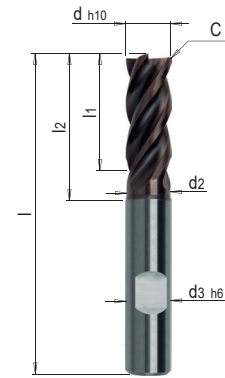


PRODUCT DESCRIPTION

- » High-performance milling cutter with non-uniform pitch and centre cut
- » Relieved behind the cutting edge
- » With optimised front geometry for quick immersion

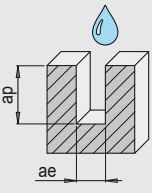
MATERIAL

- » Carbide, TiAlSiN coated

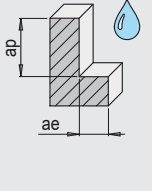


| Z | d2 | d3 | l | l1 | l2 | C | d | No. | EUR |
|---|------|----|----|----|----|------|----|---------------|-----|
| 4 | 3.7 | 6 | 57 | 11 | 18 | 0.04 | 4 | WZF 126486/ 4 | < > |
| 4 | 5.7 | 6 | 57 | 13 | 20 | 0.06 | 6 | WZF 126486/ 6 | < > |
| 4 | 7.7 | 8 | 63 | 19 | 26 | 0.08 | 8 | WZF 126486/ 8 | < > |
| 4 | 11.7 | 10 | 72 | 22 | 30 | 0.1 | 10 | WZF 126486/10 | < > |
| 4 | 13.7 | 12 | 83 | 26 | 36 | 0.12 | 12 | WZF 126486/12 | < > |
| 4 | 15.6 | 16 | 92 | 32 | 42 | 0.16 | 16 | WZF 126486/16 | < > |

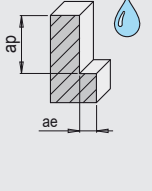
REFERENCE VALUES FOR SLOTTING

| WZF 126486 | Material | Strength | Vc ¹ m/min. | d | | | | | |
|--|----------|------------------------|---------------------------|------------------------|-------|-------|-------|-------|-------|
| | | | | 4 | 6 | 8 | 10 | 12 | 16 |
| | | | | fz ² (mm/z) | | | | | |
|  <p>ae = 1 x d ap = 1 x d</p> | 1.1730 | 640 N/mm ² | 270 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 |
| | 1.2083 | 780 N/mm ² | 200 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 |
| | 1.2085 | 1080 N/mm ² | 200 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 |
| | 1.2162 | 660 N/mm ² | 240 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 |
| | 1.2311 | 1080 N/mm ² | 230 | 0.018 | 0.027 | 0.035 | 0.044 | 0.053 | 0.071 |
| | 1.2312 | 1080 N/mm ² | 240 | 0.018 | 0.027 | 0.035 | 0.044 | 0.053 | 0.071 |
| | 1.2316 | 1010 N/mm ² | 200 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 |
| | 1.2343 | 780 N/mm ² | 240 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 |
| | 1.2379 | 780 N/mm ² | 200 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 |
| | 1.2714HH | 1350 N/mm ² | 150 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 |
| | 1.2767 | 830 N/mm ² | 240 | 0.018 | 0.027 | 0.035 | 0.044 | 0.053 | 0.071 |
| | 1.2842 | 775 N/mm ² | 240 | 0.018 | 0.027 | 0.035 | 0.044 | 0.053 | 0.071 |
| | Steel | 1400 N/mm ² | 110 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 |

