



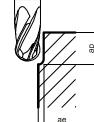
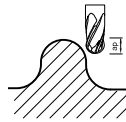
KSKF

Z4 Ball Nose Endmill

S	Order No	Code	d1f8	d2h6	L1	L2
*	29100	KSKF.4.0300.0390.R0150.0120.0000.0000.00.S03B1A03.01	3	3	39	12
*	29102	KSKF.4.0400.0500.R0200.0140.0000.0000.00.S04B1A01.01	4	4	50	14
*	29104	KSKF.4.0500.0510.R0250.0200.0000.0000.00.S05B1A01.01	5	5	51	20
*	29106	KSKF.4.0600.0580.R0300.0200.0000.0000.00.S06B1A01.01	6	6	58	20
*	29108	KSKF.4.0800.0640.R0400.0200.0000.0000.00.S08B1A01.01	8	8	64	20
*	29110	KSKF.4.1000.0730.R0500.0250.0000.0000.00.S10B1A01.01	10	10	73	25
*	29112	KSKF.4.1200.0820.R0600.0250.0000.0000.00.S12B1A01.01	12	12	82	25
*	29114	KSKF.4.1600.0930.R0800.0320.0000.0000.00.S16B1A01.01	16	16	93	32
*	29116	KSKF.4.1600.0930.R0800.0320.0000.0000.00.S16B1A01.02	16	16	93	32

Cutting Parameters

Material	Shoulder Milling $a_p=0.10 / a_e=0.030 - 0.020\phi$	Finish Milling $a_p=0.10 / a_e=0.02 - 0.01\phi$
	Vc (m/min)	Vc (m/min)



Steel	Unalloyed Steel	200-230	230-260
	Steel	200-230	230-260
	Tempered Steel	180-210	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)

ϕ	$a_e=0.03\phi$	$a_e=0.02\phi$	$a_e=0.015\phi$	$a_e=0.01\phi$
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



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

● Recommended ● Acceptable ○ Not Recommended