

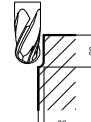
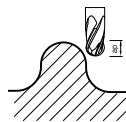
KKUF

Z4 Ball Nose Endmill

S	Order No	Code	d1h9	d2h6	l1	l2
*	38100	KKUF.4.0300.0750.R0150.0080.0000.0000.00.S03B1A01.01	3	3	75	8
*	38102	KKUF.4.0400.0750.R0200.0100.0000.0000.00.S04B1A01.01	4	4	75	10
*	38104	KKUF.4.0500.0750.R0250.0100.0000.0000.00.S05B1A01.01	5	5	75	10
*	38106	KKUF.4.0600.0750.R0300.0100.0000.0000.00.S06B1A01.01	6	6	75	10
*	38108	KKUF.4.0600.1000.R0300.0150.0000.0000.00.S06B1A01.01	6	6	100	15
*	38110	KKUF.4.0800.0750.R0400.0100.0000.0000.00.S08B1A01.01	8	8	75	10
*	38112	KKUF.4.0800.1000.R0400.0150.0000.0000.00.S08B1A01.01	8	8	100	15
*	38114	KKUF.4.1000.1100.R0500.0200.0000.0000.00.S10B1A01.01	10	10	110	20
*	38116	KKUF.4.1200.1100.R0600.0200.0000.0000.00.S12B1A01.01	12	12	110	20

Cutting Parameters

Material	Shoulder Milling $a_p=0.10 / a_e=0.03 - 0.020$	Finish Milling $a_p=0.10 / a_e=0.02 - 0.010$
	Vc (m/min)	Vc (m/min)



Steel	Unalloyed Steel	200-230	230-260
	Steel	200-230	230-260
	Tempered Steel	170-200	200-230
	Cold Work Tool Steel	150-180	180-210
	Hot Work Tool Steel	140-170	170-200
Stainless Steel	AISI 304 - 416 - 420	90-120	120-150
	AISI 316 - 440	80-110	110-140
	17-4 PH 15-5 PH	80-110	110-140
	Chrome-Cobalt Alloy	70-100	100-130
Cast Iron	Gray Cast Iron	280-310	310-350
	Alloyed Cast Iron	180-210	210-250
	Precision Cast Iron	150-180	180-210

Feed Per Tooth (mm/tooth)

Ø	$a_e=0.030$	$a_e=0.020$	$a_e=0.0150$	$a_e=0.010$
3	0.027	0.031	0.037	0.040
4	0.031	0.037	0.041	0.045
5	0.032	0.037	0.042	0.046
6	0.041	0.046	0.052	0.057
8	0.048	0.052	0.061	0.066
10	0.053	0.057	0.066	0.072
12	0.058	0.064	0.072	0.079

Z4



≤48 HRC +AlCrN

FORM HA DIN 6535



Steel	●
Stainless Steel	●
Hardened Steel ≤54 HRC	○
Hardened Steel >54 HRC	○
Cast Iron	●
Graphite	○
Non Ferrous Material	○
HRSA	○
Titanium	○

● Recommended ● Acceptable ○ Not Recommended

*Marked products can be delivered quickly from stock.