



PRODUCT DESCRIPTION

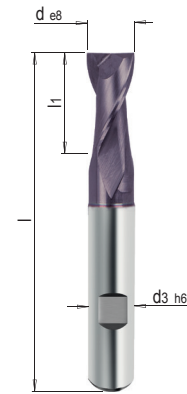
» High-performance end milling cutter with centre cut and special bore face

MATERIAL

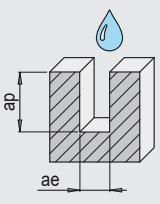
» Carbide, TiAlN multi-layer coated



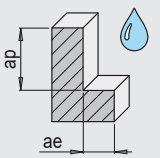
Z	d3	l	l1	C	d	No.	EUR
2	4	40	6	0.02	2	WZF 14248P/ 2	< >
2	4	50	8	0.03	3	WZF 14248P/ 3	< >
2	6	50	11	0.04	4	WZF 14248P/ 4	< >
2	6	50	13	0.05	5	WZF 14248P/ 5	< >
2	6	50	13	0.06	6	WZF 14248P/ 6	< >
2	8	60	16	0.07	7	WZF 14248P/ 7	< >
2	8	60	19	0.08	8	WZF 14248P/ 8	< >
2	10	70	22	0.10	10	WZF 14248P/10	< >
2	12	75	26	0.12	12	WZF 14248P/12	< >



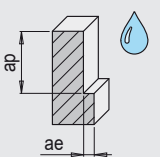
REFERENCE VALUES FOR SLOTTING

WZF 14248P	Material	Strength	Vc ¹ m/min.	d						
				2	3	4	6	8	10	12
				fz ² (mm/z)						
 <p>ap = 1 x d ae = 1 x d</p>	1.1730	640 N/mm ²	100	0.012	0.019	0.025	0.037	0.050	0.062	0.074
	1.2083	780 N/mm ²	70	0.010	0.015	0.020	0.030	0.040	0.050	0.060
	1.2085	1080 N/mm ²	70	0.010	0.015	0.020	0.030	0.040	0.050	0.060
	1.2162	660 N/mm ²	100	0.012	0.019	0.025	0.037	0.050	0.062	0.074
	1.2311	1080 N/mm ²	70	0.011	0.017	0.022	0.033	0.044	0.055	0.066
	1.2312	1080 N/mm ²	80	0.011	0.017	0.022	0.033	0.044	0.055	0.066
	1.2316	1010 N/mm ²	70	0.010	0.015	0.020	0.030	0.040	0.050	0.060
	1.2343	780 N/mm ²	80	0.012	0.019	0.025	0.037	0.050	0.062	0.074
	1.2379	780 N/mm ²	70	0.010	0.015	0.020	0.030	0.040	0.050	0.060
	1.2714HH	1350 N/mm ²	50	0.010	0.015	0.020	0.030	0.040	0.050	0.060
	1.2767	830 N/mm ²	80	0.011	0.017	0.022	0.033	0.044	0.055	0.066
	1.2842	775 N/mm ²	80	0.011	0.017	0.022	0.033	0.044	0.055	0.066
	Steel	1400 N/mm ²	50	0.010	0.015	0.020	0.030	0.040	0.050	0.060

REFERENCE VALUES FOR ROUGHING

WZF 14248P	Material	Strength	Vc ¹ m/min.	d						
				2	3	4	6	8	10	12
				fz ² (mm/z)						
 <p>ap = 0.5 x d ae = 1 x d</p>	1.1730	640 N/mm ²	120	0.015	0.023	0.031	0.046	0.062	0.077	0.092
	1.2083	780 N/mm ²	80	0.011	0.016	0.021	0.032	0.042	0.053	0.064
	1.2085	1080 N/mm ²	80	0.011	0.016	0.021	0.032	0.042	0.053	0.064
	1.2162	660 N/mm ²	120	0.014	0.021	0.028	0.042	0.056	0.070	0.084
	1.2311	1080 N/mm ²	90	0.011	0.017	0.022	0.034	0.045	0.056	0.067
	1.2312	1080 N/mm ²	90	0.011	0.016	0.021	0.032	0.042	0.053	0.064
	1.2316	1010 N/mm ²	80	0.011	0.016	0.021	0.032	0.042	0.053	0.064
	1.2343	780 N/mm ²	100	0.014	0.021	0.028	0.042	0.056	0.070	0.084
	1.2379	780 N/mm ²	80	0.011	0.016	0.021	0.032	0.042	0.053	0.064
	1.2714HH	1350 N/mm ²	60	0.011	0.016	0.021	0.032	0.042	0.053	0.064
	1.2767	830 N/mm ²	90	0.013	0.020	0.027	0.040	0.054	0.067	0.080
	1.2842	775 N/mm ²	90	0.014	0.021	0.028	0.042	0.056	0.070	0.084
	Steel	1400 N/mm ²	60	0.008	0.012	0.016	0.023	0.031	0.039	0.047

REFERENCE VALUES FOR FINISH MILLING

WZF 14248P	Material	Strength	Vc ¹ m/min.	d						
				2	3	4	6	8	10	12
				fz ² (mm/z)						
 <p>ap = 0.1 x d ae = 1.5 x d</p>	1.1730	640 N/mm ²	160	0.012	0.018	0.024	0.037	0.049	0.061	0.073
	1.2083	780 N/mm ²	110	0.008	0.012	0.016	0.025	0.033	0.041	0.049
	1.2085	1080 N/mm ²	110	0.008	0.012	0.016	0.025	0.033	0.041	0.049
	1.2162	660 N/mm ²	160	0.011	0.017	0.022	0.033	0.044	0.055	0.066
	1.2311	1080 N/mm ²	120	0.009	0.013	0.018	0.026	0.035	0.044	0.053
	1.2312	1080 N/mm ²	120	0.008	0.012	0.016	0.025	0.033	0.041	0.049
	1.2316	1010 N/mm ²	110	0.008	0.012	0.016	0.025	0.033	0.041	0.049
	1.2343	780 N/mm ²	130	0.011	0.017	0.022	0.033	0.044	0.055	0.066
	1.2379	780 N/mm ²	110	0.008	0.012	0.016	0.025	0.033	0.041	0.049
	1.2714HH	1350 N/mm ²	80	0.008	0.012	0.016	0.025	0.033	0.041	0.049
	1.2767	830 N/mm ²	120	0.010	0.016	0.021	0.031	0.042	0.052	0.062
	1.2842	775 N/mm ²	120	0.011	0.017	0.022	0.033	0.044	0.055	0.066
	Steel	1400 N/mm ²	80	0.007	0.010	0.013	0.020	0.026	0.033	0.040

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.