



PRODUCT DESCRIPTION

» High-performance drill with parabolic slot profile

MATERIAL

» HSS, nitrated

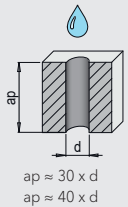


l	l1	d	No.	EUR
500	400	6	WZB 30219/ 6	< >
500	400	8	WZB 30219/ 8	< >
600	500	10	WZB 30219/10	< >
600	500	12	WZB 30219/12	< >



REFERENCE VALUES FOR DRILLING

WZB 30218 WZB 30219	Material	Strength	Vc ¹ m/min.	d			
				6	8	10	12
				f (mm/u)			
	1.1730	640 N/mm ²	14	0.085	0.105	0.130	0.140
	1.2083	780 N/mm ²	10	0.085	0.105	0.130	0.140
	1.2085	1080 N/mm ²	10	0.080	0.100	0.120	0.130
	1.2162	660 N/mm ²	12	0.085	0.105	0.130	0.140
	1.2311	1080 N/mm ²	10	0.063	0.080	0.100	0.100
	1.2312	1080 N/mm ²	12	0.063	0.080	0.100	0.100
	1.2316	1010 N/mm ²	8	0.063	0.080	0.100	0.100
	1.2343	780 N/mm ²	12	0.085	0.105	0.130	0.140
	1.2379	780 N/mm ²	10	0.085	0.105	0.130	0.140
	1.2767	830 N/mm ²	12	0.085	0.105	0.130	0.140
	1.2842	775 N/mm ²	12	0.085	0.105	0.130	0.140



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

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

» From 5 x d continue drilling with pecking cycle only

» Pilot hole $\geq 1 \times d$ recommended

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