



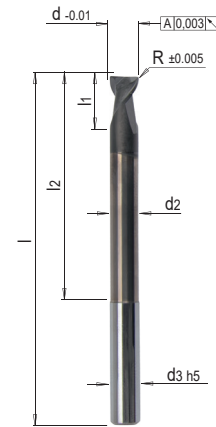
PRODUCT DESCRIPTION

- » Ultimate precision in the μ range
- » For highly precise contours and perfect concentricity
- » High-performance milling cutter for graphite
- » Especially for finish milling with extremely short cutting edges

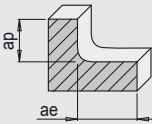
MATERIAL

- » Carbide, diamond coated

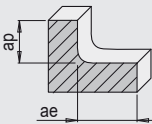
d3	d2	l	l1	d	l2	R	No.	EUR
4	0.95	60	0.4	1	10	0.1	WZF 279967/ 1/10/0,1	< >
4	1.9	60	0.6	2	12	0.3	WZF 279967/ 2/12/0,3	< >
4	1.9	60	0.8	2	12	0.5	WZF 279967/ 2/12/0,5	< >
4	1.9	60	0.6	2	24	0.3	WZF 279967/ 2/24/0,3	< >
4	1.9	60	0.8	2	24	0.5	WZF 279967/ 2/24/0,5	< >
6	2.8	60	0.4	3	18	0.1	WZF 279967/ 3/18/0,1	< >
6	2.8	60	0.6	3	30	0.3	WZF 279967/ 3/30/0,3	< >
6	2.8	60	0.8	3	18	0.5	WZF 279967/ 3/18/0,5	< >
6	2.8	60	0.4	3	30	0.1	WZF 279967/ 3/30/0,1	< >
6	3.8	60	0.5	4	30	0.2	WZF 279967/ 4/30/0,2	< >
6	3.8	60	0.6	4	30	0.3	WZF 279967/ 4/30/0,3	< >
6	3.8	60	0.8	4	30	0.5	WZF 279967/ 4/30/0,5	< >
6	5.8	70	0.6	6	45	0.3	WZF 279967/ 6/45/0,3	< >
6	5.8	70	1	6	45	0.5	WZF 279967/ 6/45/0,5	< >
6	5.8	70	1.5	6	45	1	WZF 279967/ 6/45/1	< >
8	7.8	80	1	8	40	0.5	WZF 279967/ 8/40/0,5	< >
8	7.8	80	1.5	8	40	1	WZF 279967/ 8/40/1	< >
8	7.8	100	1	8	60	0.5	WZF 279967/ 8/60/0,5	< >
8	7.8	100	1.5	8	60	1	WZF 279967/ 8/60/1	< >
8	7.8	120	1	8	85	0.5	WZF 279967/ 8/85/0,5	< >
10	9.8	120	1	10	70	0.5	WZF 279967/10/70/0,5	< >
10	9.8	120	1.5	10	70	1	WZF 279967/10/70/1	< >
12	11.8	110	1.5	12	70	1	WZF 279967/12/70/1	< >



REFERENCE VALUES FOR ROUGHING

WZF 279967	Material	Grit size	Vc ¹ m/min.	d							
				1	2	3	4	6	8	10	12
				fz ² (mm/z)							
	Graphite	1 - 4 μ	200	0.01	0.02	0.03	0.04	0.06	0.080	0.100	0.120
	Graphite	5 - 8 μ	250	0.012	0.024	0.036	0.048	0.072	0.096	0.120	0.144
	Graphite	9 - 12 μ	300	0.014	0.028	0.042	0.056	0.084	0.111	0.139	0.167
	Graphite	13 - 25 μ	350	0.016	0.032	0.048	0.064	0.096	0.129	0.161	0.194
ap (mm)				R+0.3	R+0.3	R+0.3	R+0.3	R+0.5	R+0.5	R+0.5	R+0.5
ae (mm)				0.70	1.40	2.10	2.80	4.20	5.60	7.00	8.40

REFERENCE VALUES FOR BOTTOM FINISH MILLING

WZF 279967	Material	Grit size	Vc ¹ m/min.	d							
				1	2	3	4	6	8	10	12
				fz ² (mm/z)							
	Graphite	1 - 4 μ	250	0.009	0.018	0.027	0.036	0.054	0.720	0.900	1.080
	Graphite	5 - 8 μ	300	0.011	0.022	0.032	0.043	0.065	0.864	1.080	1.296
	Graphite	9 - 12 μ	350	0.013	0.025	0.038	0.05	0.076	1.037	1.296	1.555
	Graphite	13 - 25 μ	400	0.014	0.029	0.043	0.058	0.086	1.244	1.555	1.866
ap (mm)				R+0.3	R+0.3	R+0.3	R+0.3	R+0.5	R+0.5	R+0.5	R+0.5
ae (mm)				0.40	0.80	1.20	1.60	2.40	3.20	4.00	4.80

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

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

i You can find further materials and cutting values in the cutting data calculator.

CORRECTION FACTORS

For two-edged milling cutters with a neck length of up to 6xD, you can work with an infeed (ap) that equals 100% of the diameter.

ø / L	max. ap	fz
<10	ap x 0.8	fz x 0.8
<15	ap x 0.5	fz x 0.5
>15	ap x 0.2	fz x 0.2