

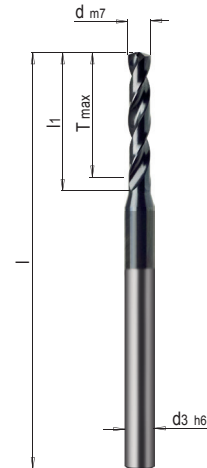


PRODUCT DESCRIPTION

- » High-performance drills with special flute profile
- » Usable as pilot drill

MATERIAL

- » Carbide, TiAlN multi-layer coated

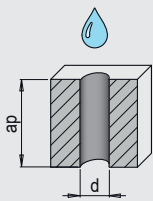


d3	l	l1	T max.	d	No.	EUR
3	47	4.4	3.3	0.5	WZB 10525/0,5	<>
3	47	4.8	3.9	0.6	WZB 10525/0,6	<>
3	47	5.6	4.6	0.7	WZB 10525/0,7	<>
3	47	6.4	5.2	0.8	WZB 10525/0,8	<>
3	47	7.2	5.9	0.9	WZB 10525/0,9	<>
3	47	8	6.5	1.0	WZB 10525/1,0	<>
3	47	8.8	7.2	1.1	WZB 10525/1,1	<>
3	52	10.8	9.0	1.2	WZB 10525/1,2	<>
3	52	11.7	9.8	1.3	WZB 10525/1,3	<>
3	52	12.6	10.5	1.4	WZB 10525/1,4	<>
3	52	13.5	11.3	1.5	WZB 10525/1,5	<>
3	52	14.4	12.0	1.6	WZB 10525/1,6	<>
3	52	15.3	12.8	1.7	WZB 10525/1,7	<>

d3	l	l1	T max.	d	No.	EUR
3	52	16.2	13.5	1.8	WZB 10525/1,8	<>
3	52	17.1	14.3	1.9	WZB 10525/1,9	<>
4	63	18	15.0	2	WZB 10525/2,0	<>
4	63	18.9	15.8	2.1	WZB 10525/2,1	<>
4	59	19.8	16.5	2.2	WZB 10525/2,2	<>
4	63	20.7	17.3	2.3	WZB 10525/2,3	<>
4	63	21.6	18.0	2.4	WZB 10525/2,4	<>
4	63	22.5	18.8	2.5	WZB 10525/2,5	<>
4	67	23.4	19.5	2.6	WZB 10525/2,6	<>
4	67	24.3	20.3	2.7	WZB 10525/2,7	<>
4	67	25.2	21.0	2.8	WZB 10525/2,8	<>
4	67	26.1	21.8	2.9	WZB 10525/2,9	<>
4	67	27	22.5	3	WZB 10525/3,0	<>

REFERENCE VALUES FOR DRILLING

WZB 10525	Material	Strength	Vc ¹ m/min.	≤ d					
				0.5	1	1.5	2	2.5	3
				f (mm/u)					
1.1730	640 N/mm ²	80	0.03	0.06	0.09	0.12	0.15	0.18	
1.2083	780 N/mm ²	50	0.012	0.022	0.036	0.052	0.07	0.09	
1.2083	52 HRC	15	0.005	0.01	0.015	0.02	0.025	0.03	
1.2085	1080 N/mm ²	80	0.02	0.04	0.06	0.08	0.1	0.12	
1.2162	660 N/mm ²	80	0.02	0.04	0.06	0.08	0.1	0.12	
1.2162	52 HRC	15	0.002	0.01	0.015	0.02	0.025	0.03	
12311	1080 N/mm ²	60	0.015	0.03	0.045	0.06	0.075	0.09	
1.2312	1080 N/mm ²	60	0.015	0.03	0.045	0.06	0.075	0.09	
1.2316	1010 N/mm ²	50	0.012	0.022	0.036	0.052	0.07	0.09	
1.2343	780 N/mm ²	50	0.012	0.022	0.036	0.052	0.07	0.09	
1.2343	52 HRC	15	0.005	0.01	0.015	0.02	0.025	0.03	
1.2379	780 N/mm ²	50	0.012	0.022	0.036	0.052	0.07	0.09	
1.2714HH	1350 N/mm ²	50	0.012	0.022	0.036	0.052	0.07	0.09	
1.2767	830 N/mm ²	50	0.012	0.022	0.036	0.052	0.07	0.09	
1.2767	52 HRC	15	0.005	0.01	0.015	0.02	0.025	0.03	
1.2842	775 N/mm ²	50	0.012	0.022	0.036	0.052	0.07	0.09	
Steel	1400 N/mm ²	40	0.012	0.022	0.036	0.052	0.07	0.09	



ap = 7 x d

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

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

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