



### PRODUCT DESCRIPTION

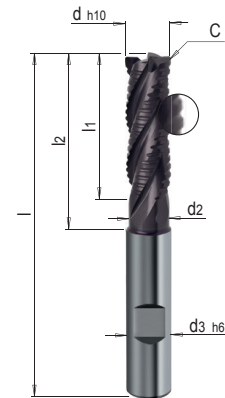
- » Relieved behind the cutting edge
- » High-performance milling cutter with non-uniform pitch and centre cut

### MATERIAL

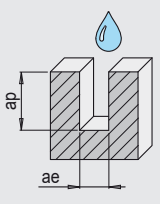
- » Carbide, TiAlN multi-layer coated



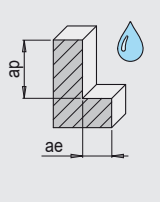
Z	d2	d3	l	l1	l2	C	d	No.	EUR
4	5.5	6	65	18	28	0.3	6	WZF 11258/ 6	< >
4	7.5	8	75	24	38	0.3	8	WZF 11258/ 8	< >
4	9.2	10	80	30	38	0.3	10	WZF 11258/10	< >
4	11.2	12	93	36	46	0.5	12	WZF 11258/12	< >
4	15	16	108	48	58	0.5	16	WZF 11258/16	< >
4	19	20	126	60	74	0.5	20	WZF 11258/20	< >



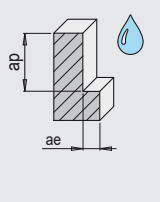
## REFERENCE VALUES FOR SLOTTING

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

## REFERENCE VALUES FOR ROUGHING

WZF 11248 WZF 11258	Material	Strength	Vc <sup>1</sup> m/min.	d						
				6	8	10	12	16	20	25
				fz <sup>2</sup> (mm/z)						
 <p>ap = 0.5 x d ae = 2 x d</p>	1.1730	640 N/mm <sup>2</sup>	130	0.022	0.028	0.037	0.043	0.055	0.062	0.074
	1.2083	780 N/mm <sup>2</sup>	90	0.010	0.014	0.017	0.021	0.025	0.030	0.036
	1.2085	1080 N/mm <sup>2</sup>	90	0.010	0.014	0.017	0.021	0.025	0.030	0.036
	1.2162	660 N/mm <sup>2</sup>	110	0.020	0.025	0.034	0.039	0.050	0.056	0.067
	1.2311	1080 N/mm <sup>2</sup>	110	0.016	0.020	0.027	0.031	0.040	0.045	0.054
	1.2312	1080 N/mm <sup>2</sup>	110	0.015	0.019	0.025	0.029	0.038	0.042	0.050
	1.2316	1010 N/mm <sup>2</sup>	90	0.010	0.014	0.017	0.021	0.025	0.030	0.036
	1.2343	780 N/mm <sup>2</sup>	110	0.020	0.025	0.034	0.039	0.050	0.056	0.067
	1.2379	780 N/mm <sup>2</sup>	90	0.010	0.014	0.017	0.021	0.025	0.030	0.036
	1.2714HH	1350 N/mm <sup>2</sup>	60	0.010	0.014	0.017	0.021	0.025	0.030	0.036
	1.2767	830 N/mm <sup>2</sup>	110	0.019	0.024	0.032	0.037	0.048	0.053	0.064
	1.2842	775 N/mm <sup>2</sup>	110	0.020	0.025	0.034	0.039	0.050	0.056	0.067
	Steel	1400 N/mm <sup>2</sup>	60	0.010	0.014	0.017	0.021	0.025	0.030	0.036

## REFERENCE VALUES FOR ROUGHING

WZF 11248 WZF 11258	Material	Strength	Vc <sup>1</sup> m/min.	d						
				6	8	10	12	16	20	25
				fz <sup>2</sup> (mm/z)						
 <p>ap = 0.25 x d ae = 2 x d</p>	1.1730	640 N/mm <sup>2</sup>	140	0.025	0.034	0.043	0.052	0.062	0.074	0.089
	1.2083	780 N/mm <sup>2</sup>	100	0.012	0.017	0.022	0.026	0.031	0.037	0.044
	1.2085	1080 N/mm <sup>2</sup>	100	0.012	0.017	0.022	0.026	0.031	0.037	0.044
	1.2162	660 N/mm <sup>2</sup>	120	0.022	0.031	0.039	0.048	0.056	0.067	0.080
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	1.2343	780 N/mm <sup>2</sup>	120	0.022	0.031	0.039	0.048	0.056	0.067	0.080
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	1.2842	775 N/mm <sup>2</sup>	120	0.022	0.031	0.039	0.048	0.056	0.067	0.080
	Steel	1400 N/mm <sup>2</sup>	80	0.012	0.017	0.022	0.026	0.031	0.037	0.044

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.