



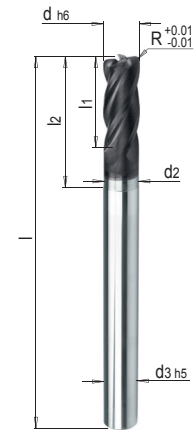
### PRODUCT DESCRIPTION

- » Ultimate precision in the  $\mu$  range
- » For highly precise contours and perfect concentricity
- » High-performance milling cutter for graphite

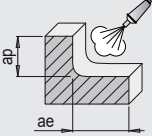
### MATERIAL

- » Carbide, diamond coated

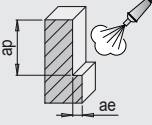
Z	d2	d3	l	l1	d	l2	R	No.	EUR
4	7.8	8	90	16	8	30	0.5	WZF 27998/8 /30 /0,5	<>
4	7.8	8	90	16	8	30	1	WZF 27998/8 /30 / 1	<>
4	7.8	8	100	16	8	60	0.5	WZF 27998/8 /60 /0,5	<>
4	7.8	8	100	16	8	60	1	WZF 27998/8 /60 / 1	<>
4	7.8	8	120	16	8	80	0.5	WZF 27998/8 /80 /0,5	<>
4	7.8	8	120	16	8	80	1	WZF 27998/8 /80 / 1	<>
4	9.8	10	90	20	10	35	0.5	WZF 27998/10 /35 /0,5	<>
4	9.8	10	90	20	10	35	1	WZF 27998/10 /35 / 1	<>
4	9.8	10	100	20	10	60	0.5	WZF 27998/10 /60 /0,5	<>
4	9.8	10	100	20	10	60	1	WZF 27998/10 /60 / 1	<>
4	9.8	10	120	20	10	80	0.5	WZF 27998/10 /80 /0,5	<>
4	9.8	10	120	20	10	80	1	WZF 27998/10 /80 / 1	<>
4	11.8	12	100	24	12	40	0.5	WZF 27998/12 /40 /0,5	<>
4	11.8	12	100	24	12	40	1	WZF 27998/12 /40 / 1	<>
4	11.8	12	108	24	12	60	0.5	WZF 27998/12 /60 /0,5	<>
4	11.8	12	108	24	12	60	1	WZF 27998/12 /60 / 1	<>
4	11.8	12	120	24	12	80	0.5	WZF 27998/12 /80 /0,5	<>
4	11.8	12	120	24	12	80	1	WZF 27998/12 /80 / 1	<>



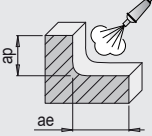
## REFERENCE VALUES FOR ROUGHING

WZF 27998	Material	Grit size	Vc <sup>1</sup> m/min.	d		
				8	10	12
				fz <sup>2</sup> (mm/z)		
	Graphite	1 - 4 μ	200	0.080	0.100	0.125
	Graphite	5 - 8 μ	250	0.089	0.112	0.140
	Graphite	9 - 12 μ	300	0.100	0.126	0.156
	Graphite	13 - 25 μ	350	0.113	0.140	0.159
	ap (mm) ae (mm)			11.20 2.00	14.00 2.50	16.80 3.00

## REFERENCE VALUES FOR FINISH MILLING

WZF 27998	Material	Grit size	Vc <sup>1</sup> m/min.	d		
				8	10	12
				fz <sup>2</sup> (mm/z)		
	Graphite	1 - 4 μ	250	0.090	0.115	0.143
	Graphite	5 - 8 μ	300	0.113	0.128	0.160
	Graphite	9 - 12 μ	350	0.115	0.145	0.179
	Graphite	13 - 25 μ	400	0.129	0.160	0.182
	ap (mm) ae (mm)			12.00 0.80	15.00 1.00	18.00 1.20

## REFERENCE VALUES FOR BOTTOM FINISH MILLING

WZF 27998	Material	Grit size	Vc <sup>1</sup> m/min.	d		
				8	10	12
				fz <sup>2</sup> (mm/z)		
	Graphite	1 - 4 μ	250	0.080	0.100	0.125
	Graphite	5 - 8 μ	300	0.089	0.112	0.140
	Graphite	9 - 12 μ	350	0.100	0.126	0.156
	Graphite	13 - 25 μ	400	0.113	0.140	0.159
	ap (mm) ae (mm)			0.50 5.00	0.50 7.00	0.50 9.00

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.