

PRODUCT DESCRIPTION

- » Maximum feed rates
- » 4 cutting edges
- » Optimised chip space for excellent chip removal
- » Maximum metal removal rate

Indexable high-feed milling cutter with steel shank

WZT 5132	E	d3	d4	a	l1	PG	d	Z	l	No.	EUR
	E 2 (T 8)	16	-	0.8	40	06	16	2	89	WZT 5132/06/16/ 2/ 89/B	<>
	E 2 (T 8)	16	-	0.8	40	06	16	2	200	WZT 5132/06/16/ 2/200/A	<>
	E 2 (T 8)	20	-	0.8	50	06	20	3	101	WZT 5132/06/20/ 3/101/B	<>
	E 2 (T 8)	20	-	0.8	50	06	20	3	225	WZT 5132/06/20/ 3/225/A	<>
	E 2 (T 8)	25	-	0.8	50	06	25	4	107	WZT 5132/06/25/ 4/107/A	<>
	E 2 (T 8)	25	-	0.8	50	06	25	4	225	WZT 5132/06/25/ 4/225/A	<>
	E 2 (T 8)	25	-	0.8	60	06	32	5	117	WZT 5132/06/32/ 5/117/B	<>
	E 2 (T 8)	25	-	0.8	60	06	32	5	225	WZT 5132/06/32/ 5/225/A	<>
	E 3 (T15)	25	-	1	50	09	25	2	225	WZT 5132/09/25/ 2/225/A	<>
	E 3 (T15)	25	-	1	50	09	25	3	225	WZT 5132/09/25/ 3/225/A	<>
	E 4 (T15)	32	-	1	63	09	32	3	250	WZT 5132/09/32/ 3/250/A	<>
	E 5 (T20)	32	-	2	63	12	32	2	250	WZT 5132/12/32/ 2/250/A	<>
E 5 (T20)	32	-	2	63	12	35	3	250	WZT 5132/12/35/ 3/250/A	<>	

Indexable high-feed milling cutter with screw-in thread

WZT 5134	E	d2	d4	a	l1	PG	d	Z	l	No.	EUR
	E 2 (T 8)	M 8	8.5	0.8	27	06	16	2	-	WZT 5134/06/16/ 2	<>
	E 2 (T 8)	M10	10.5	0.8	33	06	20	3	-	WZT 5134/06/20/ 3	<>
	E 2 (T 8)	M12	12.5	0.8	35	06	25	4	-	WZT 5134/06/25/ 4	<>
	E 2 (T 8)	M16	17	0.8	35	06	32	5	-	WZT 5134/06/32/ 5	<>
	E 3 (T15)	M12	12.5	1	35	09	25	2	-	WZT 5134/09/25/ 2	<>
	E 3 (T15)	M12	12.5	1	35	09	25	3	-	WZT 5134/09/25/ 3	<>
	E 4 (T15)	M16	17	1	35	09	32	3	-	WZT 5134/09/32/ 3	<>
	E 5 (T20)	M16	17	2	35	12	32	2	-	WZT 5134/12/32/ 2	<>
	E 5 (T20)	M16	17	2	35	12	35	3	-	WZT 5134/12/35/ 3	<>

