

PRODUCT DESCRIPTION

- » Maximum feed rates
- » Maximum stability
- » High metal removal rate

Indexable round insert milling cutter with steel shank											
WZT 2512	E	d3	d4	a	l1	PG	d	Z	l	No.	EUR
	E 1 (T 6)	10	-	2.5	25	05	10	2	165	WZT 2512/05/10/ 2/165/A	<>
	E 1 (T 6)	12	-	2.5	32	05	12	3	165	WZT 2512/05/12/ 3/165/A	<>
	E 1 (T 6)	16	-	2.5	32	05	16	4	81	WZT 2512/05/16/ 4/ 81/B	<>
	E 1 (T 6)	16	-	2.5	40	05	16	4	165	WZT 2512/05/16/ 4/165/A	<>
	E 2 (T 8)	16	-	4	32	08	16	2	81	WZT 2512/08/16/ 2/ 81/B	<>
	E 2 (T 8)	16	-	4	40	08	16	2	165	WZT 2512/08/16/ 2/165/A	<>
	E 2 (T 8)	20	-	4	60	08	20	3	110	WZT 2512/08/20/ 3/110/A	<>
	E 2 (T 8)	20	-	4	50	08	20	3	200	WZT 2512/08/20/ 3/200/A	<>
	E 2 (T 8)	25	-	4	60	08	25	4	116	WZT 2512/08/25/ 4/116/A	<>
	E 2 (T 8)	25	-	4	60	08	25	4	225	WZT 2512/08/25/ 4/225/A	<>
	E 6 (T10)	25	-	5	60	10	25	3	116	WZT 2512/10/25/ 3/116/B	<>
	E 6 (T10)	25	-	5	60	10	25	3	225	WZT 2512/10/25/ 3/225/A	<>
	E 6 (T10)	32	-	5	70	10	32	4	130	WZT 2512/10/32/ 4/130/A	<>
	E 4 (T15)	32	-	6	40	12	32	3	100	WZT 2512/12/32/ 3/100/B	<>
Indexable round insert milling cutter with screw-in thread											
WZT 2514	E	d2	d4	a	l1	PG	d	Z	l	No.	EUR
	E 2 (T 8)	M10	10.5	4	33	08	20	3	-	WZT 2514/08/20/ 3	<>
	E 2 (T 8)	M12	12.5	4	35	08	25	4	-	WZT 2514/08/25/ 4	<>
	E 2 (T 8)	M16	17	4	35	08	32	5	-	WZT 2514/08/32/ 5	<>
	E 6 (T10)	M10	10.5	5	33	10	20	2	-	WZT 2514/10/20/ 2	<>
	E 6 (T10)	M12	12.5	5	35	10	25	3	-	WZT 2514/10/25/ 3	<>
	E 6 (T10)	M16	17	5	35	10	32	4	-	WZT 2514/10/32/ 4	<>
	E 4 (T15)	M12	12.5	6	35	12	25	2	-	WZT 2514/12/25/ 2	<>
	E 4 (T15)	M16	17	6	35	12	32	3	-	WZT 2514/12/32/ 3	<>
	E 4 (T15)	M16	17	6	42	12	42	4	-	WZT 2514/12/42/ 4	<>
Indexable round insert milling cutter, shell-type											
WZT 2516	E	d1	d2	a	l1	PG	d	Z	l	No.	EUR
	E 6 (T10), E25	16	38	5	40	10	40	5	-	WZT 2516/10/40/ 5	<>
	E 6 (T10), E25	16	38	5	40	10	42	6	-	WZT 2516/10/42/ 6	<>
	E 6 (T10)	22	43	5	40	10	50	4	-	WZT 2516/10/50/ 4	<>
	E 6 (T10)	22	43	5	40	10	52	6	-	WZT 2516/10/52/ 6	<>
	E 4 (T15)	22	43	6	40	12	50	4	-	WZT 2516/12/50/ 4	<>
	E 4 (T15)	22	43	6	40	12	52	5	-	WZT 2516/12/52/ 5	<>
	E 4 (T15)	22	48	6	40	12	63	6	-	WZT 2516/12/63/ 6	<>

1) E: matching screws WZE 100 / WZE 200


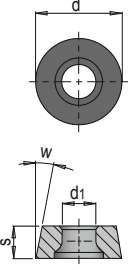
2) PG: plate size

i Supplied without indexable insert, with screw for indexable inserts

PRODUCT DESCRIPTION


- » Specifically for the materials used in die and mould making
- » Maximum metal removal rate
- » Maximum feed rates




