



PRODUCT DESCRIPTION

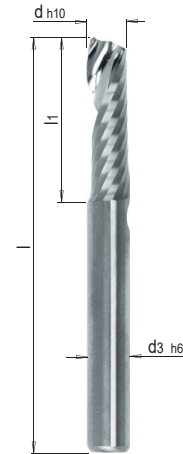
- » High-performance milling cutter for aluminium materials
- » With centre cut

MATERIAL

- » Carbide, polished



Z	d3	l	l1	d	No.	EUR
1	2	38	10	2	WZF 128462/ 2	< >
1	3	39	12	3	WZF 128462/ 3	< >
1	4	40	15	4	WZF 128462/ 4	< >
1	6	57	20	6	WZF 128462/ 6	< >
1	8	63	22	8	WZF 128462/ 8	< >
1	10	73	25	10	WZF 128462/10	< >
1	12	83	30	12	WZF 128462/12	< >



REFERENCE VALUES FOR SLOTTING

WZF 128462	Material	Strength	Vc ¹ m/min.	d						
				2	3	4	6	8	10	12
				fz ² (mm/z)						
	3.3547 / EN AW-5083	270N/mm ²	300	0.010	0.015	0.020	0.030	0.040	0.055	0.066
	3.4365 / EN AW-7075	520N/mm ²	300	0.010	0.015	0.020	0.030	0.040	0.055	0.066
	copper	280N/mm ²	200	0.009	0.014	0.018	0.027	0.036	0.050	0.060
	Non-ferrous metal	< 800N/mm ²	200	0.009	0.014	0.018	0.027	0.036	0.050	0.060

REFERENCE VALUES FOR ROUGHING

WZF 128462	Material	Strength	Vc ¹ m/min.	d						
				2	3	4	6	8	10	12
				fz ² (mm/z)						
	3.3547 / EN AW-5083	270N/mm ²	400	0.014	0.017	0.023	0.046	0.063	0.076	0.100
	3.4365 / EN AW-7075	520N/mm ²	400	0.014	0.017	0.023	0.046	0.063	0.076	0.100
	copper	280N/mm ²	230	0.013	0.016	0.021	0.031	0.041	0.058	0.069
	Non-ferrous metal	< 800N/mm ²	230	0.013	0.016	0.021	0.031	0.041	0.058	0.069

REFERENCE VALUES FOR FINISH MILLING

WZF 128462	Material	Strength	Vc ¹ m/min.	d						
				2	3	4	6	8	10	12
				fz ² (mm/z)						
	3.3547 / EN AW-5083	270N/mm ²	600	0.013	0.017	0.022	0.033	0.044	0.061	0.073
	3.4365 / EN AW-7075	520N/mm ²	600	0.013	0.017	0.022	0.033	0.044	0.061	0.073
	copper	280N/mm ²	400	0.010	0.015	0.020	0.030	0.040	0.055	0.066
	Non-ferrous metal	< 800N/mm ²	400	0.010	0.015	0.020	0.030	0.040	0.055	0.066

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

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