

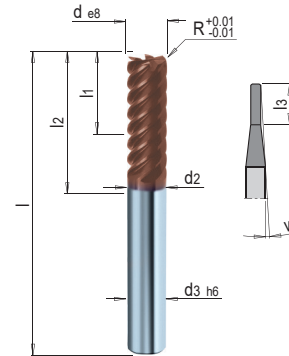


PRODUCT DESCRIPTION

- » High-performance milling cutter with centre cut for fine finishing
- » Relieved behind the cutting edge

MATERIAL

- » Carbide, TiAlSiN multi-layer coated



Z	d2	d3	l	l1	l2	l3	w	d	R	No.	EUR
6	2.8	6	57	8	11	12	4.8	3	0.3	WZF 135461/ 3 /0,3	< >
6	3.8	6	57	11	16	16	3.2	4	0.4	WZF 135461/ 4 /0,4	< >
6	4.7	6	57	13	18	18	1.6	5	0.5	WZF 135461/ 5 /0,5	< >
6	5.7	6	57	13	20	-	-	6	0.5	WZF 135461/ 6 /0,5	< >
6	5.7	6	57	13	20	-	-	6	1	WZF 135461/ 6 /1,0	< >
6	7.7	8	63	19	26	-	-	8	0.5	WZF 135461/ 8 /0,5	< >
6	7.7	8	63	19	26	-	-	8	1	WZF 135461/ 8 /1,0	< >
6	9.5	10	72	22	30	-	-	10	0.5	WZF 135461/10 /0,5	< >
6	9.5	10	72	22	30	-	-	10	1	WZF 135461/10 /1,0	< >
6	11.5	12	83	26	36	-	-	12	0.5	WZF 135461/12 /0,5	< >
6	11.5	12	83	26	36	-	-	12	1	WZF 135461/12 /1,0	< >
6	15.5	16	92	32	42	-	-	16	1	WZF 135461/16 /1,0	< >
6	15.5	16	92	32	42	-	-	16	2	WZF 135461/16 /2,0	< >

REFERENCE VALUES FOR FINISH MILLING

WZF 13546 WZF 135461	Material	Strength	Vc ¹ m/min.	d										
				3	4	5	6	8	10	12	14	16	18	20
				fz ² (mm/z)										
<p>ae = 0.05 x d ap = 1.5 x d</p>	1.2083	52 HRC	90	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057
	1.2162	52 HRC	120	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057
	1.2343	52 HRC	120	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057
	1.2379	60 HRC	90	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057
	1.2714HH	43 HRC	120	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057
	1.2767	52 HRC	120	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057
	1.2842	60 HRC	90	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057
	Steel	1400 N/mm ²	120	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057

REFERENCE VALUES FOR FINISH MILLING

WZF 13546 WZF 135461	Material	Strength	Vc ¹ m/min.	d										
				3	4	5	6	8	10	12	14	16	18	20
				fz ² (mm/z)										
<p>ae = 0.1 x d ap = 1.5 x d</p>	1.2083	52 HRC	100	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057
	1.2162	52 HRC	140	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057
	1.2343	52 HRC	140	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057
	1.2379	60 HRC	100	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057
	1.2714HH	43 HRC	140	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057
	1.2767	52 HRC	140	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057
	1.2842	60 HRC	100	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057
	Steel	1400 N/mm ²	140	0.007	0.010	0.014	0.019	0.024	0.029	0.034	0.039	0.044	0.050	0.057

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.