



### PRODUCT DESCRIPTION

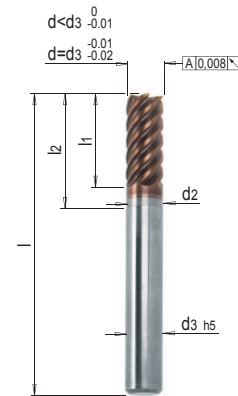
» High-performance milling cutter with centre cut for fine finishing

### MATERIAL

» Carbide, TiSiN coated



Z	d2	d3	l	l2	l1	d	No.	EUR
4	2.9	4	50	15	9	3	WZF 13746/ 3	< >
4	3.9	6	60	16	11	4	WZF 13746/ 4	< >
4	4.9	6	60	20	13	5	WZF 13746/ 5	< >
6	5.9	6	60	20	13	6	WZF 13746/ 6	< >
6	7.9	8	70	25	19	8	WZF 13746/ 8	< >
6	9.9	10	80	30	22	10	WZF 13746/10	< >
6	11.9	12	80	35	26	12	WZF 13746/12	< >
8	15.9	16	90	40	32	16	WZF 13746/16	< >



### REFERENCE VALUES FOR FINISH MILLING

WZF 13746	Material	Strength	Vc <sup>1</sup> m/min.	d							
				3	4	5	6	8	10	12	16
				fz <sup>2</sup> (mm/z)							
<p>ae = 0.03 x d ap = 1.7 x d</p>	1.2083	52 HRC	100	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2162	52 HRC	130	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2343	52 HRC	130	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2379	60 HRC	75	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2767	52 HRC	90	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2842	60 HRC	75	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2714HH	43 HRC	140	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.3343	64 HRC	65	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.3344 PM	64 HRC	65	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	M V10 PM	62 HRC	70	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	M W10 PM	65 HRC	60	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046

### REFERENCE VALUES FOR FINISH MILLING

WZF 13746	Material	Strength	Vc <sup>1</sup> m/min.	d							
				3	4	5	6	8	10	12	16
				fz <sup>2</sup> (mm/z)							
<p>ae = 0.06 x d ap = 1.7 x d</p>	1.2083	52 HRC	90	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2162	52 HRC	120	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2343	52 HRC	120	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2379	60 HRC	70	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2767	52 HRC	90	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2842	60 HRC	70	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2714HH	43 HRC	120	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.3343	64 HRC	60	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.3344 PM	64 HRC	60	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	M V10 PM	62 HRC	65	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	M W10 PM	65 HRC	55	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046

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.