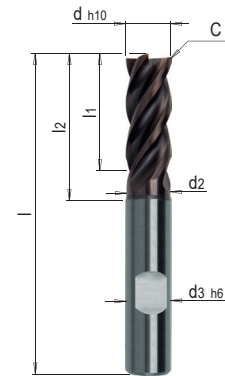


### PRODUCT DESCRIPTION

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

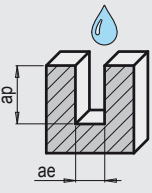
### MATERIAL

- » Carbide, TiAlSiN coated

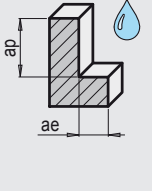


Z	d2	d3	l	l1	l2	C	d	No.	EUR
4	3.7	6	57	11	18	0.04	4	WZF 126486/ 4	< >
4	5.7	6	57	13	20	0.06	6	WZF 126486/ 6	< >
4	7.7	8	63	19	26	0.08	8	WZF 126486/ 8	< >
4	11.7	10	72	22	30	0.1	10	WZF 126486/10	< >
4	13.7	12	83	26	36	0.12	12	WZF 126486/12	< >
4	15.6	16	92	32	42	0.16	16	WZF 126486/16	< >

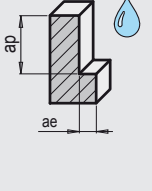
## REFERENCE VALUES FOR SLOTTING

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

## REFERENCE VALUES FOR ROUGHING

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

## REFERENCE VALUES FOR FINISH MILLING

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

**i** You can find further materials and cutting values in the cutting data calculator.