

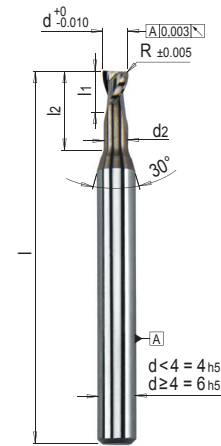


PRODUCT DESCRIPTION

- » Ultimate precision in the μ range
- » Polished cutting edges and chip spaces
- » High-performance milling cutter for copper

MATERIAL

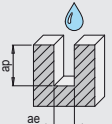
- » Carbide, polished



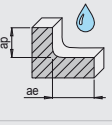
Z	d2	d3	l	l1	d	l2	R	No.	EUR
2	0.18	4	50	0.3	0.2	1.5	0.02	WZF 27896/0,2/1,5/0,02	<>
2	0.27	4	50	0.5	0.3	1.5	0.02	WZF 27896/0,3/1,5/0,02	<>
2	0.27	4	50	0.5	0.3	3	0.02	WZF 27896/0,3/3 /0,02	<>
2	0.36	4	50	0.6	0.4	2	0.02	WZF 27896/0,4/2 /0,02	<>
2	0.36	4	50	0.6	0.4	4	0.02	WZF 27896/0,4/4 /0,02	<>
2	0.45	4	50	0.7	0.5	2.5	0.05	WZF 27896/0,5/ 2,5/0,05	<>
2	0.45	4	50	0.7	0.5	5	0.05	WZF 27896/0,5/ 5 /0,05	<>
2	0.45	4	50	0.7	0.5	7.5	0.05	WZF 27896/0,5/ 7,5/0,05	<>
2	0.45	4	50	0.7	0.5	10	0.05	WZF 27896/0,5/10 /0,05	<>
2	0.45	4	50	1	0.6	3	0.05	WZF 27896/0,6/ 3 /0,05	<>
2	0.55	4	50	1	0.6	6	0.05	WZF 27896/0,6/ 6 /0,05	<>
2	0.75	4	50	1.2	0.8	4	0.05	WZF 27896/0,8/ 4 /0,05	<>
2	0.75	4	50	1.2	0.8	8	0.05	WZF 27896/0,8/ 8 /0,05	<>
2	0.95	4	50	1.6	1	5	0.1	WZF 27896/1 / 5 /0,1	<>
2	0.95	4	50	1.6	1	10	0.1	WZF 27896/1 /10 /0,1	<>
2	0.95	4	50	1.6	1	15	0.1	WZF 27896/1 /15 /0,1	<>
2	1.45	4	60	2.4	1.5	5	0.1	WZF 27896/1,5/ 5 /0,1	<>
2	1.45	4	60	2.4	1.5	10	0.1	WZF 27896/1,5/10 /0,1	<>
2	1.45	4	60	2.4	1.5	15	0.1	WZF 27896/1,5/15 /0,1	<>
2	1.45	4	60	2.4	1.5	20	0.1	WZF 27896/1,5/20 /0,1	<>
2	1.92	4	60	3	2	6	0.2	WZF 27896/2 /6 /0,2	<>
2	1.92	4	60	3	2	12	0.2	WZF 27896/2 /12 /0,2	<>
2	1.92	4	60	3	2	18	0.2	WZF 27896/2 /18 /0,2	<>

Z	d2	d3	l	l1	d	l2	R	No.	EUR
2	1.92	4	60	3	2	24	0.2	WZF 27896/2 /24 /0,2	<>
2	1.92	4	60	3	2	30	0.2	WZF 27896/2 /30 /0,2	<>
2	2.9	4	60	3.5	3	9	0.2	WZF 27896/3 / 9 /0,2	<>
2	2.9	4	60	3.5	3	18	0.2	WZF 27896/3 /18 /0,2	<>
2	2.9	4	60	3.5	3	30	0.2	WZF 27896/3 /30 /0,2	<>
2	3.9	6	60	4	4	12	0.2	WZF 27896/4 /12 /0,2	<>
2	3.9	6	60	4	4	24	0.2	WZF 27896/4 /24 /0,2	<>
2	4.9	6	60	5	5	15	0.5	WZF 27896/5 /15 /0,5	<>
2	4.9	6	60	5	5	30	0.5	WZF 27896/5 /30 /0,5	<>
2	5.9	6	60	6	6	18	0.5	WZF 27896/6 /18 /0,5	<>
2	5.9	6	60	6	6	30	0.5	WZF 27896/6 /30 /0,5	<>
4	7.8	8	70	12	8	16	0.5	WZF 27896/8 /16 /0,5	<>
4	7.8	8	70	12	8	30	0.5	WZF 27896/8 /30 /0,5	<>
4	7.8	8	70	12	8	16	1	WZF 27896/8 /16 /1	<>
4	7.8	8	70	12	8	30	1	WZF 27896/8 /30 /1	<>
4	9.8	10	80	15	10	20	0.5	WZF 27896/10 /20 /0,5	<>
4	9.8	10	80	15	10	30	0.5	WZF 27896/10 /30 /0,5	<>
4	9.8	10	80	15	10	20	1	WZF 27896/10 /20 /1	<>
4	9.8	10	80	15	10	30	1	WZF 27896/10 /30 /1	<>
4	11.8	12	80	18	12	24	0.5	WZF 27896/12 /24 /0,5	<>
4	11.8	12	80	18	12	30	0.5	WZF 27896/12 /30 /0,5	<>
4	11.8	12	80	18	12	24	1	WZF 27896/12 /24 /1	<>
4	11.8	12	80	18	12	30	1	WZF 27896/12 /30 /1	<>

