



PRODUCT DESCRIPTION

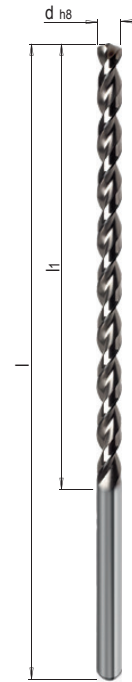
» High-performance drill with parabolic slot profile

MATERIAL

» HSS-E (5% Co), nitrated



l	l1	d	No.	EUR
150	100	3	WZB 30215/ 3	<>
165	115	3.5	WZB 30215/ 3,5	<>
175	120	4	WZB 30215/ 4	<>
185	125	4.5	WZB 30215/ 4,5	<>
195	135	5	WZB 30215/ 5	<>
205	140	5.5	WZB 30215/ 5,5	<>
205	140	6	WZB 30215/ 6	<>
215	150	6.5	WZB 30215/ 6,5	<>
225	155	7	WZB 30215/ 7	<>
225	155	7.5	WZB 30215/ 7,5	<>
240	165	8	WZB 30215/ 8	<>
240	165	8.5	WZB 30215/ 8,5	<>
250	175	9	WZB 30215/ 9	<>
250	175	9.5	WZB 30215/ 9,5	<>
265	185	10	WZB 30215/10	<>



REFERENCE VALUES FOR DRILLING

WZB 30215 WZB 30217	Material	Strength	Vc ¹ m/min.	≤ d					
				3	4	5	6	8	10
				f ² (mm/u)					
	1.1730	640 N/mm ²	14	0.050	0.060	0.065	0.080	0.100	0.120
	1.2083	780 N/mm ²	10	0.050	0.060	0.065	0.080	0.100	0.120
	1.2085	1080 N/mm ²	10	0.040	0.045	0.050	0.063	0.080	0.100
	1.2162	660 N/mm ²	12	0.050	0.060	0.065	0.080	0.100	0.120
	1.2311	1080 N/mm ²	10	0.040	0.045	0.050	0.063	0.080	0.100
	1.2312	1080 N/mm ²	10	0.040	0.045	0.050	0.063	0.080	0.100
	1.2316	1010 N/mm ²	8	0.040	0.045	0.050	0.063	0.080	0.100
	1.2343	780 N/mm ²	12	0.050	0.060	0.065	0.080	0.100	0.120
	1.2379	780 N/mm ²	10	0.050	0.060	0.065	0.080	0.100	0.120
	1.2767	830 N/mm ²	12	0.050	0.060	0.065	0.080	0.100	0.120
	1.2842	775 N/mm ²	12	0.050	0.060	0.065	0.080	0.100	0.120

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 ≥ 1 x d recommended

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