



PRODUCT DESCRIPTION

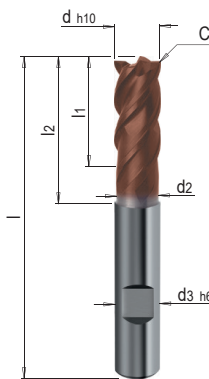
- » High-performance milling cutter for hard machining with non-uniform pitch, core stability and centre cut
- » Relieved behind the cutting edge

MATERIAL

» Carbide, TiAlSiN coated



Z	d2	d3	l	l1	l2	C	d	No.	EUR
4	5.5	6	57	13	20	0.15	6	WZF 125487/ 6	< >
4	7.5	8	63	19	26	0.15	8	WZF 125487/ 8	< >
4	9.2	10	72	22	30	0.2	10	WZF 125487/10	< >
4	11.2	12	83	26	36	0.2	12	WZF 125487/12	< >
4	15	16	92	32	42	0.35	16	WZF 125487/16	< >
4	19	20	104	38	52	0.45	20	WZF 125487/20	< >



REFERENCE VALUES FOR SLOTTING

WZF 125487	Material	Strength	Vc ¹ m/min.	d					
				6	8	10	12	16	20
				fz ² (mm/z)					
	1.2083	52 HRC	60	0.014	0.018	0.024	0.028	0.036	0.040
	1.2162	52 HRC	70	0.014	0.018	0.024	0.028	0.036	0.040
	1.2343	52 HRC	70	0.014	0.018	0.024	0.028	0.036	0.040
	1.2379	60 HRC	-	-	-	-	-	-	-
	1.2714HH	43 HRC	60	0.014	0.018	0.024	0.028	0.036	0.040
	1.2767	52 HRC	70	0.014	0.018	0.024	0.028	0.036	0.040
	1.2842	60 HRC	-	-	-	-	-	-	-
	Steel	1400 N/mm ²	60	0.014	0.018	0.024	0.028	0.036	0.040

REFERENCE VALUES FOR ROUGHING

WZF 125487	Material	Strength	Vc ¹ m/min.	d					
				6	8	10	12	16	20
				fz ² (mm/z)					
	1.2083	52 HRC	90	0.022	0.030	0.039	0.047	0.055	0.066
	1.2162	52 HRC	110	0.022	0.030	0.039	0.047	0.055	0.066
	1.2343	52 HRC	110	0.022	0.030	0.039	0.047	0.055	0.066
	1.2379	60 HRC	-	-	-	-	-	-	-
	1.2714HH	43 HRC	90	0.022	0.030	0.039	0.047	0.055	0.066
	1.2767	52 HRC	110	0.022	0.030	0.039	0.047	0.055	0.066
	1.2842	60 HRC	-	-	-	-	-	-	-
	Steel	1400 N/mm ²	90	0.022	0.030	0.039	0.047	0.055	0.066

REFERENCE VALUES FOR FINISH MILLING

WZF 125487	Material	Strength	Vc ¹ m/min.	d					
				6	8	10	12	16	20
				fz ² (mm/z)					
	1.2083	52 HRC	100	0.018	0.024	0.033	0.039	0.048	0.057
	1.2162	52 HRC	140	0.018	0.024	0.033	0.039	0.048	0.057
	1.2343	52 HRC	140	0.018	0.024	0.033	0.039	0.048	0.057
	1.2379	60 HRC	100	0.015	0.025	0.030	0.035	0.045	0.060
	1.2714HH	43 HRC	130	0.018	0.024	0.033	0.039	0.048	0.057
	1.2767	52 HRC	140	0.018	0.024	0.033	0.039	0.048	0.057
	1.2842	60 HRC	110	0.015	0.025	0.030	0.035	0.045	0.060
	Steel	1400 N/mm ²	130	0.018	0.024	0.033	0.039	0.048	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.