

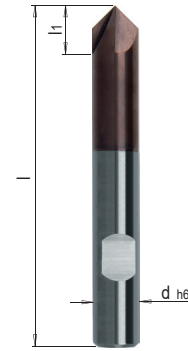


### PRODUCT DESCRIPTION

» For chamfering and deburring workpiece edges for hardened materials

### MATERIAL

» Carbide, TiAlSiN multi-layer coated



Z	I	l1	d	No.	EUR
4	50	2	4	WZF 15534/ 4	< >
4	57	3	6	WZF 15534/ 6	< >
4	63	4	8	WZF 15534/ 8	< >
4	72	5	10	WZF 15534/10	< >
4	83	6	12	WZF 15534/12	< >

### REFERENCE VALUES FOR CHAMFERING

WZF 15534	Material	Strength	Vc <sup>1</sup> m/min.	d				
				4	6	8	10	12
				fz (mm/z)				
	1.1730	640 N/mm <sup>2</sup>	190	0.029	0.037	0.050	0.062	0.074
	1.2083	780 N/mm <sup>2</sup>	140	0.024	0.030	0.040	0.050	0.060
	1.2083	52 HRC	50	0.016	0.020	0.027	0.034	0.040
	1.2085	1080 N/mm <sup>2</sup>	140	0.024	0.030	0.040	0.050	0.060
	1.2162	660 N/mm <sup>2</sup>	170	0.029	0.037	0.050	0.062	0.074
	1.2162	52 HRC	60	0.02	0.025	0.033	0.042	0.050
	1.2311	1080 N/mm <sup>2</sup>	160	0.026	0.033	0.044	0.055	0.066
	1.2312	1080 N/mm <sup>2</sup>	170	0.026	0.033	0.044	0.055	0.066
	1.2316	1010 N/mm <sup>2</sup>	140	0.024	0.030	0.040	0.050	0.060
	1.2343	780 N/mm <sup>2</sup>	170	0.029	0.037	0.050	0.062	0.074
	1.2343	52 HRC	60	0.02	0.025	0.033	0.042	0.050
	1.2379	60 HRC	50	0.016	0.020	0.027	0.034	0.040
	1.2714HH	1350 N/mm <sup>2</sup>	110	0.024	0.030	0.040	0.050	0.060
	1.2767	52 HRC	60	0.017	0.022	0.029	0.037	0.044
	1.2842	60 HRC	60	0.017	0.022	0.029	0.037	0.044
	1.3343	64 HRC	30	0.016	0.020	0.025	0.030	0.035
	1.3344 PM	64 HRC	30	0.016	0.020	0.025	0.030	0.035
	M V10 PM	62 HRC	35	0.016	0.020	0.025	0.030	0.035
	M W10 PM	65 HRC	25	0.016	0.020	0.025	0.030	0.035



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.