

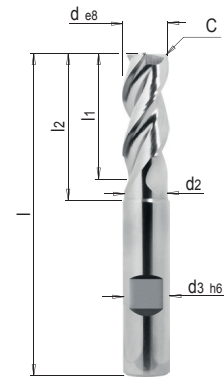


PRODUCT DESCRIPTION

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

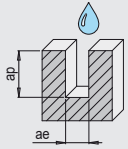
MATERIAL

» Carbide, polished



Z	d2	d3	l	l1	l2	C	d	No.	EUR
3	2.8	6	57	8	15	0.03	3	WZF 12848/ 3	< >
3	3.8	6	57	11	18	0.04	4	WZF 12848/ 4	< >
3	4.8	6	57	13	18	0.05	5	WZF 12848/ 5	< >
3	5.7	6	57	13	20	0.06	6	WZF 12848/ 6	< >
3	7.7	8	63	19	26	0.08	8	WZF 12848/ 8	< >
3	9.5	10	73	22	30	0.1	10	WZF 12848/10	< >
3	11.5	12	83	26	36	0.12	12	WZF 12848/12	< >
3	15.5	16	92	32	42	0.16	16	WZF 12848/16	< >
3	19.5	20	104	38	52	0.2	20	WZF 12848/20	< >

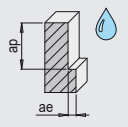
REFERENCE VALUES FOR SLOTTING

WZF 12848 WZF 12858	Material	Strength	Vc ¹ m/min.	d							
				4	5	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	350	0.018	0.018	0.035	0.045	0.060	0.070	0.090	0.100
	3.4365 / EN AW-7075	520 N/mm ²	350	0.018	0.018	0.035	0.045	0.060	0.070	0.090	0.100
	Copper	280 N/mm ²	250	0.016	0.016	0.030	0.040	0.055	0.065	0.080	0.095
	Non-ferrous metal	<800 N/mm ²	250	0.016	0.016	0.030	0.040	0.055	0.065	0.080	0.095

REFERENCE VALUES FOR ROUGHING


WZF 12848 WZF 12858	Material	Strength	Vc ¹ m/min.	d							
				4	5	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	0.020	0.020	0.040	0.050	0.065	0.080	0.095	0.110
	3.4365 / EN AW-7075	520 N/mm ²	500	0.020	0.020	0.040	0.050	0.065	0.080	0.095	0.110
	Copper	280 N/mm ²	300	0.015	0.016	0.025	0.035	0.045	0.050	0.065	0.080
	Non-ferrous metal	<800 N/mm ²	300	0.015	0.016	0.025	0.035	0.045	0.050	0.065	0.080

REFERENCE VALUES FOR FINISH MILLING

WZF 12848 WZF 12858	Material	Strength	Vc ¹ m/min.	d							
				4	5	6	8	10	12	16	20
				fz ² (mm/z)							
 <p>ae = 0.1 x d ap = 1.5 x d</p>	3.3547 / EN AW-5083	270 N/mm ²	600	0.024	0.024	0.048	0.060	0.078	0.096	0.114	0.132
	3.4365 / EN AW-7075	520 N/mm ²	600	0.024	0.024	0.048	0.060	0.078	0.096	0.114	0.132
	Copper	280 N/mm ²	400	0.0192	0.019	0.036	0.048	0.066	0.078	0.096	0.114
	Non-ferrous metal	<800 N/mm ²	400	0.0192	0.019	0.036	0.048	0.066	0.078	0.096	0.114

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.