



### PRODUCT DESCRIPTION

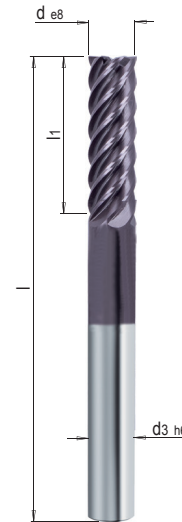
- » High-performance milling cutter without corner protection chamfer
- » Without centre cut
- » Cutting edge length 3xd

### MATERIAL

» Carbide, TiAlN multi-layer coated



Z	d3	l	l1	d	No.	EUR
6	6	63	16	4	WZF 13252P/ 4	< >
6	6	63	18	5	WZF 13252P/ 5	< >
6	6	63	18	6	WZF 13252P/ 6	< >
6	8	68	24	8	WZF 13252P/ 8	< >
6	10	80	30	10	WZF 13252P/10	< >
6	12	93	36	12	WZF 13252P/12	< >
6	16	108	48	16	WZF 13252P/16	< >



### REFERENCE VALUES FOR FINISH MILLING

WZF 13252P	Material	Strength	Vc <sup>1</sup> m/min.	d					
				4	6	8	10	12	16
				fz <sup>2</sup> (mm/z)					
<p>ae = 0.1 x d ap = 1 x d</p>	1.1730	640 N/mm <sup>2</sup>	165	0.023	0.031	0.061	0.077	0.094	0.110
	1.2083	780 N/mm <sup>2</sup>	110	0.015	0.019	0.021	0.027	0.033	0.039
	1.2085	1080 N/mm <sup>2</sup>	110	0.015	0.019	0.021	0.027	0.033	0.039
	1.2162	660 N/mm <sup>2</sup>	165	0.021	0.028	0.055	0.070	0.085	0.100
	1.2311	1080 N/mm <sup>2</sup>	120	0.017	0.022	0.044	0.056	0.068	0.080
	1.2312	1080 N/mm <sup>2</sup>	130	0.016	0.021	0.041	0.053	0.064	0.075
	1.2316	1010 N/mm <sup>2</sup>	110	0.015	0.019	0.021	0.027	0.033	0.039
	1.2343	780 N/mm <sup>2</sup>	130	0.021	0.028	0.055	0.070	0.085	0.100
	1.2379	780 N/mm <sup>2</sup>	110	0.015	0.019	0.021	0.027	0.033	0.039
	1.2714HH	1350 N/mm <sup>2</sup>	80	0.015	0.019	0.021	0.027	0.033	0.039
	1.2767	830 N/mm <sup>2</sup>	130	0.020	0.027	0.052	0.067	0.081	0.095
	1.2842	775 N/mm <sup>2</sup>	130	0.021	0.028	0.055	0.070	0.085	0.100
	Steel	1400 N/mm <sup>2</sup>	80	0.012	0.015	0.030	0.039	0.047	0.055

### REFERENCE VALUES FOR FINISH MILLING

WZF 13252P	Material	Strength	Vc <sup>1</sup> m/min.	d					
				4	6	8	10	12	16
				fz <sup>2</sup> (mm/z)					
<p>ae = 0.05 x d ap = 2 x d</p>	1.1730	640 N/mm <sup>2</sup>	190	0.017	0.021	0.029	0.037	0.037	0.061
	1.2083	780 N/mm <sup>2</sup>	130	0.015	0.019	0.023	0.027	0.031	0.039
	1.2085	1080 N/mm <sup>2</sup>	130	0.015	0.019	0.023	0.027	0.031	0.039
	1.2162	660 N/mm <sup>2</sup>	190	0.017	0.021	0.029	0.037	0.037	0.061
	1.2311	1080 N/mm <sup>2</sup>	140	0.015	0.019	0.023	0.027	0.031	0.039
	1.2312	1080 N/mm <sup>2</sup>	140	0.015	0.019	0.023	0.027	0.031	0.039
	1.2316	1010 N/mm <sup>2</sup>	130	0.015	0.019	0.023	0.027	0.031	0.039
	1.2343	780 N/mm <sup>2</sup>	150	0.017	0.021	0.029	0.037	0.037	0.061
	1.2379	780 N/mm <sup>2</sup>	130	0.015	0.019	0.023	0.027	0.031	0.039
	1.2714HH	1350 N/mm <sup>2</sup>	100	0.015	0.019	0.023	0.027	0.031	0.039
	1.2767	830 N/mm <sup>2</sup>	140	0.017	0.021	0.029	0.037	0.037	0.061
	1.2842	775 N/mm <sup>2</sup>	140	0.017	0.021	0.029	0.037	0.037	0.061
	Steel	1400 N/mm <sup>2</sup>	100	0.014	0.018	0.022	0.026	0.030	0.038

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.