



PRODUCT DESCRIPTION

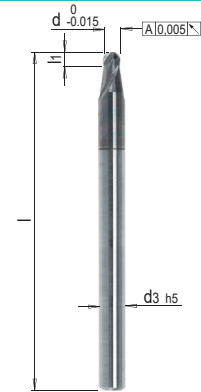
- » High-performance milling cutter with centre cut for 3D machining
- » Ultimate precision in the μ range

MATERIAL

» AlCrN coated

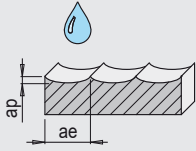


Z	l	l1	d3	d	No.	EUR
2	38	1	3	0.5	WZF 28246/0,5	< >
2	38	1.2	3	0.6	WZF 28246/0,6	< >
2	38	1.4	3	0.7	WZF 28246/0,7	< >
2	38	1.6	3	0.8	WZF 28246/0,8	< >
2	38	1.8	3	0.9	WZF 28246/0,9	< >
2	38	2	3	1	WZF 28246/1	< >
2	38	3	3	1.5	WZF 28246/1,5	< >
2	38	4	3	2	WZF 28246/2	< >
2	38	5	3	2.5	WZF 28246/2,5	< >
2	38	6	3	3	WZF 28246/3	< >



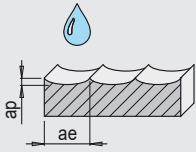
REFERENCE VALUES FOR ROUGHING

WZF 28246	Material	Strength	Vc ¹ m/min.	d									
				0.5	0.6	0.7	0.8	0.9	1	1.5	2	2.5	3
				fz ² (mm/z)									
	1.1730	640 N/mm ²	70	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2083	780 N/mm ²	35	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2085	1080 N/mm ²	35	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2162	660 N/mm ²	35	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2311	1080 N/mm ²	35	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2312	1080 N/mm ²	70	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2316	1010 N/mm ²	35	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2343	780 N/mm ²	35	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2379	780 N/mm ²	35	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2714 HH	1350 N/mm ²	70	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2767	830 N/mm ²	35	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2842	775 N/mm ²	70	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	Steel	1400 N/mm ²	35	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
ap (mm)				0.125	0.150	0.175	0.200	0.225	0.250	0.375	0.500	0.625	0.750
ae (mm)				0.050	0.060	0.070	0.080	0.090	0.100	0.150	0.200	0.250	0.300



REFERENCE VALUES FOR FINISH MILLING

WZF 28246	Material	Strength	Vc ¹ m/min.	d									
				0.5	0.6	0.7	0.8	0.9	1	1.5	2	2.5	3
				fz ² (mm/z)									
	1.1730	640 N/mm ²	90	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2083	780 N/mm ²	60	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2085	1080 N/mm ²	60	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2162	660 N/mm ²	60	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2311	1080 N/mm ²	60	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2312	1080 N/mm ²	90	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2316	1010 N/mm ²	60	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2343	780 N/mm ²	60	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2379	780 N/mm ²	60	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2714 HH	1350 N/mm ²	90	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2767	830 N/mm ²	60	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2842	775 N/mm ²	90	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	Steel	1400 N/mm ²	60	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
ap (mm)				0.025	0.03	0.035	0.040	0.045	0.050	0.075	0.10	0.125	0.15
ae (mm)				0.015	0.018	0.021	0.024	0.027	0.030	0.045	0.06	0.075	0.09



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.