

< 1.100
N/mm²

XL
length

DIN
1869.3



PRODUCT DESCRIPTION

» High-performance drill with parabolic slot profile

MATERIAL

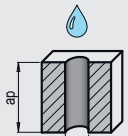
» HSS-E (5% Co), nitrated

l	l1	d	No.	EUR
330	225	6	WZB 30218/ 6	< >
390	265	8	WZB 30218/ 8	< >
430	295	10	WZB 30218/10	< >
455	310	11.5	WZB 30218/11,5	< >
480	330	12	WZB 30218/12	< >



REFERENCE VALUES FOR DRILLING

WZB 30218
WZB 30219



$a_p \approx 30 \times d$
 $a_p \approx 40 \times d$

Material	Strength	Vc ¹ m/min.	d			
			6	8	10	12
			f (mm/u)			
1.1730	640 N/mm ²	14	0.085	0.105	0.130	0.140
1.2083	780 N/mm ²	10	0.085	0.105	0.130	0.140
1.2085	1080 N/mm ²	10	0.080	0.100	0.120	0.130
1.2162	660 N/mm ²	12	0.085	0.105	0.130	0.140
1.2311	1080 N/mm ²	10	0.063	0.080	0.100	0.100
1.2312	1080 N/mm ²	12	0.063	0.080	0.100	0.100
1.2316	1010 N/mm ²	8	0.063	0.080	0.100	0.100
1.2343	780 N/mm ²	12	0.085	0.105	0.130	0.140
1.2379	780 N/mm ²	10	0.085	0.105	0.130	0.140
1.2767	830 N/mm ²	12	0.085	0.105	0.130	0.140
1.2842	775 N/mm ²	12	0.085	0.105	0.130	0.140

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 $\geq 1 \times d$ recommended

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