



PRODUCT DESCRIPTION

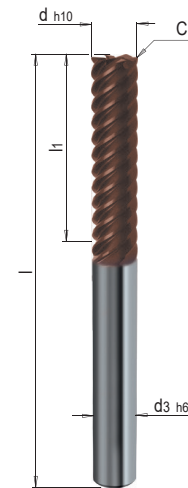
» High-performance milling cutter with centre cut for fine finishing

MATERIAL

» Carbide, TiAlSiN multi-layer coated



Z	d3	l	l1	C	d	No.	EUR
6	6	75	30	0.05	6	WZF 13556/ 6	< >
6	8	100	40	0.1	8	WZF 13556/ 8	< >
6	10	100	40	0.1	10	WZF 13556/10	< >
6	12	150	45	0.1	12	WZF 13556/12	< >
6	16	150	65	0.15	16	WZF 13556/16	< >
8	20	150	65	0.15	20	WZF 13556/20	< >



REFERENCE VALUES FOR FINISH MILLING

WZF 13556	Material	Strength	Vc ¹ m/min.	d					
				6	8	10	12	16	20
				fz ² (mm/z)					
<p>ae = 0.05 x d ap = 3 x d</p>	1.2083	52 HRC	70	0.010	0.013	0.018	0.022	0.027	0.032
	1.2162	52 HRC	110	0.010	0.013	0.018	0.022	0.027	0.032
	1.2343	52 HRC	110	0.010	0.013	0.018	0.022	0.027	0.032
	1.2379	60 HRC	70	0.010	0.013	0.018	0.022	0.027	0.032
	1.2714HH	43 HRC	120	0.010	0.013	0.018	0.022	0.027	0.032
	1.2767	52 HRC	100	0.010	0.013	0.018	0.022	0.027	0.032
	1.2842	60 HRC	70	0.010	0.013	0.018	0.022	0.027	0.032
	Steel	1400 N/mm ²	120	0.010	0.013	0.018	0.022	0.027	0.032

REFERENCE VALUES FOR FINISH MILLING

WZF 13556	Material	Strength	Vc ¹ m/min.	d					
				6	8	10	12	16	20
				fz ² (mm/z)					
<p>ae = 0.05 x d ap = 2 x d</p>	1.2083	52 HRC	70	0.013	0.017	0.023	0.027	0.034	0.040
	1.2162	52 HRC	110	0.013	0.017	0.023	0.027	0.034	0.040
	1.2343	52 HRC	110	0.013	0.017	0.023	0.027	0.034	0.040
	1.2379	60 HRC	70	0.013	0.017	0.023	0.027	0.034	0.040
	1.2714HH	43 HRC	120	0.013	0.017	0.023	0.027	0.034	0.040
	1.2767	52 HRC	100	0.013	0.017	0.023	0.027	0.034	0.040
	1.2842	60 HRC	70	0.013	0.017	0.023	0.027	0.034	0.040
	Steel	1400 N/mm ²	120	0.013	0.017	0.023	0.027	0.034	0.040

REFERENCE VALUES FOR FINISH MILLING

WZF 13576	Material	Strength	Vc ¹ m/min.	d				
				6	8	10	12	16
				fz ² (mm/z)				
<p>ae = 0.05 x d ap = 1.5 x d</p>	1.2083	52 HRC	70	0.010	0.013	0.018	0.022	0.027
	1.2162	52 HRC	110	0.010	0.013	0.018	0.022	0.027
	1.2343	52 HRC	110	0.010	0.013	0.018	0.022	0.027
	1.2379	60 HRC	70	0.010	0.013	0.018	0.022	0.027
	1.2714HH	43 HRC	110	0.010	0.013	0.018	0.022	0.027
	1.2767	52 HRC	100	0.010	0.013	0.018	0.022	0.027
	1.2842	60 HRC	70	0.010	0.013	0.018	0.022	0.027
	Steel	1400 N/mm ²	110	0.010	0.013	0.018	0.022	0.027

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

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

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