

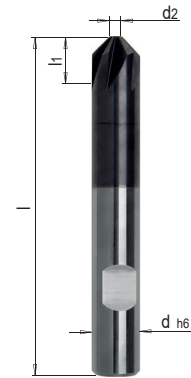


### PRODUCT DESCRIPTION

» For chamfering and deburring workpiece edges

### MATERIAL

» Carbide, TiAlN multi-layer coated



Z	d2	l	l1	d	No.	EUR
6	1.5	50	1.25	4	WZF 15238/ 4	< >
6	1.5	57	2.25	6	WZF 15238/ 6	< >
6	2	63	3	8	WZF 15238/ 8	< >
6	3	72	3.5	10	WZF 15238/10	< >
6	3	83	4.5	12	WZF 15238/12	< >
6	4	92	6	16	WZF 15238/16	< >

### REFERENCE VALUES FOR CHAMFERING

WZF 15234 WZF 15236 WZF 15238	Material	Strength	Vc <sup>1</sup> m/min.	d					
				4	6	8	10	12	16
				fz <sup>2</sup> (mm/z)					
	1.1730	640 N/mm <sup>2</sup>	120	0.040	0.050	0.065	0.070	0.080	0.100
	1.2083	780 N/mm <sup>2</sup>	100	0.040	0.050	0.065	0.070	0.080	0.085
	1.2085	1080 N/mm <sup>2</sup>	100	0.038	0.048	0.060	0.065	0.075	0.080
	1.2162	660 N/mm <sup>2</sup>	120	0.040	0.050	0.065	0.070	0.080	0.100
	1.2311	1080 N/mm <sup>2</sup>	100	0.038	0.048	0.060	0.065	0.075	0.088
	1.2312	1080 N/mm <sup>2</sup>	100	0.038	0.048	0.060	0.065	0.075	0.088
	1.2316	1010 N/mm <sup>2</sup>	100	0.038	0.048	0.060	0.065	0.075	0.080
	1.2343	780 N/mm <sup>2</sup>	120	0.040	0.050	0.065	0.070	0.080	0.100
	1.2379	780 N/mm <sup>2</sup>	100	0.040	0.050	0.065	0.070	0.080	0.085
	1.2714HH	1350 N/mm <sup>2</sup>	90	0.038	0.048	0.060	0.065	0.075	0.080
	1.2767	830 N/mm <sup>2</sup>	120	0.040	0.050	0.065	0.070	0.080	0.088
	1.2842	775 N/mm <sup>2</sup>	120	0.040	0.050	0.065	0.070	0.080	0.088
	Steel	1400 N/mm <sup>2</sup>	90	0.038	0.048	0.060	0.065	0.075	0.080



$ap \approx 0.2 \times d$

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.