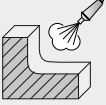
WZP 251	ISO	d	s	d1	R	w	System	PG ¹⁾	PS ²⁾	 Pcs. / PU	No.	EUR
	RDHX 0501MOFN	5	1.59	2.5	2.5	15	WZP 251	05	F20	10	WZP 251/05/F20	<>
	RDHX 0501MOSN	5	1.59	2.5	2.5	15	WZP 251	05	M45	10	WZP 251/05/M45	<>
	RDHX 0802MOSN-F50	8	2.38	2.8	4	15	WZP 251	08	M54	10	WZP 251/08/M54	<>
	RDHX 0802MOFN	8	2.38	2.8	4	15	WZP 251	08	F20	10	WZP 251/08/F20	<>
	RDHX 0802MOSN	8	2.38	2.8	4	15	WZP 251	08	M45	10	WZP 251/08/M45	<>
	RPHX 10T3MOFN-27P	10	3.97	3.4	5	11	WZP 251	10	F20	10	WZP 251/10/F20	<>
	RPHX 10T3MOSN-F50	10	3.97	3.4	5	11	WZP 251	10	F54	10	WZP 251/10/F54	<>
	RPHX 10T3MOSN-M50	10	3.97	3.4	5	11	WZP 251	10	M54	10	WZP 251/10/M54	<>
	RPNX 10T3MOSN-F50	10	3.97	3.4	5	11	WZP 251	10	F45	10	WZP 251/10/F45	<>
	RPHX 1204MOFN-27P	12	4.76	4.4	6	11	WZP 251	12	F20	10	WZP 251/12/F20	<>
	RPHX 1204MOSN-F50	12	4.76	4.4	6	11	WZP 251	12	F54	10	WZP 251/12/F54	<>
	RPHX 1204MOSN-F50	12	4.76	4.4	6	11	WZP 251	12	F45	10	WZP 251/12/F45	<>
	RPHX 1204MOSN-M50	12	4.76	4.4	6	11	WZP 251	12	M54	10	WZP 251/12/M54	<>
	RPNX 1204M8EN-R60	12	4.76	4.4	6	11	WZP 251	12	R80	10	WZP 251/12/R80	<>

