



PRODUCT DESCRIPTION

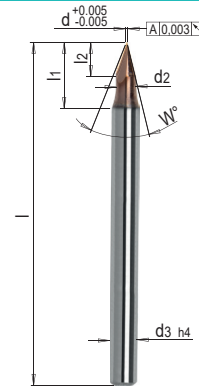
» For the machining of high-strength materials

MATERIAL

» Carbide, TiAlN coated



Z	d2	d3	l	l1	l2	w	d	No.	EUR
1	2.25	3	39	5	2.9	40	0.08	WZF 15136/40/0,08	< >
1	2.25	3	39	5	2.9	40	0.1	WZF 15136/40/0,1	< >
1	2.25	3	39	5	2.6	40	0.2	WZF 15136/40/0,2	< >
1	2.25	3	39	5	1.9	60	0.05	WZF 15136/60/0,05	< >
1	2.25	3	39	5	1.8	60	0.08	WZF 15136/60/0,08	< >
1	2.25	3	39	5	1.8	60	0.1	WZF 15136/60/0,1	< >



REFERENCE VALUES FOR ENGRAVING

WZF 15136	Material	Strength	Vc ¹ m/min.	d	
				0.2	fz ² (mm/z)
<p>ap ≈ 0.04 x d</p>	1.1730	640 N/mm ²	20	0.004	
	1.2083	780 N/mm ²	20	0.004	
	1.2085	1080 N/mm ²	10	0.002	
	1.2162	660 N/mm ²	20	0.004	
	1.2311	1080 N/mm ²	10	0.002	
	1.2312	1080 N/mm ²	10	0.002	
	1.2316	1010 N/mm ²	10	0.002	
	1.2343	780 N/mm ²	20	0.004	
	1.2379	780 N/mm ²	20	0.004	
	1.2714HH	1350 N/mm ²	10	0.002	
	1.2767	830 N/mm ²	20	0.004	
	1.2842	775 N/mm ²	20	0.004	
	Steel	1400 N/mm ²	10	0.002	

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.