



PRODUCT DESCRIPTION

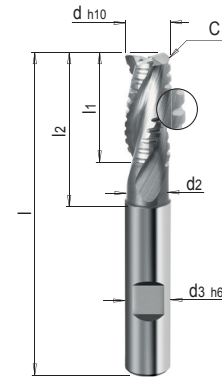
- » High-performance milling cutter for aluminium materials
- » With non-uniform pitch and centre cut
- » Relieved behind the cutting edge

MATERIAL

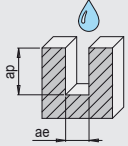
- » Carbide, polished



| Z | d2 | d3 | l | l1 | l2 | C | d | No. | EUR |
|---|------|----|-----|----|----|-----|----|--------------|-----|
| 3 | 5.7 | 6 | 57 | 13 | 20 | 0.3 | 6 | WZF 11848/ 6 | < > |
| 3 | 7.7 | 8 | 63 | 19 | 26 | 0.3 | 8 | WZF 11848/ 8 | < > |
| 3 | 9.5 | 10 | 72 | 22 | 30 | 0.3 | 10 | WZF 11848/10 | < > |
| 3 | 11.5 | 12 | 83 | 26 | 36 | 0.5 | 12 | WZF 11848/12 | < > |
| 3 | 15.5 | 16 | 92 | 32 | 42 | 0.5 | 16 | WZF 11848/16 | < > |
| 3 | 19.5 | 20 | 104 | 38 | 52 | 0.5 | 20 | WZF 11848/20 | < > |



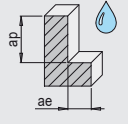
REFERENCE VALUES FOR SLOTTING

| WZF 11848 WZF 11858 | Material | Strength | Vc ¹ m/min. | d | | | | | |
|--|---------------------|------------------------|---------------------------|------------------------|-------|-------|-------|-------|-------|
| | | | | 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 | 400 | 0.025 | 0.030 | 0.040 | 0.050 | 0.065 | 0.070 |
| | 3.4365 / EN AW-7075 | 520 N/mm ² | 400 | 0.025 | 0.030 | 0.040 | 0.050 | 0.065 | 0.070 |
| | Copper | 280 N/mm ² | 250 | 0.018 | 0.020 | 0.030 | 0.040 | 0.045 | 0.050 |
| | Non-ferrous metal | <800 N/mm ² | 250 | 0.018 | 0.020 | 0.030 | 0.040 | 0.045 | 0.050 |

REFERENCE VALUES FOR ROUGHING


| WZF 11848 WZF 11858 | Material | Strength | Vc ¹ m/min. | d | | | | | |
|--|---------------------|------------------------|---------------------------|------------------------|-------|-------|-------|-------|-------|
| | | | | 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 | 0.030 | 0.040 | 0.055 | 0.065 | 0.080 | 0.095 |
| | 3.4365 / EN AW-7075 | 520 N/mm ² | 500 | 0.030 | 0.040 | 0.055 | 0.065 | 0.080 | 0.095 |
| | Copper | 280 N/mm ² | 300 | 0.025 | 0.030 | 0.040 | 0.045 | 0.060 | 0.070 |
| | Non-ferrous metal | <800 N/mm ² | 300 | 0.025 | 0.030 | 0.040 | 0.045 | 0.060 | 0.070 |

REFERENCE VALUES FOR ROUGHING

| WZF 11848 WZF 11858 | Material | Strength | Vc ¹ m/min. | d | | | | | |
|---|---------------------|------------------------|---------------------------|------------------------|-------|-------|-------|-------|-------|
| | | | | 6 | 8 | 10 | 12 | 16 | 20 |
| | | | | fz ² (mm/z) | | | | | |
|  <p>ae = 0.25 x d ap = 1.5 x d</p> | 3.3547 / EN AW-5083 | 270 N/mm ² | 600 | 0.040 | 0.050 | 0.070 | 0.080 | 0.100 | 0.120 |
| | 3.4365 / EN AW-7075 | 520 N/mm ² | 600 | 0.040 | 0.050 | 0.070 | 0.080 | 0.100 | 0.120 |
| | Copper | 280 N/mm ² | 300 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.090 |
| | Non-ferrous metal | <800 N/mm ² | 300 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.090 |

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.