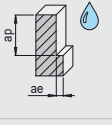
REFERENCE VALUES FOR FULL SECTION

WZF 27896	Material	Vc ¹ m/min.	d												
			0.3	0.5	0.8	1	1.5	2	3	4	5	6	8	10	12
			fz ² (mm/z)												
	Copper	160	0.003	0.004	0.006	0.008	0.012	0.015	0.024	0.032	0.040	0.048	0.060	0.070	0.085
	Aluminium	120	0.003	0.003	0.005	0.006	0.009	0.012	0.018	0.024	0.030	0.036	0.048	0.060	0.075
	Non-ferrous metal	100	0.003	0.003	0.004	0.005	0.008	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060
	ap (mm)		0.15	0.25	0.40	0.50	0.75	1.00	1.50	2.00	2.50	3.00	4.00	5.00	6.00
	ae (mm)		0.30	0.50	0.80	1.00	1.50	2.00	3.00	4.00	5.00	6.00	8.00	10.00	12.00

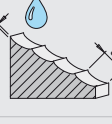
REFERENCE VALUES FOR ROUGHING

WZF 27896	Material	Vc ¹ m/min.	d												
			0.3	0.5	0.8	1	1.5	2	3	4	5	6	8	10	12
			fz ² (mm/z)												
	Copper	200	0.014	0.023	0.036	0.045	0.068	0.090	0.135	0.180	0.225	0.270	0.320	0.410	0.500
	Aluminium	160	0.008	0.013	0.020	0.025	0.038	0.050	0.075	0.100	0.125	0.150	0.200	0.250	0.300
	Non-ferrous metal	125	0.006	0.010	0.016	0.020	0.030	0.040	0.060	0.080	0.100	0.120	0.160	0.200	0.240
	ap (mm)		0.02	0.04	0.06	0.08	0.12	0.16	0.24	0.32	0.40	0.48	0.60	0.70	0.85
	ae (mm)		0.12	0.20	0.32	0.40	0.60	0.80	1.20	1.60	2.00	2.40	3.20	4.00	4.80

REFERENCE VALUES FOR TRIMMING

WZF 27896	Material	Vc ¹ m/min.	d												
			0.3	0.5	0.8	1	1.5	2	3	4	5	6	8	10	12
			fz ² (mm/z)												
	Copper	320	0.003	0.004	0.006	0.008	0.012	0.016	0.024	0.032	0.040	0.048	0.064	0.080	0.100
	Aluminium	240	0.003	0.004	0.006	0.008	0.012	0.016	0.024	0.032	0.040	0.048	0.064	0.080	0.100
	Non-ferrous metal	190	0.003	0.004	0.006	0.008	0.012	0.016	0.024	0.032	0.040	0.048	0.064	0.080	0.100
	ap (mm)		0.45	0.75	1.20	1.50	2.25	3.00	3.50	4.00	5.00	6.00	9.00	12.00	15.00
	ae (mm)		0.003	0.005	0.008	0.010	0.015	0.020	0.030	0.040	0.050	0.060	0.080	0.100	0.150

REFERENCE VALUES FOR 3D FINISH MILLING

WZF 27896	Material	Vc ¹ m/min.	d												
			0.3	0.5	0.8	1	1.5	2	3	4	5	6	8	10	12
			fz ² (mm/z)												
	Copper	360	0.003	0.004	0.005	0.008	0.012	0.016	0.030	0.040	0.050	0.060	0.080	0.100	0.120
	Aluminium	300	0.003	0.004	0.005	0.008	0.012	0.016	0.030	0.040	0.050	0.060	0.080	0.100	0.120
	Non-ferrous metal	250	0.003	0.004	0.005	0.008	0.012	0.016	0.030	0.040	0.050	0.060	0.080	0.100	0.120
	ap (mm)		0.006	0.010	0.016	0.020	0.030	0.040	0.060	0.080	0.100	0.120	0.160	0.200	0.240
	ae (mm)		0.005	0.008	0.012	0.015	0.023	0.030	0.045	0.060	0.075	0.090	0.120	0.150	0.180

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

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

i You can find further materials and cutting values in the cutting data calculator.