



PRODUCT DESCRIPTION

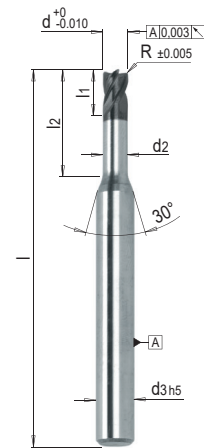
- » With precision-ground, robust cutting edges
- » High-performance milling cutter for high-speed cutting
- » Ultimate precision in the μ range

MATERIAL

» AlTiN coated

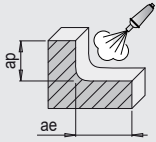


d2	d3	l	l1	d	l2	R	No.	EUR
1.95	4	48	2.5	2	4	0.2	WZF 27498/ 2 / 4/0,2	< >
1.95	4	48	2.5	2	6	0.2	WZF 27498/ 2 / 6/0,2	< >
1.95	4	48	2.5	2	12	0.2	WZF 27498/ 2 /12/0,2	< >
2.9	6	60	3.5	3	8	0.1	WZF 27498/ 3 / 8/0,1	< >
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3.9	6	60	4.5	4	8	1	WZF 27498/ 4 / 8/1	< >
3.9	6	60	4.5	4	12	0.2	WZF 27498/ 4 /12/0,2	< >
3.9	6	60	4.5	4	12	0.4	WZF 27498/ 4 /12/0,4	< >
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5.9	6	60	6.5	6	12	0.3	WZF 27498/ 6 /12/0,3	< >
5.9	6	60	6.5	6	12	0.5	WZF 27498/ 6 /12/0,5	< >
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5.9	6	60	6.5	6	20	0.6	WZF 27498/ 6 /20/0,6	< >



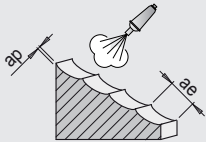
REFERENCE VALUES FOR ROUGHING

WZF 27496 WZF 27498	Material	Strength	Vc ¹ m/min.	d							
				0.8	1	1.5	2	3	4	5	6
				fz ² (mm/z)							
1.1730	640 N/mm ²	80	0.010	0.012	0.018	0.024	0.036	0.048	0.060	0.072	
1.2083	780 N/mm ²	80	0.010	0.012	0.018	0.024	0.036	0.048	0.060	0.072	
1.2083	52 HRC	68	0.008	0.010	0.015	0.020	0.030	0.040	0.050	0.060	
1.2085	1080 N/mm ²	75	0.010	0.012	0.018	0.024	0.036	0.048	0.060	0.072	
1.2162	660 N/mm ²	80	0.010	0.012	0.018	0.024	0.036	0.048	0.060	0.072	
1.2162	52 HRC	68	0.008	0.010	0.015	0.020	0.030	0.040	0.050	0.060	
1.2311	1080 N/mm ²	75	0.010	0.012	0.018	0.024	0.036	0.048	0.060	0.072	
1.2312	1080 N/mm ²	75	0.010	0.012	0.018	0.024	0.036	0.048	0.060	0.072	
1.2316	1010 N/mm ²	75	0.010	0.012	0.018	0.024	0.036	0.048	0.060	0.072	
1.2343	780 N/mm ²	80	0.010	0.012	0.018	0.024	0.036	0.048	0.060	0.072	
1.2343	52 HRC	68	0.008	0.010	0.015	0.020	0.030	0.040	0.050	0.060	
1.2379	780 N/mm ²	80	0.010	0.012	0.018	0.024	0.036	0.048	0.060	0.072	
1.2714 HH	1350 N/mm ²	75	0.010	0.012	0.018	0.024	0.036	0.048	0.060	0.072	
1.2767	830 N/mm ²	80	0.010	0.012	0.018	0.024	0.036	0.048	0.060	0.072	
1.2767	52 HRC	68	0.008	0.010	0.015	0.020	0.030	0.040	0.050	0.060	
1.2842	775 N/mm ²	80	0.010	0.012	0.018	0.024	0.036	0.048	0.060	0.072	
Steel	1400 N/mm ²	75	0.010	0.012	0.018	0.024	0.036	0.048	0.060	0.072	
ap (mm)			0.032	0.04	0.060	0.08	0.12	0.16	0.20	0.24	
ae (mm)			0.280	0.35	0.525	0.70	1.05	1.40	1.75	2.10	



REFERENCE VALUES FOR FINISH MILLING

WZF 27496 WZF 27498	Material	Strength	Vc ¹ m/min.	d							
				0.8	1	1.5	2	3	4	5	6
				fz ² (mm/z)							
1.1730	640 N/mm ²	100	0.008	0.010	0.015	0.020	0.030	0.040	0.050	0.060	
1.2083	780 N/mm ²	100	0.008	0.010	0.015	0.020	0.030	0.040	0.050	0.060	
1.2083	52 HRC	90	0.008	0.010	0.015	0.020	0.030	0.040	0.050	0.060	
1.2085	1080 N/mm ²	95	0.008	0.010	0.015	0.020	0.030	0.040	0.050	0.060	
1.2162	660 N/mm ²	100	0.008	0.010	0.015	0.020	0.030	0.040	0.050	0.060	
1.2162	52 HRC	90	0.008	0.010	0.015	0.020	0.030	0.040	0.050	0.060	
1.2311	1080 N/mm ²	95	0.008	0.010	0.015	0.020	0.030	0.040	0.050	0.060	
1.2312	1080 N/mm ²	95	0.008	0.010	0.015	0.020	0.030	0.040	0.050	0.060	
1.2316	1010 N/mm ²	95	0.008	0.010	0.015	0.020	0.030	0.040	0.050	0.060	
1.2343	780 N/mm ²	100	0.008	0.010	0.015	0.020	0.030	0.040	0.050	0.060	
1.2343	52 HRC	90	0.008	0.010	0.015	0.020	0.030	0.040	0.050	0.060	
1.2379	780 N/mm ²	100	0.008	0.010	0.015	0.020	0.030	0.040	0.050	0.060	
1.2714 HH	1350 N/mm ²	95	0.008	0.010	0.015	0.020	0.030	0.040	0.050	0.060	
1.2767	830 N/mm ²	100	0.008	0.010	0.015	0.020	0.030	0.040	0.050	0.060	
1.2767	52 HRC	90	0.008	0.010	0.015	0.020	0.030	0.040	0.050	0.060	
1.2842	775 N/mm ²	100	0.008	0.010	0.015	0.020	0.030	0.040	0.050	0.060	
Steel	1400 N/mm ²	95	0.008	0.010	0.015	0.020	0.030	0.040	0.050	0.060	
ap (mm)			0.016	0.02	0.03	0.04	0.06	0.08	0.10	0.12	
ae (mm)			0.160	0.20	0.30	0.40	0.60	0.80	1.00	1.20	



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.