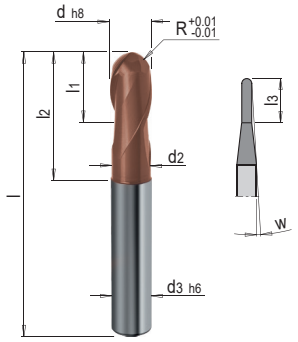
meusburger

CARBIDE 3D FULL-RADIUS MILLING CUTTER FOR HARD MACHINING, SHORT — WZF 18518



PRODUCT DESCRIPTION

» High-performance milling cutter with centre cut for 3D hard machining
» Relieved behind the cutting edge

MATERIAL

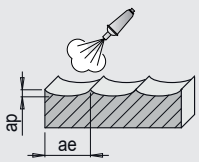
» Carbide, TiAlSiN multi-layer coated

P	M	K	N	S	H
○		●			●

Z	d2	d3	l	l1	l2	l3	R	w	d	No.	#CU#
4	1.9	6	57	3	21	10	1	5.8	**2**	WZF 18518/ 2	XX,YY
4	2.8	6	57	3.5	21	14	1.5	4.4	**3**	WZF 18518/ 3	XX,YY
4	3.8	6	57	4	21	16	2	3.1	**4**	WZF 18518/ 4	XX,YY
4	4.8	6	57	5	21	18	2.5	1.6	**5**	WZF 18518/ 5	XX,YY
4	5.7	6	57	6	21	-	3	-	**6**	WZF 18518/ 6	XX,YY
4	7.7	8	63	7	27	-	4	-	**8**	WZF 18518/ 8	XX,YY
4	9.5	10	72	8	32	-	5	-	**10**	WZF 18518/10	XX,YY
4	11.5	12	83	10	38	-	6	-	**12**	WZF 18518/12	XX,YY

REFERENCE VALUES FOR ROUGHING

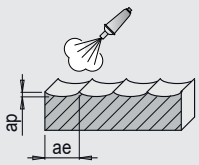
WZF 18518
WZF 18528



Material	Strength	Vc[1] m/min.	d						
			2	3	4	6	8	10	12
			fz[2] (mm/z)						
1.2083	52 HRC	120	0.020	0.030	0.035	0.035	0.040	0.050	0.070
1.2162	52 HRC	180	0.020	0.030	0.035	0.035	0.040	0.050	0.070
1.2343	52 HRC	180	0.020	0.030	0.035	0.035	0.040	0.050	0.070
1.2379	60 HRC	120	0.020	0.030	0.035	0.035	0.040	0.050	0.070
1.2767	52 HRC	180	0.020	0.030	0.035	0.035	0.040	0.050	0.070
1.2842	60 HRC	140	0.020	0.030	0.035	0.035	0.040	0.050	0.070
ap (mm)			0.10	0.15	0.20	0.30	0.40	0.60	0.75
ae (mm)			0.15	0.15	0.30	0.40	0.50	0.75	1.00

REFERENCE VALUES FOR FINISH MILLING

WZF 18518
WZF 18528



Material	Strength	Vc[1] m/min.	d						
			2	3	4	6	8	10	12
			fz[2] (mm/z)						
1.2083	52 HRC	180	0.030	0.040	0.045	0.045	0.050	0.070	0.100
1.2162	52 HRC	280	0.030	0.040	0.045	0.045	0.050	0.070	0.100
1.2343	52 HRC	280	0.030	0.040	0.045	0.045	0.050	0.070	0.100
1.2379	60 HRC	180	0.025	0.030	0.040	0.040	0.045	0.050	0.070
1.2767	52 HRC	280	0.030	0.040	0.045	0.045	0.050	0.070	0.100
1.2842	60 HRC	230	0.025	0.030	0.040	0.040	0.045	0.050	0.070
ap (mm)			0.05	0.07	0.10	0.14	0.16	0.18	0.20
ae (mm)			0.05	0.05	0.07	0.10	0.15	0.20	0.25

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.

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