

PRODUCT DESCRIPTION

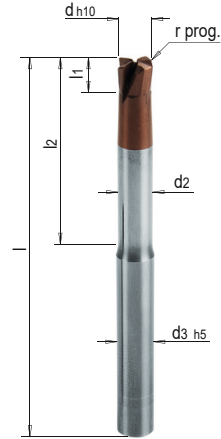
» High-performance high-feed milling cutter

MATERIAL

» Carbide, TiAlN coated



Z	d2	d3	l	l1	r prog.	d	l2	No.	EUR
4	2.6	6	57	3	0.4	3	10	WZF 11492/ 3/10	< >
4	2.6	6	57	3	0.4	3	20	WZF 11492/ 3/20	< >
4	3.6	6	57	3	0.6	4	15	WZF 11492/ 4/15	< >
4	3.6	6	57	3	0.6	4	25	WZF 11492/ 4/25	< >
4	5.6	6	57	5	0.7	6	25	WZF 11492/ 6/25	< >
4	5.6	6	78	5	0.7	6	35	WZF 11492/ 6/35	< >
4	7.3	8	63	6	0.8	8	25	WZF 11492/ 8/25	< >
4	7.3	8	80	6	0.8	8	40	WZF 11492/ 8/40	< >
4	9	10	78	7	1	10	30	WZF 11492/10/30	< >
4	9	10	105	7	1	10	50	WZF 11492/10/50	< >
4	11	12	83	8	1.2	12	35	WZF 11492/12/35	< >
4	11	12	105	8	1.2	12	60	WZF 11492/12/60	< >



REFERENCE VALUES FOR ROUGHING

WZF 11492	Material	Strength	Vc ¹ m/min.	d					
				3	4	6	8	10	12
				fz ² (mm/z)					
1.1730	640 N/mm ²	175	0,155	0,210	0,315	0,400	0,495	0,590	
1.2083	780 N/mm ²	175	0,155	0,210	0,315	0,400	0,495	0,590	
1.2085	1080 N/mm ²	135	0,155	0,210	0,315	0,400	0,495	0,590	
1.2162	660 N/mm ²	175	0,155	0,210	0,315	0,400	0,495	0,590	
1.2311	1080 N/mm ²	135	0,155	0,210	0,315	0,400	0,495	0,590	
1.2312	1080 N/mm ²	135	0,155	0,210	0,315	0,400	0,495	0,590	
1.2316	1010 N/mm ²	135	0,155	0,210	0,315	0,400	0,495	0,590	
1.2343	780 N/mm ²	175	0,155	0,210	0,315	0,400	0,495	0,590	
1.2379	780 N/mm ²	175	0,155	0,210	0,315	0,400	0,495	0,590	
1.2714 HH	1350 N/mm ²	125	0,155	0,210	0,315	0,400	0,495	0,590	
1.2767	830 N/mm ²	155	0,155	0,210	0,315	0,400	0,495	0,590	
1.2842	775 N/mm ²	175	0,155	0,210	0,315	0,400	0,495	0,590	
Steel	1400 N/mm ²	125	0,155	0,210	0,315	0,400	0,495	0,590	
ap (mm)				0,12	0,16	0,2	0,32	0,4	0,48
ae (mm)				1,5	2	3	4	5	6

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

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

Further materials and cutting values can be found in the cutting data calculator.