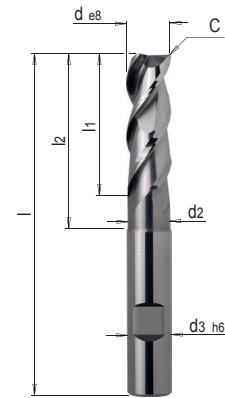


PRODUCT DESCRIPTION

- » High-performance milling cutter for aluminium materials
- » With non-uniform pitch and centre cut
- » Relieved behind the cutting edge

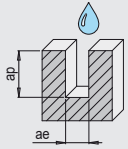
MATERIAL

» Carbide, polished



Z	d2	d3	l	l1	l2	C	d	No.	EUR
3	4.8	6	57	15	19.4	0.05	5	WZF 12858/ 5	< >
3	5.7	6	65	18	28	0.06	6	WZF 12858/ 6	< >
3	7.7	8	75	24	38	0.08	8	WZF 12858/ 8	< >
3	9.5	10	80	30	38	0.1	10	WZF 12858/10	< >
3	11.5	12	93	36	46	0.12	12	WZF 12858/12	< >
3	15.5	16	108	48	58	0.16	16	WZF 12858/16	< >
3	19.5	20	126	60	74	0.2	20	WZF 12858/20	< >

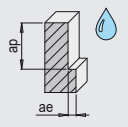
REFERENCE VALUES FOR SLOTTING

WZF 12848 WZF 12858	Material	Strength	Vc ¹ m/min.	d							
				4	5	6	8	10	12	16	20
				fz ² (mm/z)							
 <p>ae = 1 x d ap = 1 x d</p>	3.3547 / EN AW-5083	270 N/mm ²	350	0.018	0.018	0.035	0.045	0.060	0.070	0.090	0.100
	3.4365 / EN AW-7075	520 N/mm ²	350	0.018	0.018	0.035	0.045	0.060	0.070	0.090	0.100
	Copper	280 N/mm ²	250	0.016	0.016	0.030	0.040	0.055	0.065	0.080	0.095
	Non-ferrous metal	<800 N/mm ²	250	0.016	0.016	0.030	0.040	0.055	0.065	0.080	0.095

REFERENCE VALUES FOR ROUGHING


WZF 12848 WZF 12858	Material	Strength	Vc ¹ m/min.	d							
				4	5	6	8	10	12	16	20
				fz ² (mm/z)							
 <p>ae = 0.5 x d ap = 1 x d</p>	3.3547 / EN AW-5083	270 N/mm ²	500	0.020	0.020	0.040	0.050	0.065	0.080	0.095	0.110
	3.4365 / EN AW-7075	520 N/mm ²	500	0.020	0.020	0.040	0.050	0.065	0.080	0.095	0.110
	Copper	280 N/mm ²	300	0.015	0.016	0.025	0.035	0.045	0.050	0.065	0.080
	Non-ferrous metal	<800 N/mm ²	300	0.015	0.016	0.025	0.035	0.045	0.050	0.065	0.080

REFERENCE VALUES FOR FINISH MILLING

WZF 12848 WZF 12858	Material	Strength	Vc ¹ m/min.	d							
				4	5	6	8	10	12	16	20
				fz ² (mm/z)							
 <p>ae = 0.1 x d ap = 1.5 x d</p>	3.3547 / EN AW-5083	270 N/mm ²	600	0.024	0.024	0.048	0.060	0.078	0.096	0.114	0.132
	3.4365 / EN AW-7075	520 N/mm ²	600	0.024	0.024	0.048	0.060	0.078	0.096	0.114	0.132
	Copper	280 N/mm ²	400	0.0192	0.019	0.036	0.048	0.066	0.078	0.096	0.114
	Non-ferrous metal	<800 N/mm ²	400	0.0192	0.019	0.036	0.048	0.066	0.078	0.096	0.114

1) Vc: cutting speed (m/min.)

2) fz: feed per cut (mm per tooth)

 You can find further materials and cutting values in the cutting data calculator.