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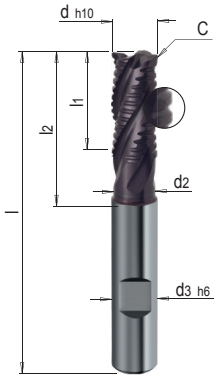
CARBIDE ROUGH MILLING CUTTER, LONG — WZF 11248



PRODUCT DESCRIPTION

» Relieved behind the cutting edge
» High-performance milling cutter with non-uniform pitch and centre cut

MATERIAL

» Carbide, TiAlN multi-layer coated

P ● M K ● N S H

Z	d2	d3	l	l1	l2	C	d	No.	EUR
4	5.5	6	57	13	20	0.3	**6**	WZF 11248/ 6	< >
4	7.5	8	63	19	26	0.3	**8**	WZF 11248/ 8	< >
4	9.2	10	72	22	30	0.3	**10**	WZF 11248/10	< >
4	11.2	12	83	26	36	0.5	**12**	WZF 11248/12	< >
4	15	16	92	32	42	0.5	**16**	WZF 11248/16	< >
4	19	20	104	38	52	0.5	**20**	WZF 11248/20	< >
4	24	25	121	45	63	0.6	**25**	WZF 11248/25	< >

Meusburger Georg GmbH & Co KG | Kesselstr. 42 | 6960 Wolfurt | Austria
T +43 5574 6706-0 | sales@meusburger.com | www.meusburger.com

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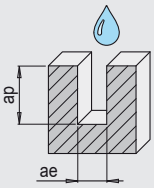
REFERENCE VALUES FOR SLOTTING

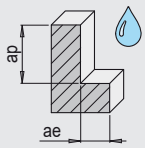
WZF 11248	Material	Strength	Vc[1] m/min.	d						
				6	8	10	12	16	20	25
				fz[2] (mm/z)						
	1.1730	640 N/mm²	180	0.020	0.027	0.034	0.042	0.049	0.059	0.084
	1.2083	780 N/mm²	135	0.010	0.013	0.017	0.020	0.025	0.028	0.042
	1.2085	1080 N/mm²	135	0.010	0.013	0.017	0.020	0.025	0.028	0.042
	1.2162	660 N/mm²	160	0.018	0.025	0.031	0.038	0.045	0.054	0.076
	1.2311	1080 N/mm²	150	0.014	0.020	0.025	0.030	0.036	0.043	0.061
	1.2312	1080 N/mm²	160	0.013	0.018	0.024	0.029	0.034	0.040	0.057
	1.2316	1010 N/mm²	135	0.010	0.013	0.017	0.020	0.025	0.028	0.042
	1.2343	780 N/mm²	160	0.018	0.025	0.031	0.038	0.045	0.054	0.076
	1.2379	780 N/mm²	135	0.010	0.013	0.017	0.020	0.025	0.028	0.042
	1.2714HH	1350 N/mm²	80	0.010	0.013	0.017	0.020	0.025	0.028	0.042
	1.2767	830 N/mm²	160	0.017	0.023	0.030	0.036	0.043	0.051	0.072
	1.2842	775 N/mm²	160	0.018	0.025	0.031	0.038	0.045	0.054	0.076
	Steel	1400 N/mm²	70	0.010	0.013	0.017	0.020	0.025	0.028	0.042



ae = 1 x d
ap = 1 x d

REFERENCE VALUES FOR ROUGHING

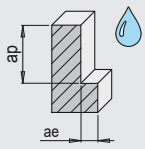
WZF 11248 WZF 11258	Material	Strength	Vc[1] m/min.	d						
				6	8	10	12	16	20	25
				fz[2] (mm/z)						
	1.1730	640 N/mm²	130	0.022	0.028	0.037	0.043	0.055	0.062	0.074
	1.2083	780 N/mm²	90	0.010	0.014	0.017	0.021	0.025	0.030	0.036
	1.2085	1080 N/mm²	90	0.010	0.014	0.017	0.021	0.025	0.030	0.036
	1.2162	660 N/mm²	110	0.020	0.025	0.034	0.039	0.050	0.056	0.067
	1.2311	1080 N/mm²	110	0.016	0.020	0.027	0.031	0.040	0.045	0.054
	1.2312	1080 N/mm²	110	0.015	0.019	0.025	0.029	0.038	0.042	0.050
	1.2316	1010 N/mm²	90	0.010	0.014	0.017	0.021	0.025	0.030	0.036
	1.2343	780 N/mm²	110	0.020	0.025	0.034	0.039	0.050	0.056	0.067
	1.2379	780 N/mm²	90	0.010	0.014	0.017	0.021	0.025	0.030	0.036
	1.2714HH	1350 N/mm²	60	0.010	0.014	0.017	0.021	0.025	0.030	0.036
	1.2767	830 N/mm²	110	0.019	0.024	0.032	0.037	0.048	0.053	0.064
	1.2842	775 N/mm²	110	0.020	0.025	0.034	0.039	0.050	0.056	0.067
	Steel	1400 N/mm²	60	0.010	0.014	0.017	0.021	0.025	0.030	0.036



ae = 0.5 x d
ap = 2 x d

REFERENCE VALUES FOR ROUGHING

WZF 11248 WZF 11258	Material	Strength	Vc[1] m/min.	d						
				6	8	10	12	16	20	25
				fz[2] (mm/z)						
	1.1730	640 N/mm²	140	0.025	0.034	0.043	0.052	0.062	0.074	0.089
	1.2083	780 N/mm²	100	0.012	0.017	0.022	0.026	0.031	0.037	0.044
	1.2085	1080 N/mm²	100	0.012	0.017	0.022	0.026	0.031	0.037	0.044
	1.2162	660 N/mm²	120	0.022	0.031	0.039	0.048	0.056	0.067	0.080
	1.2311	1080 N/mm²	120	0.018	0.025	0.031	0.038	0.045	0.054	0.065
	1.2312	1080 N/mm²	120	0.017	0.023	0.029	0.036	0.042	0.050	0.060
	1.2316	1010 N/mm²	100	0.012	0.017	0.022	0.026	0.031	0.037	0.044
	1.2343	780 N/mm²	120	0.022	0.031	0.039	0.048	0.056	0.067	0.080
	1.2379	780 N/mm²	100	0.012	0.017	0.022	0.026	0.031	0.037	0.044
	1.2714HH	1350 N/mm²	80	0.012	0.017	0.022	0.026	0.031	0.037	0.044
	1.2767	830 N/mm²	120	0.021	0.029	0.037	0.045	0.053	0.064	0.077
	1.2842	775 N/mm²	120	0.022	0.031	0.039	0.048	0.056	0.067	0.080
	Steel	1400 N/mm²	80	0.012	0.017	0.022	0.026	0.031	0.037	0.044



ae = 0.25 x d
ap = 2 x d

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.

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