

< 1.400
N/mm²



PRODUCT DESCRIPTION

» For drilling the holes required for inserting the E 2030 Marking chips for cooling connections

MATERIAL

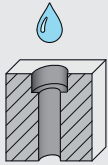
» Carbide, TiCN coated



d3	l1	d2	d1	l	d	No.	EUR
12	4	17	8	72	15	WZB 119225/15	< >
12	4	20	10	75	18	WZB 119225/18	< >

REFERENCE VALUES FOR DRILLING

WZB 119225	Material	Strength	Vc ¹ m/min.	d	
				15	18
				f ² (mm/u)	
	1.1730	640 N/mm ²	50	0.140	0.140
	1.2083	780 N/mm ²	40	0.120	0.120
	1.2085	1080 N/mm ²	45	0.140	0.140
	1.2162	660 N/mm ²	45	0.140	0.140
	1.2311	1080 N/mm ²	45	0.140	0.140
	1.2312	1080 N/mm ²	45	0.140	0.140
	1.2316	1010 N/mm ²	40	0.140	0.140
	1.2343	780 N/mm ²	45	0.140	0.140
	1.2379	780 N/mm ²	45	0.140	0.140
	1.2714HH	1350 N/mm ²	30	0.080	0.080
	1.2767	830 N/mm ²	45	0.140	0.140
	1.2842	775 N/mm ²	45	0.140	0.140
	Steel	1400 N/mm ²	30	0.080	0.080



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.