

PRODUCT DESCRIPTION

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

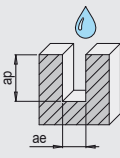
MATERIAL

» Carbide, polished

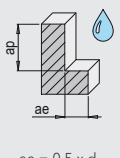


Z	d2	d3	l	l1	l2	d	R	No.	EUR
3	5.7	6	57	13	20	6	0.5	WZF 128481/ 6/0,5	<>
3	5.7	6	57	13	20	6	1	WZF 128481/ 6/ 1	<>
3	7.7	8	63	19	26	8	0.5	WZF 128481/ 8/0,5	<>
3	7.7	8	63	19	26	8	1	WZF 128481/ 8/ 1	<>
3	9.5	10	72	22	30	10	0.5	WZF 128481/10/0,5	<>
3	9.5	10	72	22	30	10	1	WZF 128481/10/ 1	<>
3	9.5	10	72	22	30	10	1.5	WZF 128481/10/ 1,5	<>
3	11.5	12	83	26	36	12	1	WZF 128481/12/ 1	<>
3	11.5	12	83	26	36	12	2	WZF 128481/12/ 2	<>
3	11.5	12	83	26	36	12	3	WZF 128481/12/ 3	<>
3	15.5	16	92	32	42	16	1	WZF 128481/16/ 1	<>
3	15.5	16	92	32	42	16	2	WZF 128481/16/ 2	<>
3	15.5	16	92	32	42	16	3	WZF 128481/16/ 3	<>

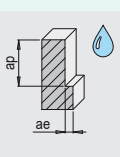
REFERENCE VALUES FOR SLOTTING

WZF 128481	Material	Strength	Vc ¹ m/min.	d				
				6	8	10	12	16
				fz ² (mm/z)				
 <p>ae = 1 x d ap = 1 x d</p>	3.3547 / EN AW-5083	270 N/mm ²	350	0.035	0.045	0.060	0.070	0.090
	3.4365 / EN AW-7075	520 N/mm ²	350	0.035	0.045	0.060	0.070	0.090
	Copper	280 N/mm ²	250	0.025	0.035	0.045	0.050	0.065
	Non-ferrous metal	<800 N/mm ²	250	0.025	0.035	0.045	0.050	0.065

REFERENCE VALUES FOR ROUGHING


WZF 128481	Material	Strength	Vc ¹ m/min.	d				
				6	8	10	12	16
				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	0.040	0.050	0.070	0.080	0.110
	3.4365 / EN AW-7075	520 N/mm ²	500	0.040	0.050	0.070	0.080	0.110
	Copper	280 N/mm ²	300	0.030	0.040	0.050	0.060	0.080
	Non-ferrous metal	<800 N/mm ²	300	0.030	0.040	0.050	0.060	0.080

REFERENCE VALUES FOR FINISH MILLING

WZF 128481	Material	Strength	Vc ¹ m/min.	d				
				6	8	10	12	16
				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	0.050	0.060	0.080	0.100	0.130
	3.4365 / EN AW-7075	520 N/mm ²	600	0.050	0.060	0.080	0.100	0.130
	Copper	280 N/mm ²	400	0.040	0.050	0.060	0.070	0.090
	Non-ferrous metal	<800 N/mm ²	400	0.040	0.050	0.060	0.070	0.090

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.