



PRODUCT DESCRIPTION

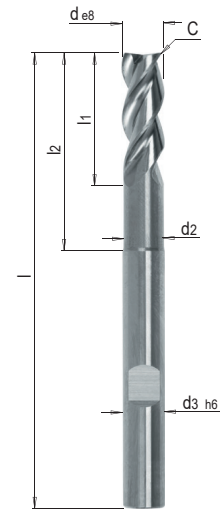
- » High-performance milling cutter for aluminium materials
- » With non-uniform pitch and centre cut

MATERIAL

- » Carbide, polished



Z	d2	d3	l	C	l1	l2	d	No.	EUR
3	5.5	6	65	0.06	13	28	6	WZF 128581/ 6	< >
3	7.5	8	75	0.08	19	38	8	WZF 128581/ 8	< >
3	9.5	10	80	0.1	22	38	10	WZF 128581/10	< >
3	11.5	12	93	0.12	26	46	12	WZF 128581/12	< >
3	15	16	108	0.16	32	58	16	WZF 128581/16	< >



REFERENCE VALUES FOR SLOTTING

WZF 128581	Material	Strength	Vc ¹ m/min.	d				
				6	8	10	12	16
				fz ² (mm/z)				
	3.3547 / EN AW-5083	270N/mm ²	350	0.035	0.045	0.060	0.070	0.090
	3.4365 / EN AW-7075	520N/mm ²	350	0.035	0.045	0.060	0.070	0.090
	copper	280N/mm ²	250	0.030	0.040	0.055	0.065	0.080
	Non-ferrous metal	< 800N/mm ²	250	0.030	0.040	0.055	0.065	0.080

REFERENCE VALUES FOR ROUGHING

WZF 128581	Material	Strength	Vc ¹ m/min.	d				
				6	8	10	12	16
				fz ² (mm/z)				
	3.3547 / EN AW-5083	270N/mm ²	500	0.040	0.050	0.065	0.080	0.095
	3.4365 / EN AW-7075	520N/mm ²	500	0.040	0.050	0.065	0.080	0.095
	copper	280N/mm ²	300	0.030	0.040	0.055	0.065	0.080
	Non-ferrous metal	< 800N/mm ²	300	0.030	0.040	0.055	0.065	0.080

REFERENCE VALUES FOR FINISH MILLING

WZF 128581	Material	Strength	Vc ¹ m/min.	d				
				6	8	10	12	16
				fz ² (mm/z)				
	3.3547 / EN AW-5083	270N/mm ²	600	0.048	0.060	0.078	0.096	0.114
	3.4365 / EN AW-7075	520N/mm ²	600	0.048	0.060	0.078	0.096	0.114
	copper	280N/mm ²	400	0.036	0.048	0.066	0.078	0.096
	Non-ferrous metal	< 800N/mm ²	400	0.036	0.048	0.066	0.078	0.096

1) Vc: cutting speed (m/min.)

2) fz: feed per cut (mm per tooth)