Indexable high-feed milling cutter, shell-type

WZT 5136	E	d1	d2	a	l1	PG	d	Z	l	No.	EUR
	E 4 (T15), E25	16	38	1	40	09	32	3	-	WZT 5136/09/32/ 3	<>
	E 4 (T15), E25	16	38	1	40	09	35	4	-	WZT 5136/09/35/ 4	<>
	E 4 (T15), E25	16	38	1	40	09	40	4	-	WZT 5136/09/40/ 4	<>
	E 4 (T15), E25	16	38	1	40	09	42	5	-	WZT 5136/09/42/ 5	<>
	E 4 (T15)	22	43	1	40	09	50	5	-	WZT 5136/09/50/ 5	<>
	E 4 (T15)	22	43	1	40	09	52	6	-	WZT 5136/09/52/ 6	<>
	E 4 (T15)	22	48	1	40	09	63	6	-	WZT 5136/09/63/ 6	<>
	E 5 (T20), E26	16	38	2	40	12	40	3	-	WZT 5136/12/40/ 3	<>
	E 5 (T20), E26	16	38	2	40	12	42	4	-	WZT 5136/12/42/ 4	<>
	E 5 (T20)	22	43	2	40	12	50	4	-	WZT 5136/12/50/ 4	<>
	E 5 (T20)	22	43	2	40	12	52	5	-	WZT 5136/12/52/ 5	<>
	E 5 (T20)	22	48	2	40	12	63	5	-	WZT 5136/12/63/ 5	<>

1) E: matching screws WZE 100 / WZE 200


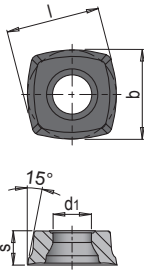
2) PG: plate size

Supplied without indexable insert, with screw for indexable inserts

PRODUCT DESCRIPTION

- » Specifically for the materials used in die and mould making
- » Maximum efficiency
- » Soft cutting and reduced vibration
- » Feed rates up to 3 mm




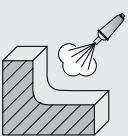
WZP 513	ISO	b	l	s	d1	System	PG ¹⁾	PS ²⁾	 Pcs. / PU	No.	EUR
	XPLX 060305SR-M50	6.35	6	2.75	2.8	WZP 513	06	M54	10	WZP 513/06/M54	<>
	XPLX 060305SR-M50	6.35	6	2.75	2.8	WZP 513	06	M45	10	WZP 513/06/M45	<>
	XDLX 09T308SR-M50	9.6	9	3.97	4.4	WZP 513	09	M54	10	WZP 513/09/M54	<>
	XDLX 09T308SR-M50	9.6	9	3.97	4.4	WZP 513	09	M45	10	WZP 513/09/M45	<>
	XOLX 120410SR-M50	12.7	12	4.76	5.5	WZP 513	12	M54	10	WZP 513/12/M54	<>
	XOLX 120410SR-M50	12.7	12	4.76	5.5	WZP 513	12	M45	10	WZP 513/12/M45	<>
	XOLX 120410SR-M50	12.7	12	4.76	5.5	WZP 513	12	R45	10	WZP 513/12/R45	<>

