

PRODUCT DESCRIPTION

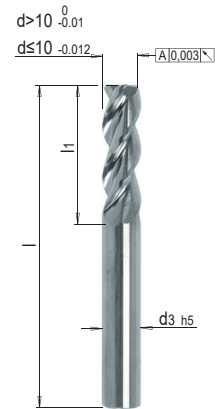
- » High-performance milling cutter for aluminium and copper materials
- » With non-uniform pitch and centre cut

MATERIAL

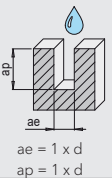
- » Carbide, polished



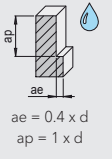
| Z | d3 | l | l1 | d | No. | EUR |
|---|----|----|-----|-----|----------------|-----|
| 3 | 4 | 45 | 3 | 1 | WZF 22848/ 1 | <> |
| 3 | 4 | 45 | 4.5 | 1.5 | WZF 22848/ 1,5 | <> |
| 3 | 4 | 45 | 6 | 2 | WZF 22848/ 2 | <> |
| 3 | 4 | 50 | 7.5 | 2.5 | WZF 22848/ 2,5 | <> |
| 3 | 4 | 50 | 9 | 3 | WZF 22848/ 3 | <> |
| 3 | 4 | 50 | 12 | 4 | WZF 22848/ 4 | <> |
| 3 | 6 | 50 | 15 | 5 | WZF 22848/ 5 | <> |
| 3 | 6 | 50 | 18 | 6 | WZF 22848/ 6 | <> |
| 3 | 8 | 60 | 20 | 8 | WZF 22848/ 8 | <> |
| 3 | 10 | 75 | 25 | 10 | WZF 22848/10 | <> |
| 3 | 12 | 75 | 30 | 12 | WZF 22848/12 | <> |



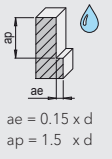
REFERENCE VALUES FOR SLOTTING

| WZF 22484 | Material | Strength | Vc ¹ m/min. | d | | | | | | | | | | |
|--|---------------------|------------------------|---------------------------|------------------------|-------|-------|-------|-------|-------|-------|-------|-------|--|--|
| | | | | 1 | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | | |
| | | | | fz ² (mm/z) | | | | | | | | | | |
|  <p>ae = 1 x d ap = 1 x d</p> | 3.3547 / EN AW-5083 | 270N/mm ² | 360 | 0,005 | 0,02 | 0,036 | 0,047 | 0,06 | 0,072 | 0,096 | 0,12 | 0,144 | | |
| | 3.4365 / EN AW-7075 | 520N/mm ² | 360 | 0,005 | 0,02 | 0,036 | 0,047 | 0,06 | 0,072 | 0,096 | 0,12 | 0,144 | | |
| | copper | 280N/mm ² | 110 | 0,004 | 0,016 | 0,029 | 0,038 | 0,048 | 0,058 | 0,077 | 0,096 | 0,115 | | |
| | Non-ferrous metal | < 800N/mm ² | 210 | 0,004 | 0,016 | 0,029 | 0,038 | 0,048 | 0,058 | 0,077 | 0,096 | 0,115 | | |

REFERENCE VALUES FOR ROUGHING


| WZF 22848 | Material | Strength | Vc ¹ m/min. | d | | | | | | | | | | |
|--|---------------------|------------------------|---------------------------|------------------------|-------|-------|-------|-------|-------|-------|-------|-------|--|--|
| | | | | 1 | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | | |
| | | | | fz ² (mm/z) | | | | | | | | | | |
|  <p>ae = 0.4 x d ap = 1 x d</p> | 3.3547 / EN AW-5083 | 270N/mm ² | 450 | 0,005 | 0,02 | 0,036 | 0,047 | 0,06 | 0,072 | 0,096 | 0,12 | 0,144 | | |
| | 3.4365 / EN AW-7075 | 520N/mm ² | 450 | 0,005 | 0,02 | 0,036 | 0,047 | 0,06 | 0,072 | 0,096 | 0,12 | 0,144 | | |
| | copper | 280N/mm ² | 180 | 0,004 | 0,016 | 0,029 | 0,038 | 0,048 | 0,058 | 0,077 | 0,096 | 0,115 | | |
| | Non-ferrous metal | < 800N/mm ² | 360 | 0,004 | 0,016 | 0,029 | 0,038 | 0,048 | 0,058 | 0,077 | 0,096 | 0,115 | | |

REFERENCE VALUES FOR FINISH MILLING

| WZF 22848 | Material | Strength | Vc ¹ m/min. | d | | | | | | | | | | |
|---|---------------------|------------------------|---------------------------|------------------------|-------|-------|-------|-------|-------|-------|-------|-------|--|--|
| | | | | 1 | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | | |
| | | | | fz ² (mm/z) | | | | | | | | | | |
|  <p>ae = 0.15 x d ap = 1.5 x d</p> | 3.3547 / EN AW-5083 | 270N/mm ² | 450 | 0,01 | 0,04 | 0,072 | 0,094 | 0,12 | 0,144 | 0,192 | 0,24 | 0,288 | | |
| | 3.4365 / EN AW-7075 | 520N/mm ² | 450 | 0,01 | 0,04 | 0,072 | 0,094 | 0,12 | 0,144 | 0,192 | 0,24 | 0,288 | | |
| | copper | 280N/mm ² | 180 | 0,008 | 0,032 | 0,057 | 0,075 | 0,096 | 0,115 | 0,153 | 0,192 | 0,23 | | |
| | Non-ferrous metal | < 800N/mm ² | 360 | 0,008 | 0,032 | 0,057 | 0,075 | 0,096 | 0,115 | 0,153 | 0,192 | 0,23 | | |

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.