1) PG: plate size

2) PS: plate type

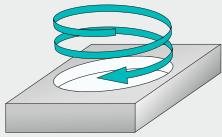
 Overview of plate types on page IL

REFERENCE VALUES FOR ROUGHING

WZP 251 	Material	Strength	PS	Vc m/min.	WZP 251 05		WZP 251 08		WZP 251 10		WZP 251 12	
					fz mm	ap mm	fz mm	ap mm	fz mm	ap mm	fz mm	ap mm
	1.1730	640 N/mm ²	M 45	220	0.1 - 0.4	0.25 - 1.0	0.15 - 0.4	0.5 - 1.5	0.15 - 0.5	0.5 - 2.5	0.2 - 0.8	0.5 - 3.0
	1.2083	780 N/mm ²	M 54	180			0.08 - 0.35	0.5 - 1.5	0.08 - 0.35	0.5 - 2.5	0.08 - 0.35	0.5 - 3.0
	1.2083	52 HRC	R 80	60							0.05 - 0.35	0.5 - 3.0
	1.2085	1080 N/mm ²	M 54	180			0.08 - 0.35	0.5 - 1.5	0.08 - 0.35	0.5 - 2.5	0.08 - 0.35	0.5 - 3.0
	1.2162	660 N/mm ²	M 45	200	0.1 - 0.4	0.25 - 1.0	0.15 - 0.4	0.5 - 1.5	0.15 - 0.5	0.5 - 2.5	0.2 - 0.8	0.5 - 3.0
	1.2162	52 HRC	R 80	60							0.05 - 0.35	0.5 - 3.0
	1.2311	1080 N/mm ²	M 45	200	0.1 - 0.4	0.25 - 1.0	0.15 - 0.4	0.5 - 1.5	0.15 - 0.5	0.5 - 2.5	0.2 - 0.8	0.5 - 3.0
	1.2312	1080 N/mm ²	M 45	200	0.1 - 0.4	0.25 - 1.0	0.15 - 0.4	0.5 - 1.5	0.15 - 0.5	0.5 - 2.5	0.2 - 0.8	0.5 - 3.0
	1.2316	1010 N/mm ²	M 54	160			0.08 - 0.35	0.5 - 1.5	0.08 - 0.35	0.5 - 2.5	0.08 - 0.35	0.5 - 3.0
	1.2343	780 N/mm ²	M 45	160	0.1 - 0.4	0.25 - 1.0	0.15 - 0.4	0.5 - 1.5	0.15 - 0.5	0.5 - 2.5	0.2 - 0.8	0.5 - 3.0
	1.2343	52 HRC	R 80	60							0.05 - 0.35	0.5 - 3.0
	1.2379	780 N/mm ²	M 54	180			0.08 - 0.35	0.5 - 1.5	0.08 - 0.35	0.5 - 2.5	0.08 - 0.35	0.5 - 0.25
	1.2379	60 HRC	R 80	50							0.05 - 0.35	0.5 - 3.0
	1.2714HH	1350 N/mm ²	M 45	150	0.1 - 0.4	0.25 - 1.0	0.15 - 0.4	0.5 - 1.5	0.15 - 0.5	0.5 - 2.5	0.2 - 0.8	0.5 - 3.0
	1.2767	830 N/mm ²	M 45	180	0.1 - 0.4	0.25 - 1.0	0.15 - 0.4	0.5 - 1.5	0.15 - 0.5	0.5 - 2.5	0.2 - 0.8	0.5 - 3.0
	1.2767	52 HRC	R 80	60							0.05 - 0.35	0.5 - 3.0
	1.2842	775 N/mm ²	M 45	180	0.1 - 0.4	0.25 - 1.0	0.15 - 0.4	0.5 - 1.5	0.15 - 0.5	0.5 - 2.5	0.2 - 0.8	0.5 - 3.0
	1.2842	60 HRC	R 80	50							0.05 - 0.35	0.5 - 3.0
	3.3547	270 N/mm ²	F 20	1500	0.05 - 0.4	0.25 - 1.0	0.05 - 0.4	0.5 - 1.5	0.05 - 0.4	0.5 - 2.5	0.05 - 0.4	0.5 - 3.0
	3.4365	520 N/mm ²	F 20	1000	0.05 - 0.4	0.25 - 1.0	0.05 - 0.4	0.5 - 1.5	0.05 - 0.4	0.5 - 2.5	0.05 - 0.4	0.5 - 3.0

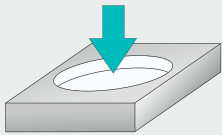
TECHNOLOGY DATA

Circular plunging



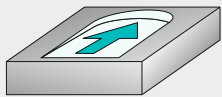
WZP 251 05				WZP 251 08				WZP 251 10				WZP 251 12			
d1	Dmax ¹	Dmin ²	aR	d1	Dmax ¹	Dmin ²	aR	d1	Dmax ¹	Dmin ²	aR	d1	Dmax ¹	Dmin ²	aR
10	15	15	2.5°												
12	19	16	2.1°												
16	17	24	1.5°	16	24	21	2.4°								
				20	32	27	1.9°	20	30	26	1.3°				
				25	42	37	1.5°	25	40	37	1.8°	25	38	31	2.2°
				32	56	51	1.2°	32	54	50	1.5°	32	52	46	1.7°
								40	70	64	1.1°	40	68	62	1.4°
								42	74	68	1.1°	42	70	64	1.2°
								50	90	84	0.9°	50	88	81	1.1°
								52	94	88	0.9°	52	92	86	1.0°
												63	114	107	0.9°

Axial plunging



WZP 251 05		WZP 251 08		WZP 251 10		WZP 251 12	
d1	t max	d1	t max	d1	t max	d1	t max
10	0.5						
12 - 16	1.3						
		16	0.5				
		20 - 32	2.7				
				20	0.2		
				25	0.4	25	1.0
				32	0.8	32	1.1
				40 - 52	1.5	40	1.2
						42 - 63	1.5

Ramping



WZP 251 05		WZP 251 08		WZP 251 10		WZP 251 12	
d1	aR	d1	aR	d1	aR	d1	aR
10	3.4°						
12	16.0°						
16	8.0°	16	2.5°				
		20	20.0°	20	1.3°		
		25	13.0°	25	2.0°	25	6.0°
		32	8.0°	32	3.0°	32	4.0°
				40	3.3°	40	2.8°
				52	3.1°	42	2.7°
				50	2.4°	50	2.6°
				52	2.2°	52	2.3°
						63	1.9°

1) Dmin: smallest hole diameter [mm]

2) Dmax: largest diameter for flat bottom surfaces [mm]