

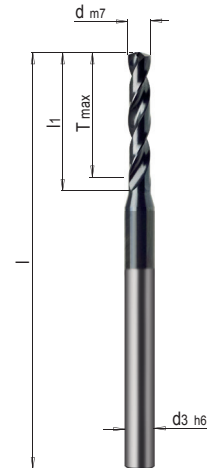


### PRODUCT DESCRIPTION

- » High-performance drills with special flute profile
- » Usable as pilot drill

### MATERIAL

- » Carbide, TiAlN multi-layer coated

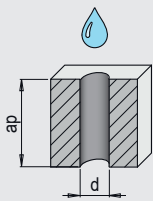


d3	l	l1	T max.	d	No.	EUR
3	47	6	4.5	1	WZB 10524/1,0	<>
3	47	6.6	5.0	1.1	WZB 10524/1,1	<>
3	47	9	6.8	1.5	WZB 10524/1,5	<>
3	47	9.6	7.2	1.6	WZB 10524/1,6	<>
3	47	10.2	7.7	1.7	WZB 10524/1,7	<>
3	52	10.8	8.1	1.8	WZB 10524/1,8	<>
3	52	11.4	8.6	1.9	WZB 10524/1,9	<>
4	59	11.7	8.7	2	WZB 10524/2,0	<>
4	59	12	8.9	2.1	WZB 10524/2,1	<>

d3	l	l1	T max.	d	No.	EUR
4	59	13.2	9.8	2.3	WZB 10524/2,3	<>
4	59	13.8	10.2	2.4	WZB 10524/2,4	<>
4	59	14.4	10.7	2.5	WZB 10524/2,5	<>
4	59	15.6	11.7	2.6	WZB 10524/2,6	<>
4	59	16.2	12.2	2.7	WZB 10524/2,7	<>
4	59	16.8	12.7	2.8	WZB 10524/2,8	<>
4	59	17.4	13.1	2.9	WZB 10524/2,9	<>
4	59	18	13.5	3	WZB 10524/3,0	<>

### REFERENCE VALUES FOR DRILLING

WZB 10524	Material	Strength	Vc <sup>1</sup> m/min.	≤ d					
				0,5	1	1,5	2	2,5	3
				f (mm/u)					
1.1730	640 N/mm <sup>2</sup>	80	0.03	0.06	0.09	0.12	0.15	0.18	
1.2083	780 N/mm <sup>2</sup>	50	0.012	0.022	0.036	0.052	0.07	0.09	
1.2083	52 HRC	15	0.005	0.01	0.015	0.02	0.025	0.03	
1.2085	1080 N/mm <sup>2</sup>	80	0.02	0.04	0.06	0.08	0.1	0.12	
1.2162	660 N/mm <sup>2</sup>	80	0.02	0.04	0.06	0.08	0.1	0.12	
1.2162	52 HRC	15	0.002	0.01	0.015	0.02	0.025	0.03	
1.2311	1080 N/mm <sup>2</sup>	60	0.015	0.03	0.045	0.06	0.075	0.09	
1.2312	1080 N/mm <sup>2</sup>	60	0.015	0.03	0.045	0.06	0.075	0.09	
1.2316	1010 N/mm <sup>2</sup>	50	0.012	0.022	0.036	0.052	0.07	0.09	
1.2343	780 N/mm <sup>2</sup>	50	0.012	0.022	0.036	0.052	0.07	0.09	
1.2343	52 HRC	15	0.005	0.01	0.015	0.02	0.025	0.03	
1.2379	780 N/mm <sup>2</sup>	50	0.012	0.022	0.036	0.052	0.07	0.09	
1.2714HH	1350 N/mm <sup>2</sup>	50	0.012	0.022	0.036	0.052	0.07	0.09	
1.2767	830 N/mm <sup>2</sup>	50	0.012	0.022	0.036	0.052	0.07	0.09	
1.2767	52 HRC	15	0.005	0.01	0.015	0.02	0.025	0.03	
1.2842	775 N/mm <sup>2</sup>	50	0.012	0.022	0.036	0.052	0.07	0.09	
Steel	1400 N/mm <sup>2</sup>	40	0.012	0.022	0.036	0.052	0.07	0.09	



ap = 4 x d

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.