○	○	○		○	
	MR	APKT 1604PDR - MR	PT25	B4F2116MRPT25	○	○	●			●	●			○
			PT30	B4F2116MRPT30	●	●	●			●	○			○
			PT35	B4F2116MRPT35	●	●	○	○	○	○	○		○	
MEDIUM CUT	ALP	APKT 1604PDFR - ALP	K10	B4F2216ALPK10								●		
	MR	APKT 1604PDFR - MR	PT35	B4F2216MRPT35	●	●	○	○	○	○	○		○	

Material	Hardness Brinell HB	Degrees Recommended	Cutting speed Speed(m/min.)	Feed fz/mm
Low carbon content steel (C15, etc.)	~ 180	P30	150 - 200	0.10 - 0.25
	~ 180	P35	90 - 150	0.12 - 0.30
High carbon content steel (C45E, C55E, etc.)	~ 300	P30	150 - 200	0.10 - 0.25
	~ 300	P35	90-150	0.12 - 0.30
Tool steel (X155CrVMo 12 1, etc.)	~ 300	P30	150 - 200	0.10 - 0.25
	~ 300	P35	90-150	0.12 - 0.30
Stainless steel (X5CrNi 18-9, etc.)	-	M35	80-180	0.08 - 0.15
Cast iron (GG25, GG30, etc.) Spheroidal cast iron (GGG40, etc.)	150 - 250	P25	130 - 230	0.10 - 0.20
Non ferrous alloys (SI < 13%)	-	K10	200-1000	0.10 - 0.25
Hardened steel < 55 HRC	-	P25	30 - 50	0.06 - 0.10

SPARE PARTS

Tech. Code	Version	Description	Denomination
BRICA003	All diameters	Clamping insert screw	BRICA003
BRICA004		Wrench	BRICA004