



### PRODUCT DESCRIPTION

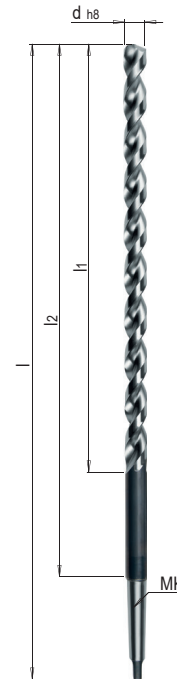
- » High-performance drill with parabolic slot profile
- » For the E210x Baffles

### MATERIAL

- » HSS-E (5% Co), nitrated



| MK   | l   | l1  | l2  | d    | No.            | EUR |
|------|-----|-----|-----|------|----------------|-----|
| MK 1 | 375 | 250 | 313 | 11.5 | WZB 35217/11,5 | < > |
| MK 1 | 410 | 275 | 348 | 14   | WZB 35217/14   | < > |
| MK 2 | 425 | 275 | 350 | 15   | WZB 35217/15   | < > |
| MK 2 | 445 | 295 | 370 | 16   | WZB 35217/16   | < > |
| MK 2 | 465 | 310 | 390 | 18   | WZB 35217/18   | < > |
| MK 2 | 465 | 310 | 390 | 18.5 | WZB 35217/18,5 | < > |
| MK 2 | 490 | 325 | 415 | 20   | WZB 35217/20   | < > |



### REFERENCE VALUES FOR DRILLING

| WZB 35215<br>WZB 35217             | Material | Strength               | Vc <sup>1</sup><br>m/min. | d                     |       |       |       |       |
|------------------------------------|----------|------------------------|---------------------------|-----------------------|-------|-------|-------|-------|
|                                    |          |                        |                           | 12                    | 14    | 16    | 18    | 20    |
|                                    |          |                        |                           | f <sup>2</sup> (mm/u) |       |       |       |       |
| <p>ap ≈ 20 x d<br/>ap ≈ 25 x d</p> | 1.1730   | 640 N/mm <sup>2</sup>  | 30                        | 0.170                 | 0.2   | 0.230 | 0.250 | 0.250 |
|                                    | 1.2083   | 780 N/mm <sup>2</sup>  | 11                        | 0.125                 | 0.160 | 0.16  | 0.200 | 0.230 |
|                                    | 1.2085   | 1080 N/mm <sup>2</sup> | 8                         | 0.100                 | 0.125 | 0.125 | 0.160 | 0.160 |
|                                    | 1.2162   | 660 N/mm <sup>2</sup>  | 11                        | 0.125                 | 0.160 | 0.16  | 0.200 | 0.230 |
|                                    | 1.2311   | 1080 N/mm <sup>2</sup> | 8                         | 0.100                 | 0.125 | 0.125 | 0.160 | 0.160 |
|                                    | 1.2312   | 1080 N/mm <sup>2</sup> | 8                         | 0.100                 | 0.125 | 0.125 | 0.160 | 0.160 |
|                                    | 1.2316   | 1010 N/mm <sup>2</sup> | 10                        | 0.100                 | 0.125 | 0.125 | 0.160 | 0.160 |
|                                    | 1.2343   | 780 N/mm <sup>2</sup>  | 11                        | 0.125                 | 0.160 | 0.160 | 0.200 | 0.200 |
|                                    | 1.2379   | 780 N/mm <sup>2</sup>  | 11                        | 0.125                 | 0.160 | 0.160 | 0.200 | 0.200 |
|                                    | 1.2767   | 830 N/mm <sup>2</sup>  | 11                        | 0.125                 | 0.160 | 0.160 | 0.200 | 0.200 |
|                                    | 1.2842   | 775 N/mm <sup>2</sup>  | 11                        | 0.125                 | 0.160 | 0.160 | 0.200 | 0.200 |

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 ≥ 1 x d recommended

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