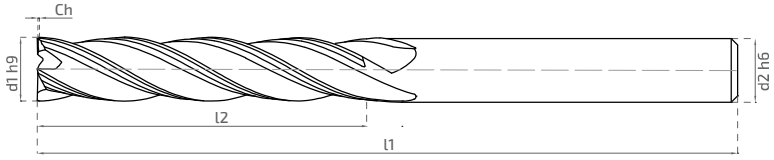
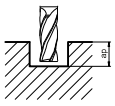
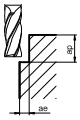
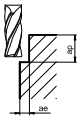



| S | Order No | Code | d1h9 | d2h6 | l1 | l2 | Corner |
|---|---|---|---|---|---|---|---|
| * | **28100** | KSUF.4.0150.0500.K0000.0090.0000.0000.00.S04A1A02.01 | 1,5 | 4 | 50 | 9 | Ch 0.00 |
| * | **28102** | KSUF.4.0200.0500.K0000.0120.0000.0000.00.S04A1A02.01 | 2 | 4 | 50 | 12 | Ch 0.00 |
| * | **28104** | KSUF.4.0300.0500.C0010.0150.0000.0000.00.S03A1A02.01 | 3 | 3 | 50 | 15 | Ch 0.10 |
| * | **28106** | KSUF.4.0300.0750.C0010.0150.0000.0000.00.S03A1A02.01 | 3 | 3 | 75 | 15 | Ch 0.10 |
| * | **28108** | KSUF.4.0400.0750.C0010.0200.0000.0000.00.S04A1A02.01 | 4 | 4 | 75 | 20 | Ch 0.10 |
| * | **28110** | KSUF.4.0400.1000.C0010.0250.0000.0000.00.S04A1A02.01 | 4 | 4 | 100 | 25 | Ch 0.10 |
| * | **28112** | KSUF.4.0500.0750.C0010.0200.0000.0000.00.S05A1A02.01 | 5 | 5 | 75 | 20 | Ch 0.10 |
| | **28114** | KSUF.4.0500.1000.C0010.0250.0000.0000.00.S05A1A02.01 | 5 | 5 | 100 | 25 | Ch 0.10 |
| * | **28116** | KSUF.4.0600.0750.C0010.0250.0000.0000.00.S06A1A02.01 | 6 | 6 | 75 | 25 | Ch 0.10 |
| * | **28118** | KSUF.4.0600.1000.C0010.0300.0000.0000.00.S06A1A02.01 | 6 | 6 | 100 | 30 | Ch 0.10 |
| * | **28120** | KSUF.4.0800.1000.C0010.0350.0000.0000.00.S08A1A02.01 | 8 | 8 | 100 | 35 | Ch 0.10 |
| * | **28122** | KSUF.4.1000.1100.C0010.0400.0000.0000.00.S10A1A02.01 | 10 | 10 | 110 | 40 | Ch 0.10 |
| * | **28124** | KSUF.4.1200.1100.C0015.0450.0000.0000.00.S12A2A02.01 | 12 | 12 | 110 | 45 | Ch 0.15 |
| * | **28126** | KSUF.4.1200.1500.C0015.0600.0000.0000.00.S12A2A02.01 | 12 | 12 | 150 | 60 | Ch 0.15 |
| | **28128** | KSUF.4.1400.1500.C0015.0600.0000.0000.00.S14A1A02.01 | 14 | 14 | 150 | 60 | Ch 0.15 |
| | **28130** | KSUF.4.1500.1000.C0010.0450.0000.0000.00.S16A1A02.01 | 15 | 16 | 100 | 45 | Ch 0.10 |
| | **28132** | KSUF.4.1600.1000.C0015.0450.0000.0000.00.S16A1A02.01 | 16 | 16 | 100 | 45 | Ch 0.15 |
| * | **28134** | KSUF.4.1600.1500.C0015.0750.0000.0000.00.S16A2A02.01 | 16 | 16 | 150 | 75 | Ch 0.15 |
| | **28136** | KSUF.4.1650.1500.C0015.0750.0000.0000.00.S18A1A02.01 | 16,5 | 18 | 150 | 75 | Ch 0.15 |
| | **28138** | KSUF.4.1700.1500.C0015.0750.0000.0000.00.S18A1A02.01 | 17 | 18 | 150 | 75 | Ch 0.15 |
| | **28140** | KSUF.4.1750.1500.C0015.0750.0000.0000.00.S18A1A02.01 | 17,5 | 18 | 150 | 75 | Ch 0.15 |
| | **28142** | KSUF.4.1800.1500.C0015.0750.0000.0000.00.S18A1A02.01 | 18 | 18 | 150 | 75 | Ch 0.15 |
| | **28144** | KSUF.4.1850.1500.C0015.0750.0000.0000.00.S20A1A02.01 | 18,5 | 20 | 150 | 75 | Ch 0.15 |
| * | **28146** | KSUF.4.2000.1500.C0015.0750.0000.0000.00.S20A1A02.01 | 20 | 20 | 150 | 75 | Ch 0.15 |

