

ECO+PLUS

KKUF Z4 Series

Ball Nose Endmill



General Engineering



Mold&Die



Automotive



Finish



Rough

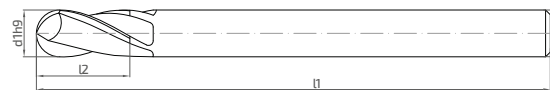
Brand-New Original
Geometry, Unique
Edge-Preparation,
And Advanced
Coating Technology,

Unrivaled To Machine Workpieces Till 48HRC
Hardness In Price-Performance Ratio



Available from stock in all sizes **% 100**

www.karcan.com



Stock	Code	d1h9	d2h6	l1	l2
*	KKUF403075	3	3	75	8
*	KKUF404075	4	4	75	10
*	KKUF405075	5	5	75	10
*	KKUF406075	6	6	75	10
*	KKUF406100	6	6	100	15
*	KKUF408075	8	8	75	10
*	KKUF408100	8	8	100	15
*	KKUF410110	10	10	110	20
*	KKUF412110	12	12	110	20

Material	Cutting Parameters	
	Shoulder Milling ap=0.10 / ae=0.30 - 0.200 Vc (m/min)	Finish Milling ap=0.10 / ae=0.20 - 0.100 Vc (m/min)



Material	Shoulder Milling		Finish Milling	
	ap=0.10 / ae=0.30 - 0.200	Vc (m/min)	ap=0.10 / ae=0.20 - 0.100	Vc (m/min)
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	
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	
Gray Cast Iron	280-310		310-350	
Alloyed Cast Iron	180-210		210-250	
Precision Cast Iron	150-180		180-210	

Feed	Feed Per Tooth (mm/tooth)			
	ae=0.300	ae=0.200	ae=0.150	ae=0.100
0				
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

ECO+PLUS

KKUF Z4 Ball Nose Endmill



≤48 HRC +AlCrN



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.



ECO+PLUS

KKUF Z2 Series

Ball Nose Endmill



General Engineering



Mold&Die



Automotive



Finish



Rough

Brand-New Original Geometry, Unique Edge-Preparation, And Advanced Coating Technology,

Unrivaled To Machine Workpieces Till 55HRC Hardness In Price-Performance Ratio.



Up to **40%** longer tool life thanks to its new geometry and developed coating

Available from stock in all sizes **100%**

www.karcan.com



Stock	Code	d1h9	d2h6	l1	l2
*	KKUF203075	3	3	75	8
*	KKUF204075	4	4	75	10
*	KKUF205075	5	5	75	10
*	KKUF206075	6	6	75	10
*	KKUF206100	6	6	100	15
*	KKUF208100	8	8	100	15
*	KKUF210110	10	10	110	20
*	KKUF212110	12	12	110	22

Material	Cutting Parameters	
	Shoulder Milling ap=0.10 / ae=0.30-0.200 Vc (m/min)	Finish Milling ap=0.10 / ae=0.20-0.100 Vc (m/min)

Material	Shoulder Milling ap=0.10 / ae=0.30-0.200 Vc (m/min)	Finish Milling ap=0.10 / ae=0.20-0.100 Vc (m/min)
Steel	200-230	230-260
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	90-120	120-150
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	280-310	310-350
Gray Cast Iron	280-310	310-350
Alloyed Cast Iron	180-210	210-250
Precision Cast Iron	150-180	180-210

Ø	Feed Per Tooth (mm/tooth)		
	ae=0.300	ae=0.200	ae=0.150
3	0,020	0,023	0,027
4	0,023	0,027	0,030
5	0,024	0,027	0,030
6	0,030	0,035	0,040
8	0,036	0,040	0,045
10	0,040	0,042	0,050
12	0,045	0,048	0,055

ECO+PLUS

KKUF Z2

Ball Nose Endmill



≤55 HRC

+TISIN

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.



2022
Endmill Catalog

KKUF Eco-Plus