



PRODUCT DESCRIPTION

- » High-performance milling cutter for aluminium materials
- » With non-uniform pitch and centre cut
- » Cutting edge length 4xd

MATERIAL

» Carbide, polished



Z	d3	l	l1	C	d	No.	EUR
3	6	65	24	0.06	6	WZF 12868/ 6	<>
3	8	75	32	0.08	8	WZF 12868/ 8	<>
3	10	100	40	0.1	10	WZF 12868/10	<>
3	12	100	48	0.12	12	WZF 12868/12	<>
3	16	125	64	0.16	16	WZF 12868/16	<>
3	20	150	80	0.2	20	WZF 12868/20	<>

REFERENCE VALUES FOR ROUGHING

WZF 12868 WZF 12878	Material	Strength	Vc ¹ m/min.	d					
				6	8	10	12	16	20
				fz ² (mm/z)					
<p>ae = 0.25 x d ap = 3 x d</p>	3.3547 / EN AW-5083	270 N/mm ²	500	0.040	0.050	0.065	0.080	0.095	0.110
	3.4365 / EN AW-7075	520 N/mm ²	500	0.040	0.050	0.065	0.080	0.095	0.110
	Copper	280 N/mm ²	300	0.030	0.040	0.055	0.065	0.080	0.095
	Non-ferrous metal	<800 N/mm ²	300	0.030	0.040	0.055	0.065	0.080	0.095

REFERENCE VALUES FOR FINISH MILLING

WZF 12868 WZF 12878	Material	Strength	Vc ¹ m/min.	d					
				6	8	10	12	16	20
				fz ² (mm/z)					
<p>ae = 0.1 x d ap = 3 x d</p>	3.3547 / EN AW-5083	270 N/mm ²	600	0.050	0.070	0.090	0.100	0.120	0.140
	3.4365 / EN AW-7075	520 N/mm ²	600	0.050	0.070	0.090	0.100	0.120	0.140
	Copper	280 N/mm ²	400	0.040	0.050	0.070	0.090	0.100	0.120
	Non-ferrous metal	<800 N/mm ²	400	0.040	0.050	0.070	0.090	0.100	0.120

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.