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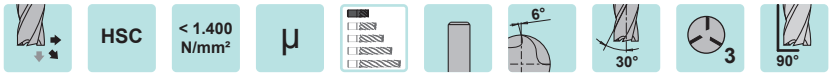
CARBIDE ROUGH / FINISH MILLING CUTTERS WZF 222483



PRODUCT DESCRIPTION

» Ultimate precision in the µ range

MATERIAL

» AlCrN coated

P	M	K	N	S	H
●	○	●	○	○	

Z	l	l1	d3	d	No.	EUR
3	38	1	3	**0.5**	WZF 222483/0,5	< >
3	38	1.2	3	**0.6**	WZF 222483/0,6	< >
3	38	1.4	3	**0.7**	WZF 222483/0,7	< >
3	38	1.6	3	**0.8**	WZF 222483/0,8	< >
3	38	1.8	3	**0.9**	WZF 222483/0,9	< >
3	38	2	3	**1**	WZF 222483/1	< >
3	38	3	3	**1.5**	WZF 222483/1,5	< >
3	38	4	3	**2**	WZF 222483/2	< >
3	38	5	3	**2.5**	WZF 222483/2,5	< >
3	38	6	3	**3**	WZF 222483/3	< >

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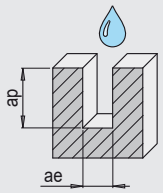
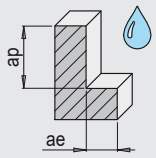
REFERENCE VALUES FOR SLOTTING

WZF 222483	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/mm²	55	0.005	0.0060	0.0070	0.0080	0.0080	0.010	0.015	0.020	0.025	0.030
	1.2083	780 N/mm²	35	0.002	0.0024	0.0028	0.0032	0.0032	0.004	0.006	0.008	0.010	0.012
	1.2085	1080 N/mm²	35	0.002	0.0024	0.0028	0.0032	0.0032	0.004	0.006	0.008	0.010	0.012
	1.2162	660 N/mm²	35	0.002	0.0024	0.0028	0.0032	0.0032	0.004	0.006	0.008	0.010	0.012
	1.2311	1080 N/mm²	35	0.002	0.0024	0.0028	0.0032	0.0032	0.004	0.006	0.008	0.010	0.012
	1.2312	1080 N/mm²	55	0.005	0.0060	0.0070	0.0080	0.0080	0.010	0.015	0.020	0.025	0.030
	1.2316	1010 N/mm²	35	0.002	0.0024	0.0028	0.0032	0.0032	0.004	0.006	0.008	0.010	0.012
	1.2343	780 N/mm²	35	0.002	0.0024	0.0028	0.0032	0.0032	0.004	0.006	0.008	0.010	0.012
	1.2379	780 N/mm²	35	0.002	0.0024	0.0028	0.0032	0.0032	0.004	0.006	0.008	0.010	0.012
	1.2714 HH	1350 N/mm²	55	0.005	0.0060	0.0070	0.0080	0.0080	0.010	0.015	0.020	0.025	0.030
	1.2767	830 N/mm²	35	0.005	0.0060	0.0070	0.0080	0.0080	0.010	0.015	0.020	0.025	0.030
	1.2842	775 N/mm²	55	0.005	0.0060	0.0070	0.0080	0.0080	0.010	0.015	0.020	0.025	0.030
	Steel	1400 N/mm²	35	0.002	0.0024	0.0028	0.0032	0.0032	0.004	0.006	0.008	0.010	0.012

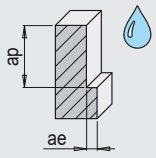
ae = 1 x d
ap = 0.3 x d

REFERENCE VALUES FOR ROUGHING

WZF 222483	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/mm²	70	0.036	0.0072	0.0084	0.0096	0.0108	0.012	0.018	0.024	0.03	0.036
	1.2083	780 N/mm²	35	0.036	0.0072	0.0084	0.0096	0.0108	0.012	0.018	0.024	0.03	0.036
	1.2085	1080 N/mm²	35	0.036	0.0072	0.0084	0.0096	0.0108	0.012	0.018	0.024	0.03	0.036
	1.2162	660 N/mm²	35	0.036	0.0072	0.0084	0.0096	0.0108	0.012	0.018	0.024	0.03	0.036
	1.2311	1080 N/mm²	35	0.036	0.0072	0.0084	0.0096	0.0108	0.012	0.018	0.024	0.03	0.036
	1.2312	1080 N/mm²	70	0.036	0.0072	0.0084	0.0096	0.0108	0.012	0.018	0.024	0.03	0.036
	1.2316	1010 N/mm²	35	0.036	0.0072	0.0084	0.0096	0.0108	0.012	0.018	0.024	0.03	0.036
	1.2343	780 N/mm²	35	0.036	0.0072	0.0084	0.0096	0.0108	0.012	0.018	0.024	0.03	0.036
	1.2379	780 N/mm²	35	0.036	0.0072	0.0084	0.0096	0.0108	0.012	0.018	0.024	0.03	0.036
	1.2714 HH	1350 N/mm²	70	0.036	0.0072	0.0084	0.0096	0.0108	0.012	0.018	0.024	0.03	0.036
	1.2767	830 N/mm²	35	0.036	0.0072	0.0084	0.0096	0.0108	0.012	0.018	0.024	0.03	0.036
	1.2842	775 N/mm²	70	0.036	0.0072	0.0084	0.0096	0.0108	0.012	0.018	0.024	0.03	0.036
	Steel	1400 N/mm²	35	0.036	0.0072	0.0084	0.0096	0.0108	0.012	0.018	0.024	0.03	0.036

ae = 0.15 x d
ap = 0.5 x d

REFERENCE VALUES FOR FINISH MILLING

WZF 222483	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/mm²	90	0.0025	0.003	0.0035	0.004	0.0045	0.005	0.0075	0.01	0.0125	0.015
	1.2083	780 N/mm²	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/mm²	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/mm²	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/mm²	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/mm²	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/mm²	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/mm²	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/mm²	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/mm²	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/mm²	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/mm²	90	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	Steel	1400 N/mm²	60	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018

ae = 0.02 x d
ap = 1.5 x d

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.

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