



### PRODUCT DESCRIPTION

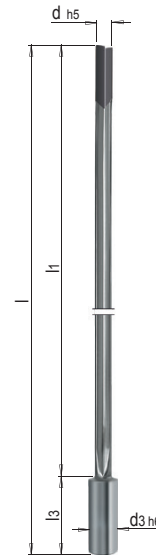
» Soldered carbide tip

### MATERIAL

» TiCN coated

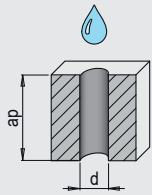


d3	l	l1	l3	d	No.	EUR
16	320	272	48	6	WZB 50827/ 6	< >
16	420	372	48	8	WZB 50827/ 8	< >
20	510	460	50	10	WZB 50827/10	< >
20	600	550	50	12	WZB 50827/12	< >



### REFERENCE VALUES FOR DEEP-HOLE DRILLING

**WZB 50823**  
**WZB 50825**  
**WZB 50827**



ap = 20 x d  
ap = 30 x d  
ap = 40 x d

Material	Strength	Vc <sup>1</sup> m/min.	d			
			6	8	10	12
			f <sup>2</sup> (mm/u)			
1.1730	640 N/mm <sup>2</sup>	75	0.010	0.014	0.022	0.028
1.2083	780 N/mm <sup>2</sup>	75	0.007	0.009	0.014	0.016
1.2085	1080 N/mm <sup>2</sup>	65	0.007	0.009	0.014	0.016
1.2162	660 N/mm <sup>2</sup>	75	0.007	0.009	0.014	0.016
1.2311	1080 N/mm <sup>2</sup>	65	0.007	0.009	0.014	0.016
1.2312	1080 N/mm <sup>2</sup>	65	0.007	0.009	0.014	0.016
1.2316	1010 N/mm <sup>2</sup>	60	0.007	0.009	0.014	0.016
1.2343	780 N/mm <sup>2</sup>	75	0.007	0.009	0.014	0.016
1.2379	780 N/mm <sup>2</sup>	75	0.007	0.009	0.014	0.016
1.2714HH	1350 N/mm <sup>2</sup>	55	0.007	0.009	0.014	0.016
1.2767	830 N/mm <sup>2</sup>	75	0.007	0.009	0.014	0.016
1.2842	775 N/mm <sup>2</sup>	75	0.007	0.009	0.014	0.016

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.

- » Pilot hole  $\geq 1 \times d$  required
- » Insert the drill with  $\sim 300$  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

### COOLANT VALUES

- max. coolant pressure
- min. coolant pressure
- max. coolant quantity
- min. coolant quantity

Grease content of the emulsion is 10-12%

