



### PRODUCT DESCRIPTION

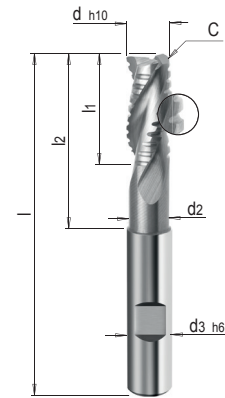
- » High-performance milling cutter for aluminium materials
- » With non-uniform pitch and centre cut
- » Relieved behind the cutting edge

### MATERIAL

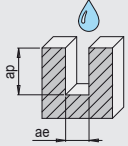
- » Carbide, polished



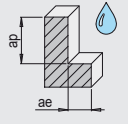
| Z | d2   | d3 | l   | l1 | l2 | C   | d  | No.          | EUR |
|---|------|----|-----|----|----|-----|----|--------------|-----|
| 3 | 5.7  | 6  | 65  | 13 | 28 | 0.3 | 6  | WZF 11858/ 6 | < > |
| 3 | 7.7  | 8  | 75  | 19 | 38 | 0.3 | 8  | WZF 11858/ 8 | < > |
| 3 | 9.5  | 10 | 80  | 22 | 38 | 0.3 | 10 | WZF 11858/10 | < > |
| 3 | 11.5 | 12 | 93  | 26 | 46 | 0.5 | 12 | WZF 11858/12 | < > |
| 3 | 15.5 | 16 | 108 | 32 | 58 | 0.5 | 16 | WZF 11858/16 | < > |
| 3 | 19.5 | 20 | 126 | 38 | 74 | 0.5 | 20 | WZF 11858/20 | < > |



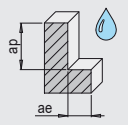
## REFERENCE VALUES FOR SLOTTING

| WZF 11848<br>WZF 11858   | Material            | Strength               | Vc <sup>1</sup><br>m/min. | d                      |       |       |       |       |       |
|--|---------------------|------------------------|---------------------------|------------------------|-------|-------|-------|-------|-------|
|  |                     |                        |                           | 6                      | 8     | 10    | 12    | 16    | 20    |
|  |                     |                        |                           | fz <sup>2</sup> (mm/z) |       |       |       |       |       |
|  <p>ae = 1 x d<br/>ap = 1 x d</p> | 3.3547 / EN AW-5083 | 270 N/mm <sup>2</sup>  | 400                       | 0.025                  | 0.030 | 0.040 | 0.050 | 0.065 | 0.070 |
|  | 3.4365 / EN AW-7075 | 520 N/mm <sup>2</sup>  | 400                       | 0.025                  | 0.030 | 0.040 | 0.050 | 0.065 | 0.070 |
|  | Copper              | 280 N/mm <sup>2</sup>  | 250                       | 0.018                  | 0.020 | 0.030 | 0.040 | 0.045 | 0.050 |
|  | Non-ferrous metal   | <800 N/mm <sup>2</sup> | 250                       | 0.018                  | 0.020 | 0.030 | 0.040 | 0.045 | 0.050 |

## REFERENCE VALUES FOR ROUGHING


| WZF 11848<br>WZF 11858   | Material            | Strength               | Vc <sup>1</sup><br>m/min. | d                      |       |       |       |       |       |
|--|---------------------|------------------------|---------------------------|------------------------|-------|-------|-------|-------|-------|
|  |                     |                        |                           | 6                      | 8     | 10    | 12    | 16    | 20    |
|  |                     |                        |                           | fz <sup>2</sup> (mm/z) |       |       |       |       |       |
|  <p>ae = 0.5 x d<br/>ap = 1 x d</p> | 3.3547 / EN AW-5083 | 270 N/mm <sup>2</sup>  | 500                       | 0.030                  | 0.040 | 0.055 | 0.065 | 0.080 | 0.095 |
|  | 3.4365 / EN AW-7075 | 520 N/mm <sup>2</sup>  | 500                       | 0.030                  | 0.040 | 0.055 | 0.065 | 0.080 | 0.095 |
|  | Copper              | 280 N/mm <sup>2</sup>  | 300                       | 0.025                  | 0.030 | 0.040 | 0.045 | 0.060 | 0.070 |
|  | Non-ferrous metal   | <800 N/mm <sup>2</sup> | 300                       | 0.025                  | 0.030 | 0.040 | 0.045 | 0.060 | 0.070 |

## REFERENCE VALUES FOR ROUGHING

| WZF 11848<br>WZF 11858  | Material            | Strength               | Vc <sup>1</sup><br>m/min. | d                      |       |       |       |       |       |
|---|---------------------|------------------------|---------------------------|------------------------|-------|-------|-------|-------|-------|
|   |                     |                        |                           | 6                      | 8     | 10    | 12    | 16    | 20    |
|   |                     |                        |                           | fz <sup>2</sup> (mm/z) |       |       |       |       |       |
|  <p>ae = 0.25 x d<br/>ap = 1.5 x d</p> | 3.3547 / EN AW-5083 | 270 N/mm <sup>2</sup>  | 600                       | 0.040                  | 0.050 | 0.070 | 0.080 | 0.100 | 0.120 |
|   | 3.4365 / EN AW-7075 | 520 N/mm <sup>2</sup>  | 600                       | 0.040                  | 0.050 | 0.070 | 0.080 | 0.100 | 0.120 |
|   | Copper              | 280 N/mm <sup>2</sup>  | 300                       | 0.030                  | 0.040 | 0.050 | 0.060 | 0.080 | 0.090 |
|   | Non-ferrous metal   | <800 N/mm <sup>2</sup> | 300                       | 0.030                  | 0.040 | 0.050 | 0.060 | 0.080 | 0.090 |

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.