



PRODUCT DESCRIPTION

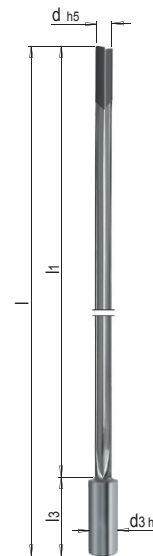
» Soldered carbide tip

MATERIAL

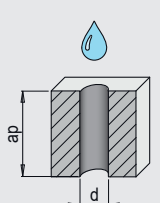
» TiCN coated



d3	l	l1	l3	d	No.	EUR
16	210	162	48	6	WZB 50823/ 6	< >
16	260	212	48	8	WZB 50823/ 8	< >
20	320	270	50	10	WZB 50823/10	< >
20	370	320	50	12	WZB 50823/12	< >




REFERENCE VALUES FOR DEEP-HOLE DRILLING

WZB 50823 WZB 50825 WZB 50827	Material	Strength	Vc ¹ m/min.	d			
				6	8	10	12
				f ² (mm/u)			
	1.1730	640 N/mm ²	75	0.010	0.014	0.022	0.028
	1.2083	780 N/mm ²	75	0.007	0.009	0.014	0.016
	1.2085	1080 N/mm ²	65	0.007	0.009	0.014	0.016
	1.2162	660 N/mm ²	75	0.007	0.009	0.014	0.016
	1.2311	1080 N/mm ²	65	0.007	0.009	0.014	0.016
	1.2312	1080 N/mm ²	65	0.007	0.009	0.014	0.016
	1.2316	1010 N/mm ²	60	0.007	0.009	0.014	0.016
	1.2343	780 N/mm ²	75	0.007	0.009	0.014	0.016
	1.2379	780 N/mm ²	75	0.007	0.009	0.014	0.016
	1.2714HH	1350 N/mm ²	55	0.007	0.009	0.014	0.016
	1.2767	830 N/mm ²	75	0.007	0.009	0.014	0.016
	1.2842	775 N/mm ²	75	0.007	0.009	0.014	0.016





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

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

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

- » Pilot hole $\geq 1 \times d$ required
- » Insert the drill with ~ 300 rev/min into the pilot hole (Never operate the deep-hole drill at a higher speed without guide!)
- » Switch on the internal cooling supply
- » Drill continuously at machining speed without pecking cycle

COOLANT VALUES

-  max. coolant pressure
-  min. coolant pressure
-  max. coolant quantity
-  min. coolant quantity

Grease content of the emulsion is 10-12%