1) PG: plate size

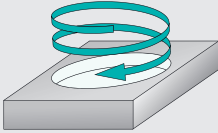
2) PS: plate type

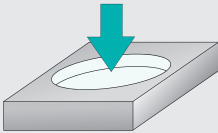
 Overview of plate types on page II

REFERENCE VALUES FOR ROUGHING

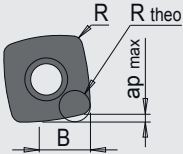
WZP 513 	Material	Strength	PS	Vc m/min.	WZP 513 06		WZP 513 09		WZP 513 12	
					fz mm	ap mm	fz mm	ap mm	fz mm	ap mm
	1.1730	640 N/mm ²	M 45	220	0.8 - 1.4	0.25 - 0.8	1.3 - 2	0.25 - 1	1.1 - 2.6	0.25 - 2
	1.2083	780 N/mm ²	M 54	180	0.5 - 1.2	0.25 - 0.8	0.8 - 1.4	0.25 - 1	0.6 - 1.6	0.25 - 2
	1.2085	1080 N/mm ²	M 54	180	0.5 - 1.2	0.25 - 0.8	0.8 - 1.4	0.25 - 1	0.6 - 1.6	0.25 - 2
	1.2162	660 N/mm ²	M 45	200	0.8 - 1.4	0.25 - 0.8	1.3 - 2	0.25 - 1	1.1 - 2.6	0.25 - 2
	1.2311	1080 N/mm ²	M 45	200	0.8 - 1.4	0.25 - 0.8	1.3 - 2	0.25 - 1	1.1 - 2.6	0.25 - 2
	1.2312	1080 N/mm ²	M 45	200	0.8 - 1.4	0.25 - 0.8	1.3 - 2	0.25 - 1	1.1 - 2.6	0.25 - 2
	1.2316	1010 N/mm ²	M 54	160	0.5 - 1.2	0.25 - 0.8	0.8 - 1.4	0.25 - 1	0.6 - 1.6	0.25 - 2
	1.2343	780 N/mm ²	M 45	160	0.1 - 1.5	0.25 - 0.8	0.25 - 1	0.25 - 1	0.1 - 3.0	0.25 - 2
	1.2379	780 N/mm ²	M 54	180	0.5 - 1.2	0.25 - 0.8	0.8 - 1.4	0.25 - 1	0.6 - 1.6	0.25 - 2
	1.2714HH	1350 N/mm ²	M 45	150	0.1 - 1.5	0.25 - 0.8	0.25 - 1	0.25 - 1	0.1 - 3.0	0.25 - 2
	1.2767	830 N/mm ²	M 45	180	0.8 - 1.4	0.25 - 0.8	1.3 - 2	0.25 - 1	1.1 - 2.6	0.25 - 2
	1.2842	775 N/mm ²	M 45	180	0.8 - 1.4	0.25 - 0.8	1.3 - 2	0.25 - 1	1.1 - 2.6	0.25 - 2
	Steel	1400 N/mm ²	M 45	150	0.1 - 1.5	0.25 - 0.8	0.25 - 1	0.25 - 1	0.1 - 3.0	0.25 - 2

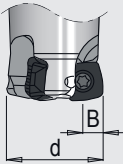
TECHNOLOGY DATA

Circular plunging	WZP 513 06				WZP 513 09				WZP 513 12			
	d1	Dmax ¹	Dmin ²	aR	d1	Dmax ¹	Dmin ²	aR	d1	Dmax ¹	Dmin ²	aR
	16	31	22	4.5°								
	20	39	30	2.3°								
	25	49	40	1.3°	25	48	35	3.1°				
	32	63	54	0.9°	32	62	49	1.7°	32	62	44	6.1°
					35	68	55	1.4°	35	68	50	3.7°
					40	78	65	1.0°	40	78	60	2.5°
					42	82	69	0.9°	42	82	64	2.3°
					50	98	85	0.8°	50	98	80	1.3°
					52	102	89	0.7°	52	102	84	1.3°
					63	124	111	0.7°	63	124	106	0.9°

Axial plunging	WZP 513 06		WZP 513 09		WZP 513 12	
	d1	t max	d1	t max	d1	t max
	16 - 32	0.5	25 - 63	0.75	32 - 63	1.15

Ramping	WZP 513 06		WZP 513 09		WZP 513 12	
	d1	aR	d1	aR	d1	aR
	16	5.9°				
	20	3.2°				
	25	2.0°	25	3.6°		
	32	1.3°	32	2.0°	32	7.2°
			35	1.6°	35	4.4°
			40	1.2°	40	2.9°
			42	1.1°	42	2.7°
			50	0.9°	50	1.5°
			52	0.8°	52	1.5°
			63	0.8°	63	1.1°

Engagement during plunge milling	WZP 513 06				WZP 513 09				WZP 513 12			
	R theo	B	R	ap max	R theo	B	R	ap max	R theo	B	R	ap max
	1.2	5.3	0.5	0.8	2	5.9	0.8	1	3	8.3	1.0	2

Cut width for flat surfaces	WZP 513 06				WZP 513 09				WZP 513 12			
	R theo	B	R	ap max	R theo	B	R	ap max	R theo	B	R	ap max
	1.2	5.3	0.5	0.8	2	5.9	0.8	1	3	8.3	1.0	2

1) Dmin: smallest hole diameter [mm]

2) Dmax: largest diameter for flat bottom surfaces [mm]