



# AG 140-4



## HSS End Mill

Manufacturer standard



| d <sub>1</sub><br>mm | d <sub>2</sub><br>mm | l <sub>2</sub><br>mm | l <sub>1</sub><br>mm | Z | Uncoated<br>Part No. | Coated<br>Part No. | f <sub>r</sub> Roughing<br>mm/Z | f <sub>f</sub> Finishing<br>mm/Z |
|----------------------|----------------------|----------------------|----------------------|---|----------------------|--------------------|---------------------------------|----------------------------------|
| 6,0                  | 6                    | 40                   | 100                  | 4 | AG140406             | AG140406A          | 0,010 – 0,027                   | 0,008 – 0,025                    |
| 8,0                  | 8                    | 65                   | 115                  | 4 | AG140408             | AG140408A          | 0,014 – 0,034                   | 0,012 – 0,032                    |
| 10,0                 | 10                   | 65                   | 115                  | 4 | AG140410             | AG140410A          | 0,017 – 0,041                   | 0,015 – 0,039                    |
| 12,0                 | 12                   | 75                   | 132                  | 4 | AG140412             | AG140412A          | 0,020 – 0,050                   | 0,018 – 0,048                    |
| 14,0                 | 12                   | 80                   | 137                  | 4 | AG140414             | AG140414A          | 0,022 – 0,057                   | 0,020 – 0,055                    |
| 16,0                 | 16                   | 100                  | 160                  | 4 | AG140416             | AG140416A          | 0,025 – 0,060                   | 0,023 – 0,058                    |
| 18,0                 | 16                   | 100                  | 160                  | 4 | AG140418             | AG140418A          | 0,027 – 0,067                   | 0,025 – 0,065                    |
| 20,0                 | 20                   | 100                  | 166                  | 4 | AG140420             | AG140420A          | 0,030 – 0,075                   | 0,028 – 0,073                    |
| 20,0                 | 20                   | 125                  | 191                  | 4 | AG140520             | AG140520A          | 0,030 – 0,075                   | 0,028 – 0,073                    |
| 22,0                 | 20                   | 110                  | 176                  | 4 | AG140422             | AG140422A          | 0,032 – 0,078                   | 0,028 – 0,078                    |
| 25,0                 | 25                   | 125                  | 201                  | 4 | AG140425             | AG140425A          | 0,039 – 0,084                   | 0,037 – 0,082                    |
| 25,0                 | 25                   | 140                  | 216                  | 4 | AG140525             | AG140525A          | 0,039 – 0,084                   | 0,037 – 0,082                    |
| 25,0                 | 25                   | 160                  | 236                  | 4 | AG140625             | AG140625A          | 0,039 – 0,084                   | 0,037 – 0,082                    |
| 28,0                 | 25                   | 140                  | 216                  | 4 | AG140428             | AG140428A          | 0,043 – 0,088                   | 0,041 – 0,086                    |
| 28,0                 | 25                   | 160                  | 236                  | 4 | AG140528             | AG140528A          | 0,043 – 0,088                   | 0,041 – 0,086                    |
| 30,0                 | 25                   | 140                  | 216                  | 4 | AG140430             | AG140430A          | 0,046 – 0,091                   | 0,044 – 0,089                    |
| 32,0                 | 32                   | 140                  | 220                  | 4 | AG140432             | AG140432A          | 0,049 – 0,094                   | 0,047 – 0,092                    |
| 32,0                 | 32                   | 160                  | 240                  | 4 | AG140532             | AG140532A          | 0,049 – 0,094                   | 0,047 – 0,092                    |
| 32,0                 | 32                   | 180                  | 260                  | 4 | AG140632             | AG140632A          | 0,049 – 0,094                   | 0,047 – 0,092                    |



Peripheral milling  
a<sub>e</sub> = 0,2xD  
a<sub>p</sub> = 1,5xD



Full slot milling  
a<sub>p</sub> = 0,3xD

|                |                |
|----------------|----------------|
| d <sub>1</sub> | d <sub>2</sub> |
| h10            | h6             |

| Material                         | Steel                   | Stainless               | Cast                    | Alu                     |
|----------------------------------|-------------------------|-------------------------|-------------------------|-------------------------|
| Tensile strength/ Hardness       | < 850 N/mm <sup>2</sup> | < 850 N/mm <sup>2</sup> | < 800 N/mm <sup>2</sup> | < 600 N/mm <sup>2</sup> |
| V <sub>c</sub> (m/min) Finishing | 60                      | 45                      | 60                      | 120                     |
| V <sub>c</sub> (m/min) Roughing  | 40                      | 30                      | 40                      | 90                      |