

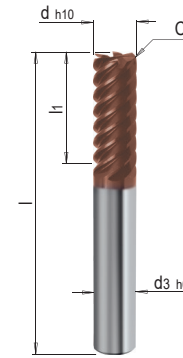


### PRODUCT DESCRIPTION

» High-performance milling cutter with centre cut for fine finishing

### MATERIAL

» Carbide, TiAlSiN multi-layer coated



Z	d3	l	l1	C	d	No.	EUR
6	6	57	8	0.05	3	WZF 13546/ 3	< >
6	6	57	11	0.05	4	WZF 13546/ 4	< >
6	6	57	13	0.05	5	WZF 13546/ 5	< >
6	6	57	13	0.05	6	WZF 13546/ 6	< >
6	8	63	19	0.1	8	WZF 13546/ 8	< >
6	10	72	22	0.1	10	WZF 13546/10	< >
6	12	83	26	0.1	12	WZF 13546/12	< >
6	14	83	26	0.15	14	WZF 13546/14	< >
6	16	92	32	0.15	16	WZF 13546/16	< >
8	18	92	32	0.15	18	WZF 13546/18	< >
8	20	104	38	0.15	20	WZF 13546/20	< >

### REFERENCE VALUES FOR FINISH MILLING

WZF 13546 WZF 135461	Material	Strength	Vc <sup>1</sup> m/min.	d											
				3	4	5	6	8	10	12	14	16	18	20	
				fz <sup>2</sup> (mm/z)											
<p>ae = 0.05 x d ap = 1.5 x d</p>	1.2083	52 HRC	90	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057	
	1.2162	52 HRC	120	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057	
	1.2343	52 HRC	120	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057	
	1.2379	60 HRC	90	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057	
	1.2714HH	43 HRC	120	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057	
	1.2767	52 HRC	120	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057	
	1.2842	60 HRC	90	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057	
	Steel	1400 N/mm <sup>2</sup>	120	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057	

### REFERENCE VALUES FOR FINISH MILLING

WZF 13546 WZF 135461	Material	Strength	Vc <sup>1</sup> m/min.	d											
				3	4	5	6	8	10	12	14	16	18	20	
				fz <sup>2</sup> (mm/z)											
<p>ae = 0.1 x d ap = 1.5 x d</p>	1.2083	52 HRC	100	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057	
	1.2162	52 HRC	140	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057	
	1.2343	52 HRC	140	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057	
	1.2379	60 HRC	100	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057	
	1.2714HH	43 HRC	140	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057	
	1.2767	52 HRC	140	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057	
	1.2842	60 HRC	100	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057	
	Steel	1400 N/mm <sup>2</sup>	140	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057	

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.