



PRODUCT DESCRIPTION

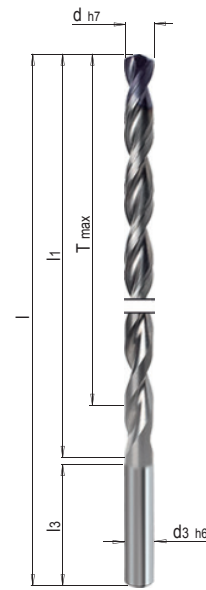
» High-performance drill with parabolic slot profile

MATERIAL

» Carbide, TiAlN coated

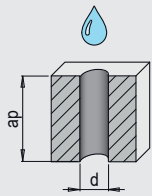


d3	l	l1	l3	T max.	d	No.	EUR
6	140	100	36	96	3	WZB 10233/ 3	< >
6	176	136	36	131	3.5	WZB 10233/ 3,5	< >
6	176	136	36	130	4	WZB 10233/ 4	< >
6	208	168	36	161	4.5	WZB 10233/ 4,5	< >
6	208	168	36	161	5	WZB 10233/ 5	< >
6	240	200	36	191	6	WZB 10233/ 6	< >
8	272	232	36	222	6.5	WZB 10233/ 6,5	< >
8	272	232	36	222	7	WZB 10233/ 7	< >
8	303	263	36	251	8	WZB 10233/ 8	< >
10	371	327	40	312	10	WZB 10233/10	< >



REFERENCE VALUES FOR DRILLING

WZB 10233	Material	Strength	Vc ¹ m/min.	d					
				3	4	5	6	8	10
				f ² (mm/u)					
	1.1730	640 N/mm ²	110	0.080	0.100	0.120	0.140	0.170	0.200
	1.2083	780 N/mm ²	80	0.063	0.008	0.08	0.125	0.125	0.16
	1.2085	1080 N/mm ²	70	0.060	0.070	0.070	0.080	0.110	0.140
	1.2162	660 N/mm ²	80	0.100	0.125	0.125	0.160	0.200	0.250
	1.2311	1080 N/mm ²	70	0.055	0.075	0.095	0.110	0.140	0.170
	1.2312	1080 N/mm ²	70	0.055	0.075	0.095	0.110	0.140	0.170
	1.2316	1010 N/mm ²	70	0.055	0.075	0.095	0.110	0.170	0.170
	1.2343	780 N/mm ²	80	0.070	0.085	0.085	0.120	0.140	0.175
	1.2379	780 N/mm ²	80	0.063	0.080	0.080	0.100	0.015	0.160
	1.2714HH	1350 N/mm ²	55	0.063	0.080	0.080	0.100	0.125	0.160
	1.2767	830 N/mm ²	70	0.063	0.080	0.080	0.100	0.125	0.160
	1.2842	775 N/mm ²	80	0.070	0.070	0.080	0.110	0.140	0.170
	Steel	1400 N/mm ²	55	0.063	0.080	0.080	0.100	0.125	0.160



ap = 30 x d

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

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

- » 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

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