## Cutting Parameters

| | Material | Slotting ap=0.5 - 0.1Ø Vc (m/min) | Shoulder Milling ap=1.5Ø / ae=0.30 - 0.20Ø Vc (m/min) | Finish Milling ap=1.5Ø / ae=0.20 - 0.10Ø Vc (m/min) |
|---|---|---|---|---|
| | |  |  |  |
| Steel | Unalloyed Steel | 95-125 | 180-210 | 210-230 |
| Steel | Steel | 90-120 | 180-210 | 210-230 |
| Steel | Tempered Steel | 80-110 | 160-190 | 190-120 |
| Steel | Cold Work Tool Steel | 70-90 | 150-180 | 170-200 |
| Steel | Hot Work Tool Steel | 60-80 | 140-170 | 160-190 |
| Cast Iron | Gray Cast Iron | 100-130 | 250-280 | 280-330 |
| Cast Iron | Alloyed Cast Iron | 70-100 | 150-190 | 190-240 |
| Cast Iron | Precision Cast Iron | 60-90 | 130-160 | 160-210 |

## Feed Per Tooth (mm/tooth)

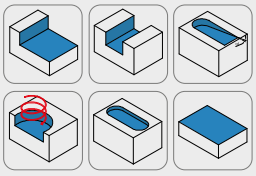
| Ø | ap=0.05Ø | ae=0.10Ø | ae=0.30Ø | ae=0.20Ø | ae=0.15Ø | ae=0.10Ø |
|---|---|---|---|---|---|---|
| 3 | 0.005 | 0.006 | 0.031 | 0.036 | 0.038 | 0.040 |
| 4 | 0.008 | 0.011 | 0.038 | 0.042 | 0.044 | 0.046 |
| 5 | 0.013 | 0.017 | 0.041 | 0.043 | 0.045 | 0.047 |
| 6 | 0.016 | 0.022 | 0.048 | 0.052 | 0.054 | 0.056 |
| 8 | 0.021 | 0.027 | 0.054 | 0.058 | 0.061 | 0.064 |
| 10 | 0.029 | 0.035 | 0.062 | 0.066 | 0.069 | 0.072 |
| 12 | 0.038 | 0.043 | 0.067 | 0.072 | 0.075 | 0.079 |
| 14 | 0.047 | 0.052 | 0.072 | 0.077 | 0.080 | 0.083 |
| 16 | 0.056 | 0.063 | 0.076 | 0.081 | 0.086 | 0.090 |
| 18 | 0.068 | 0.073 | 0.079 | 0.085 | 0.089 | 0.095 |
| 20 | 0.078 | 0.084 | 0.084 | 0.092 | 0.097 | 0.098 |

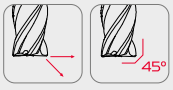


# KSUF

General Purpose Endmill

Z4




| | |
|---|---|
| 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.