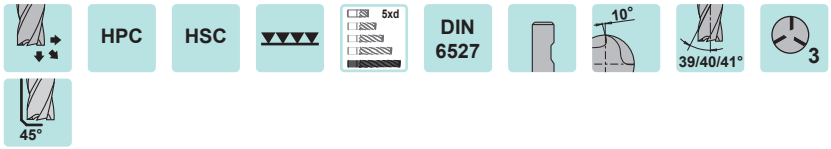
meusburger

CARBIDE ROUGH / FINISH MILLING CUTTER FOR ALUMINIUM, EXTRA LONG, 5XD — WZF 12878



PRODUCT DESCRIPTION

» High-performance milling cutter for aluminium materials
» With non-uniform pitch and centre cut
» Cutting edge length 5xd

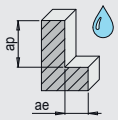
MATERIAL

» Carbide, polished

P M K N S H

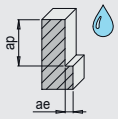
Z	d3	l	l1	C	d	No.	EUR
3	6	75	30	0.06	**6**	WZF 12878/ 6	< >
3	8	86	40	0.08	**8**	WZF 12878/ 8	< >
3	10	100	50	0.1	**10**	WZF 12878/10	< >
3	12	120	60	0.12	**12**	WZF 12878/12	< >
3	16	150	80	0.16	**16**	WZF 12878/16	< >
3	20	175	100	0.2	**20**	WZF 12878/20	< >

REFERENCE VALUES FOR ROUGHING

WZF 12868 WZF 12878	Material	Strength	Vc[1] m/min.	d 6	d 8	d 10	d 12	d 16	d 20
				fz[2] (mm/z)					
	3.3547 / EN AW-5083	270 N/mm²	500	0.040	0.050	0.065	0.080	0.095	0.110
	3.4365 / EN AW-7075	520 N/mm²	500	0.040	0.050	0.065	0.080	0.095	0.110
	Copper	280 N/mm²	300	0.030	0.040	0.055	0.065	0.080	0.095
	Non-ferrous metal	<800 N/mm²	300	0.030	0.040	0.055	0.065	0.080	0.095

ae = 0.25 x d
ap = 3 x d

REFERENCE VALUES FOR FINISH MILLING

WZF 12868 WZF 12878	Material	Strength	Vc[1] m/min.	d 6	d 8	d 10	d 12	d 16	d 20
				fz[2] (mm/z)					
	3.3547 / EN AW-5083	270 N/mm²	600	0.050	0.070	0.090	0.100	0.120	0.140
	3.4365 / EN AW-7075	520 N/mm²	600	0.050	0.070	0.090	0.100	0.120	0.140
	Copper	280 N/mm²	400	0.040	0.050	0.070	0.090	0.100	0.120
	Non-ferrous metal	<800 N/mm²	400	0.040	0.050	0.070	0.090	0.100	0.120

ae = 0.1 x d
ap = 3 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.

Meusburger Georg GmbH & Co KG | Kesselstr. 42 | 6960 Wolfurt | Austria
T +43 5574 6706-0 | sales@meusburger.com | www.meusburger.com