



PRODUCT DESCRIPTION

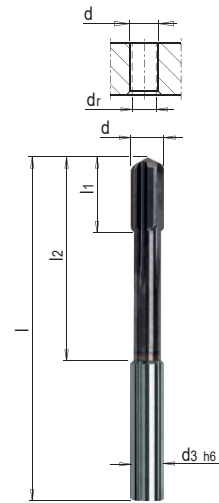
- » Tool tolerance 0/+0.005
- » For soft and hardened steel up to 65 HRC
- » Excellent performance and process reliability

MATERIAL

- » Carbide, TiAlN multi-layer coated



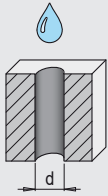
Z	d3	l	l1	l2	Cut	dr ¹⁾	d	No.	EUR
4	4	50	8	22	0.5	1.9	1.98	WZR 102522/ 1,98	< >
4	4	50	8	22	0.5	1.9	1.99	WZR 102522/ 1,99	< >
4	4	50	8	22	0.5	1.9	2	WZR 102522/ 2,00	< >
4	4	50	8	22	0.5	1.9	2.01	WZR 102522/ 2,01	< >
4	4	50	8	22	0.5	1.9	2.02	WZR 102522/ 2,02	< >
4	4	68	12	40	0.7	2.9	2.98	WZR 102522/ 2,98	< >
4	4	68	12	40	0.7	2.9	2.99	WZR 102522/ 2,99	< >
4	4	68	12	40	0.7	2.9	3	WZR 102522/ 3,00	< >
4	4	68	12	40	0.7	2.9	3.01	WZR 102522/ 3,01	< >
4	4	68	12	40	0.7	2.9	3.02	WZR 102522/ 3,02	< >
4	4	68	12	40	1.0	3.9	3.98	WZR 102522/ 3,98	< >
4	4	68	12	40	1.0	3.9	3.99	WZR 102522/ 3,99	< >
4	4	68	12	40	1.0	3.9	4	WZR 102522/ 4,00	< >
4	4	68	12	40	1.0	3.9	4.01	WZR 102522/ 4,01	< >
4	4	68	12	40	1.0	3.9	4.02	WZR 102522/ 4,02	< >
4	6	76	12	40	1.0	4.9	4.98	WZR 102522/ 4,98	< >
4	6	76	12	40	1.0	4.9	4.99	WZR 102522/ 4,99	< >
4	6	76	12	40	1.0	4.9	5	WZR 102522/ 5,00	< >
4	6	76	12	40	1.0	4.9	5.01	WZR 102522/ 5,01	< >
4	6	76	12	40	1.0	4.9	5.02	WZR 102522/ 5,02	< >
4	6	76	12	40	1.0	5.8	5.98	WZR 102522/ 5,98	< >
4	6	76	12	40	1.0	5.8	5.99	WZR 102522/ 5,99	< >
4	6	76	12	40	1.0	5.8	6	WZR 102522/ 6,00	< >
4	6	76	12	40	1.0	5.8	6.01	WZR 102522/ 6,01	< >
4	6	76	12	40	1.0	5.8	6.02	WZR 102522/ 6,02	< >
6	8	101	16	65	1.4	7.8	7.98	WZR 102522/ 7,98	< >
6	8	101	16	65	1.4	7.8	7.99	WZR 102522/ 7,99	< >
6	8	101	16	65	1.4	7.8	8	WZR 102522/ 8,00	< >
6	8	101	16	65	1.4	7.8	8.01	WZR 102522/ 8,01	< >
6	8	101	16	65	1.4	7.8	8.02	WZR 102522/ 8,02	< >
6	10	101	19	61	1.4	9.8	9.98	WZR 102522/ 9,98	< >
6	10	101	19	61	1.4	9.8	9.99	WZR 102522/ 9,99	< >
6	10	101	19	61	1.4	9.8	10	WZR 102522/10,00	< >
6	10	101	19	61	1.4	9.8	10.01	WZR 102522/10,01	< >
6	10	101	19	61	1.4	9.8	10.02	WZR 102522/10,02	< >
6	12	130	19	85	1.8	11.8	11.98	WZR 102522/11,98	< >
6	12	130	19	85	1.8	11.8	11.99	WZR 102522/11,99	< >
6	12	130	19	85	1.8	11.8	12	WZR 102522/12,00	< >
6	12	130	19	85	1.8	11.8	12.01	WZR 102522/12,01	< >
6	12	130	19	85	1.8	11.8	12.02	WZR 102522/12,02	< >



1) dr: pre-drill

REFERENCE VALUES FOR REAMING

WZR 102520 WZR 102522	Material	Strength	Vc ¹ m/min.	d							
				2	3	4	5	6	8	10	12
				f ² (mm/u)							
	1.1730	640 N/mm ²	200	0.55	0.6	0.7	0.8	1	1.3	1.5	1.7
	1.2083	780 N/mm ²	180	0.55	0.6	0.7	0.8	1	1.3	1.5	1.7
	1.2083	52 HRC	50	0.18	0.2	0.24	0.3	0.35	0.45	0.55	0.65
	1.2085	1080 N/mm ²	80	0.3	0.35	0.4	0.5	0.6	0.8	1	1
	1.2162	660 N/mm ²	200	0.5	0.6	0.7	0.8	1	1.3	1.5	1.7
	1.2162	52 HRC	50	0.18	0.2	0.24	0.3	0.35	0.45	0.55	0.65
	1.2311	1080 N/mm ²	160	0.3	0.35	0.4	0.5	0.6	0.8	0.9	1
	1.2312	1080 N/mm ²	160	0.3	0.35	0.4	0.5	0.6	0.8	0.9	1
	1.2316	1010 N/mm ²	160	0.3	0.35	0.4	0.5	0.6	0.8	0.9	1
	1.2343	780 N/mm ²	130	0.3	0.35	0.4	0.5	0.6	0.8	0.9	1
	1.2343	52 HRC	45	0.18	0.2	0.24	0.3	0.35	0.45	0.55	0.65
	1.2379	780 N/mm ²	180	0.5	0.6	0.7	0.8	1	1.3	1.5	1.7
	1.2379	60 HRC	30	0.1	0.12	0.16	0.18	0.2	0.24	0.28	0.3
	1.2714HH	1350 N/mm ²	80	0.18	0.2	0.24	0.3	0.35	0.45	0.55	0.65
	1.2767	830 N/mm ²	180	0.3	0.35	0.4	0.5	0.6	0.8	1	1
	1.2842	775 N/mm ²	180	0.5	0.6	0.7	0.5	1	1.3	1.5	1.7
	1.2842	60 HRC	30	0.1	0.12	0.16	0.18	0.2	0.24	0.28	0.3
	1.3343	64 HRC	25	0.1	0.1	0.14	0.16	0.18	0.22	0.26	0.28
	1.3344 PM	64 HRC	25	0.1	0.1	0.14	0.16	0.18	0.22	0.26	0.28
	M V10 PM	62 HRC	30	0.1	0.1	0.14	0.16	0.18	0.22	0.26	0.28
	M W10 PM	65 HRC	25	0.1	0.1	0.14	0.16	0.18	0.22	0.26	0.28
	Steel	1400 N/mm ²	120	0.5	0.6	0.7	0.8	1	1.3	1.5	1.7



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

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

» For clamping in hydraulic expansion chucks and shrink fit chucks from 52 HRC $dr = D - 0.1\text{mm}$

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