

### PRODUCT DESCRIPTION

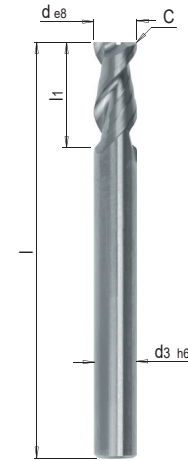
- » High-performance milling cutter for aluminium materials
- » With centre cut

### MATERIAL

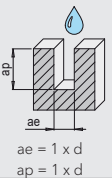
- » Carbide, polished



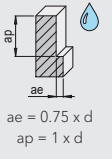
| Z | d3 | l  | C    | l1 | d  | No.          | EUR |
|---|----|----|------|----|----|--------------|-----|
| 2 | 6  | 57 | 0.03 | 7  | 3  | WZF 12846/ 3 | <>  |
| 2 | 6  | 57 | 0.03 | 8  | 4  | WZF 12846/ 4 | <>  |
| 2 | 6  | 57 | 0.03 | 10 | 5  | WZF 12846/ 5 | <>  |
| 2 | 6  | 57 | 0.03 | 10 | 6  | WZF 12846/ 6 | <>  |
| 2 | 8  | 63 | 0.05 | 16 | 8  | WZF 12846/ 8 | <>  |
| 2 | 10 | 72 | 0.05 | 19 | 10 | WZF 12846/10 | <>  |
| 2 | 12 | 83 | 0.1  | 22 | 12 | WZF 12846/12 | <>  |



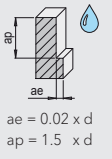
## REFERENCE VALUES FOR SLOTTING

| WZF 12846  | Material            | Strength               | Vc <sup>1</sup><br>m/min. | d                      |       |       |       |       |       |       |
|--|---------------------|------------------------|---------------------------|------------------------|-------|-------|-------|-------|-------|-------|
|  |                     |                        |                           | 3                      | 4     | 5     | 6     | 8     | 10    | 12    |
|  |                     |                        |                           | fz <sup>2</sup> (mm/z) |       |       |       |       |       |       |
|  <p>ae = 1 x d<br/>ap = 1 x d</p> | 3.3547 / EN AW-5083 | 270N/mm <sup>2</sup>   | 300                       | 0.019                  | 0.025 | 0.030 | 0.037 | 0.050 | 0.065 | 0.078 |
|  | 3.4365 / EN AW-7075 | 520N/mm <sup>2</sup>   | 300                       | 0.019                  | 0.025 | 0.030 | 0.037 | 0.050 | 0.065 | 0.078 |
|  | copper              | 280N/mm <sup>2</sup>   | 175                       | 0.010                  | 0.017 | 0.021 | 0.025 | 0.034 | 0.046 | 0.055 |
|  | Non-ferrous metal   | < 800N/mm <sup>2</sup> | 175                       | 0.010                  | 0.017 | 0.021 | 0.025 | 0.034 | 0.046 | 0.055 |

## REFERENCE VALUES FOR ROUGHING

| WZF 12846   | Material            | Strength               | Vc <sup>1</sup><br>m/min. | d                      |       |       |       |       |       |       |
|---|---------------------|------------------------|---------------------------|------------------------|-------|-------|-------|-------|-------|-------|
|   |                     |                        |                           | 3                      | 4     | 5     | 6     | 8     | 10    | 12    |
|   |                     |                        |                           | fz <sup>2</sup> (mm/z) |       |       |       |       |       |       |
|  <p>ae = 0.75 x d<br/>ap = 1 x d</p> | 3.3547 / EN AW-5083 | 270N/mm <sup>2</sup>   | 350                       | 0.021                  | 0.029 | 0.036 | 0.043 | 0.057 | 0.075 | 0.090 |
|   | 3.4365 / EN AW-7075 | 520N/mm <sup>2</sup>   | 350                       | 0.021                  | 0.029 | 0.036 | 0.043 | 0.057 | 0.075 | 0.090 |
|   | copper              | 280N/mm <sup>2</sup>   | 290                       | 0.014                  | 0.019 | 0.024 | 0.029 | 0.039 | 0.053 | 0.063 |
|   | Non-ferrous metal   | < 800N/mm <sup>2</sup> | 290                       | 0.014                  | 0.019 | 0.024 | 0.029 | 0.039 | 0.053 | 0.063 |

## REFERENCE VALUES FOR FINISH MILLING

| WZF 12846   | Material            | Strength               | Vc <sup>1</sup><br>m/min. | d                      |       |       |       |       |       |       |
|---|---------------------|------------------------|---------------------------|------------------------|-------|-------|-------|-------|-------|-------|
|   |                     |                        |                           | 3                      | 4     | 5     | 6     | 8     | 10    | 12    |
|   |                     |                        |                           | fz <sup>2</sup> (mm/z) |       |       |       |       |       |       |
|  <p>ae = 0.02 x d<br/>ap = 1.5 x d</p> | 3.3547 / EN AW-5083 | 270N/mm <sup>2</sup>   | 600                       | 0.020                  | 0.027 | 0.034 | 0.041 | 0.055 | 0.072 | 0.086 |
|   | 3.4365 / EN AW-7075 | 520N/mm <sup>2</sup>   | 600                       | 0.020                  | 0.027 | 0.034 | 0.041 | 0.055 | 0.072 | 0.086 |
|   | copper              | 280N/mm <sup>2</sup>   | 500                       | 0.014                  | 0.018 | 0.023 | 0.028 | 0.037 | 0.051 | 0.061 |
|   | Non-ferrous metal   | < 800N/mm <sup>2</sup> | 500                       | 0.014                  | 0.018 | 0.023 | 0.028 | 0.037 | 0.051 | 0.061 |

1) Vc: cutting speed (m/min.)

2) fz: feed per cut (mm per tooth)