



PRODUCT DESCRIPTION

» High-performance drills with special flute profile

MATERIAL

» Carbide, TiAlN multi-layer coated

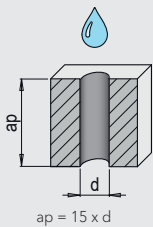


d3	l	l1	T max.	d	No.	EUR
4	62	25	22.9	1.4	WZB 10528/1,4	< >
4	62	27	24.8	1.5	WZB 10528/1,5	< >
4	62	29	26.6	1.6	WZB 10528/1,6	< >
4	70	31	28.5	1.7	WZB 10528/1,7	< >
4	70	32	29.3	1.8	WZB 10528/1,8	< >
4	70	34	31.2	1.9	WZB 10528/1,9	< >
4	70	36	33.0	2	WZB 10528/2,0	< >
4	78	38	34.9	2.1	WZB 10528/2,1	< >
4	78	40	36.7	2.2	WZB 10528/2,2	< >
4	78	42	38.6	2.3	WZB 10528/2,3	< >
4	78	44	40.4	2.4	WZB 10528/2,4	< >
4	78	45	41.3	2.5	WZB 10528/2,5	< >
4	87	47	43.1	2.6	WZB 10528/2,6	< >
4	87	48	44.0	2.7	WZB 10528/2,7	< >
4	87	50	45.8	2.8	WZB 10528/2,8	< >
4	87	52	47.7	2.9	WZB 10528/2,9	< >
4	87	54	49.5	3	WZB 10528/3,0	< >



REFERENCE VALUES FOR DRILLING

WZB 10528	Material	Strength	Vc ¹ m/min.	≤ d			
				1.5	2	2.5	3
				f (mm/u)			
1.1730	640 N/mm ²	100	0.051	0.072	0.095	0.12	
1.2083	780 N/mm ²	70	0.036	0.052	0.07	0.09	
1.2083	52 HRC	35	0.023	0.03	0.038	0.045	
1.2085	1080 N/mm ²	100	0.06	0.08	0.1	0.12	
1.2162	660 N/mm ²	100	0.06	0.08	0.09	0.1	
1.2162	52 HRC	35	0.023	0.03	0.038	0.045	
1.2311	1080 N/mm ²	80	0.045	0.06	0.075	0.09	
1.2312	1080 N/mm ²	80	0.045	0.06	0.075	0.09	
1.2316	1010 N/mm ²	70	0.036	0.052	0.07	0.09	
1.2343	780 N/mm ²	70	0.036	0.052	0.07	0.09	
1.2343	52 HRC	35	0.023	0.03	0.038	0.045	
1.2379	780 N/mm ²	70	0.022	0.031	0.042	0.054	
1.2714HH	1350 N/mm ²	70	0.022	0.031	0.042	0.054	
1.2767	830 N/mm ²	80	0.051	0.072	0.095	0.12	
1.2767	52 HRC	35	0.023	0.03	0.038	0.045	
1.2842	775 N/mm ²	80	0.051	0.072	0.095	0.12	
Steel	1400 N/mm ²	60	0.022	0.031	0.042	0.054	



ap = 15 x d

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1) Vc: cutting speed (m/min.)

2) f: feed per revolution (mm/rev.)

» Pilot hole ≥ 1 x d required

» Drill continuously without pecking cycle, with internal cooling only

i You can find further materials and cutting values in the cutting data calculator.