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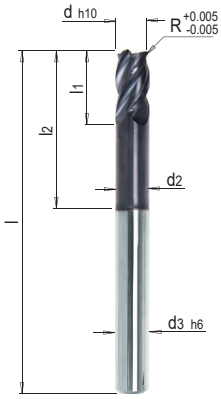
CARBIDE ROUGH / FINISH MILLING CUTTER WITH RADIUS, EXTRA LONG — WZF 122681P



PRODUCT DESCRIPTION

» High-performance milling cutter with non-uniform pitch and centre cut
» Relieved behind the cutting edge

MATERIAL

» Carbide, TiAlN multi-layer coated

P	M	K	N	S	H
●	○	●	○	○	

Z	d2	d3	l	l1	l2	d	R	No.	EUR
4	5.9	6	79	10	30	**6**	**0.5**	WZF 122681P/ 6/0,5	< >
4	5.9	6	79	10	30	**6**	**1**	WZF 122681P/ 6/1	< >
4	7.8	8	79	12	36	**8**	**0.5**	WZF 122681P/ 8/0,5	< >
4	7.8	8	79	12	36	**8**	**1**	WZF 122681P/ 8/1	< >
4	9.8	10	99	15	45	**10**	**0.5**	WZF 122681P/10/0,5	< >
4	9.8	10	99	15	45	**10**	**1**	WZF 122681P/10/1	< >
4	11.8	12	99	18	48	**12**	**0.5**	WZF 122681P/12/0,5	< >
4	11.8	12	99	18	48	**12**	**1**	WZF 122681P/12/1	< >
4	15.8	16	125	24	64	**16**	**1**	WZF 122681P/16/1	< >
4	15.8	16	125	24	64	**16**	**2**	WZF 122681P/16/2	< >

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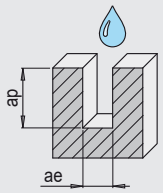
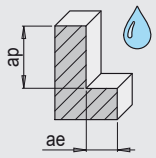
REFERENCE VALUES FOR SLOTTING

WZF 122681P	Material	Strength	Vc[1] m/min.	d				
				6	8	10	12	16
				fz[2] (mm/z)				
	1.1730	640 N/mm²	150	0.028	0.037	0.050	0.062	0.075
	1.2083	780 N/mm²	110	0.023	0.03	0.040	0.050	0.060
	1.2085	1080 N/mm²	110	0.023	0.03	0.040	0.050	0.060
	1.2162	660 N/mm²	130	0.028	0.037	0.050	0.062	0.075
	1.2311	1080 N/mm²	130	0.025	0.033	0.044	0.055	0.066
	1.2312	1080 N/mm²	130	0.025	0.033	0.044	0.055	0.066
	1.2316	1010 N/mm²	110	0.023	0.03	0.040	0.050	0.060
	1.2343	780 N/mm²	130	0.028	0.037	0.050	0.062	0.075
	1.2379	780 N/mm²	110	0.023	0.03	0.040	0.050	0.060
	1.2714HH	1350 N/mm²	90	0.023	0.03	0.040	0.050	0.060
	1.2767	830 N/mm²	130	0.025	0.033	0.044	0.055	0.066
	1.2842	775 N/mm²	130	0.025	0.033	0.044	0.055	0.066
	Steel	1400 N/mm²	60	0.023	0.03	0.040	0.050	0.060

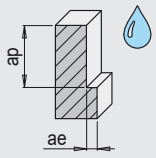
ae = 1 x d
ap = 0.8 x d

REFERENCE VALUES FOR ROUGHING

WZF 122681P	Material	Strength	Vc[1] m/min.	d				
				6	8	10	12	16
				fz[2] (mm/z)				
	1.1730	640 N/mm²	190	0.034	0.044	0.061	0.077	0.094
	1.2083	780 N/mm²	120	0.023	0.03	0.041	0.053	0.064
	1.2085	1080 N/mm²	120	0.023	0.03	0.041	0.053	0.064
	1.2162	660 N/mm²	190	0.031	0.04	0.055	0.070	0.085
	1.2311	1080 N/mm²	130	0.025	0.032	0.044	0.056	0.068
	1.2312	1080 N/mm²	140	0.023	0.03	0.041	0.053	0.064
	1.2316	1010 N/mm²	120	0.023	0.03	0.041	0.053	0.064
	1.2343	780 N/mm²	150	0.031	0.04	0.055	0.070	0.085
	1.2379	780 N/mm²	120	0.023	0.03	0.041	0.053	0.064
	1.2714HH	1350 N/mm²	100	0.023	0.03	0.041	0.053	0.064
	1.2767	830 N/mm²	140	0.029	0.038	0.052	0.067	0.081
	1.2842	775 N/mm²	140	0.031	0.04	0.055	0.070	0.085
	Steel	1400 N/mm²	100	0.017	0.022	0.030	0.039	0.047

ae = 0.5 x d
ap = 1 x d

REFERENCE VALUES FOR FINISH MILLING

WZF 122681P	Material	Strength	Vc[1] m/min.	d				
				6	8	10	12	16
				fz[2] (mm/z)				
	1.1730	640 N/mm²	260	0.033	0.044	0.061	0.072	0.088
	1.2083	780 N/mm²	150	0.023	0.030	0.041	0.049	0.060
	1.2085	1080 N/mm²	150	0.023	0.030	0.041	0.049	0.060
	1.2162	660 N/mm²	260	0.030	0.040	0.055	0.065	0.080
	1.2311	1080 N/mm²	190	0.024	0.032	0.044	0.052	0.064
	1.2312	1080 N/mm²	190	0.023	0.030	0.041	0.049	0.060
	1.2316	1010 N/mm²	150	0.023	0.030	0.041	0.049	0.060
	1.2343	780 N/mm²	210	0.030	0.040	0.055	0.065	0.080
	1.2379	780 N/mm²	150	0.023	0.030	0.041	0.049	0.060
	1.2714HH	1350 N/mm²	130	0.023	0.030	0.041	0.049	0.060
	1.2767	830 N/mm²	190	0.029	0.038	0.052	0.062	0.076
	1.2842	775 N/mm²	190	0.030	0.040	0.055	0.065	0.080
	Steel	1400 N/mm²	120	0.018	0.024	0.033	0.039	0.048

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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