REFERENCE VALUES FOR ROUGHING


| WZF 126486 | Material | Strength | Vc ¹ m/min. | d | | | | | |
|---|----------|------------------------|---------------------------|------------------------|-------|-------|-------|-------|-------|
| | | | | 4 | 6 | 8 | 10 | 12 | 16 |
| | | | | fz ² (mm/z) | | | | | |
|  <p>ae = 0.4 x d ap = 2 x d</p> | 1.1730 | 640 N/mm ² | 350 | 0.023 | 0.035 | 0.046 | 0.058 | 0.069 | 0.092 |
| | 1.2083 | 780 N/mm ² | 260 | 0.019 | 0.028 | 0.037 | 0.046 | 0.056 | 0.074 |
| | 1.2085 | 1080 N/mm ² | 260 | 0.019 | 0.028 | 0.037 | 0.046 | 0.056 | 0.074 |
| | 1.2162 | 660 N/mm ² | 310 | 0.023 | 0.035 | 0.046 | 0.058 | 0.069 | 0.092 |
| | 1.2311 | 1080 N/mm ² | 300 | 0.020 | 0.031 | 0.041 | 0.051 | 0.061 | 0.082 |
| | 1.2312 | 1080 N/mm ² | 310 | 0.020 | 0.031 | 0.041 | 0.051 | 0.061 | 0.082 |
| | 1.2316 | 1010 N/mm ² | 260 | 0.019 | 0.028 | 0.037 | 0.046 | 0.056 | 0.074 |
| | 1.2343 | 780 N/mm ² | 310 | 0.023 | 0.035 | 0.046 | 0.058 | 0.069 | 0.092 |
| | 1.2379 | 780 N/mm ² | 260 | 0.019 | 0.028 | 0.037 | 0.046 | 0.056 | 0.074 |
| | 1.2714HH | 1350 N/mm ² | 200 | 0.019 | 0.028 | 0.037 | 0.046 | 0.056 | 0.074 |
| | 1.2767 | 830 N/mm ² | 310 | 0.020 | 0.031 | 0.041 | 0.051 | 0.061 | 0.082 |
| | 1.2842 | 775 N/mm ² | 310 | 0.020 | 0.031 | 0.041 | 0.051 | 0.061 | 0.082 |
| | Steel | 1400 N/mm ² | 140 | 0.019 | 0.028 | 0.037 | 0.046 | 0.056 | 0.074 |

REFERENCE VALUES FOR FINISH MILLING

| WZF 126486 | Material | Strength | Vc ¹ m/min. | d | | | | | |
|---|----------|------------------------|---------------------------|------------------------|-------|-------|-------|-------|-------|
| | | | | 4 | 6 | 8 | 10 | 12 | 16 |
| | | | | fz ² (mm/z) | | | | | |
|  <p>ae = 0.02 x d ap = 2 x d</p> | 1.1730 | 640 N/mm ² | 540 | 0.025 | 0.038 | 0.051 | 0.063 | 0.076 | 0.101 |
| | 1.2083 | 780 N/mm ² | 400 | 0.020 | 0.031 | 0.041 | 0.051 | 0.061 | 0.082 |
| | 1.2085 | 1080 N/mm ² | 400 | 0.020 | 0.031 | 0.041 | 0.051 | 0.061 | 0.082 |
| | 1.2162 | 660 N/mm ² | 480 | 0.025 | 0.038 | 0.051 | 0.063 | 0.076 | 0.101 |
| | 1.2311 | 1080 N/mm ² | 460 | 0.022 | 0.034 | 0.045 | 0.056 | 0.067 | 0.090 |
| | 1.2312 | 1080 N/mm ² | 480 | 0.022 | 0.034 | 0.045 | 0.056 | 0.067 | 0.090 |
| | 1.2316 | 1010 N/mm ² | 400 | 0.020 | 0.031 | 0.041 | 0.051 | 0.061 | 0.082 |
| | 1.2343 | 780 N/mm ² | 480 | 0.025 | 0.038 | 0.051 | 0.063 | 0.076 | 0.101 |
| | 1.2379 | 780 N/mm ² | 400 | 0.020 | 0.031 | 0.041 | 0.051 | 0.061 | 0.082 |
| | 1.2714HH | 1350 N/mm ² | 300 | 0.020 | 0.031 | 0.041 | 0.051 | 0.061 | 0.082 |
| | 1.2767 | 830 N/mm ² | 480 | 0.022 | 0.034 | 0.045 | 0.056 | 0.067 | 0.090 |
| | 1.2842 | 775 N/mm ² | 480 | 0.022 | 0.034 | 0.045 | 0.056 | 0.067 | 0.090 |
| | Steel | 1400 N/mm ² | 220 | 0.020 | 0.031 | 0.041 | 0.051 | 0.061 | 0.082 |

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.