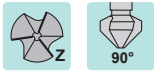


< 1.100
N/mm²



PRODUCT DESCRIPTION

» For deburring and countersinking

MATERIAL

» HSS

| Content | No. | EUR |
|---------------------------------------|-----------------------|-----|
| d1 = 6.3, 8.3, 10.4, 12.4, 16.5, 20.5 | WZB 31722/Set6,3-20,5 | < > |



HSS 90° COUNTERSINK

WZB 31722

< 1.100
N/mm²



PRODUCT DESCRIPTION

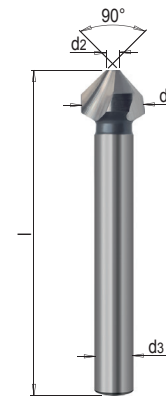
» For deburring and countersinking

MATERIAL

» HSS

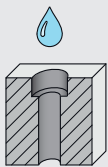


| Z | d3 | d2 | l | d1 | No. | EUR |
|---|----|-----|----|------|----------------|-----|
| 3 | 4 | 1.3 | 40 | 4.3 | WZB 31722/ 4,3 | < > |
| 3 | 5 | 1.5 | 45 | 6.3 | WZB 31722/ 6,3 | < > |
| 3 | 6 | 2 | 50 | 8.3 | WZB 31722/ 8,3 | < > |
| 3 | 6 | 2.5 | 50 | 10.4 | WZB 31722/10,4 | < > |
| 3 | 8 | 2.8 | 56 | 12.4 | WZB 31722/12,4 | < > |
| 3 | 10 | 3.2 | 60 | 16.5 | WZB 31722/16,5 | < > |
| 3 | 10 | 3.5 | 63 | 20.5 | WZB 31722/20,5 | < > |
| 3 | 10 | 3.8 | 67 | 25 | WZB 31722/25 | < > |



REFERENCE VALUES FOR COUNTERSINKING

WZB 31722
WZB 317226
WZB 318120
WZB 318121
WZB 318122



| Material | Strength | Vc ¹ m/min. | ≤ d | | | | | | | |
|----------|------------------------|---------------------------|-----------------------|-------|-------|-------|-------|-------|-------|-------|
| | | | 8 | 10 | 15 | 20 | 24 | 26 | 33 | 40 |
| | | | f ² (mm/u) | | | | | | | |
| 1.1730 | 640 N/mm ² | 20 | 0.125 | 0.150 | 0.160 | 0.180 | 0.200 | 0.225 | 0.250 | 0.250 |
| 1.2083 | 780 N/mm ² | 11 | 0.100 | 0.120 | 0.130 | 0.150 | 0.160 | 0.180 | 0.200 | 0.200 |
| 1.2085 | 1080 N/mm ² | 9 | 0.095 | 0.115 | 0.125 | 0.140 | 0.150 | 0.170 | 0.190 | 0.190 |
| 1.2162 | 660 N/mm ² | 11 | 0.100 | 0.120 | 0.130 | 0.150 | 0.160 | 0.180 | 0.200 | 0.200 |
| 1.2311 | 1080 N/mm ² | 9 | 0.095 | 0.115 | 0.125 | 0.140 | 0.150 | 0.170 | 0.190 | 0.190 |
| 1.2312 | 1080 N/mm ² | 9 | 0.095 | 0.115 | 0.125 | 0.140 | 0.150 | 0.170 | 0.190 | 0.190 |
| 1.2316 | 1010 N/mm ² | 9 | 0.095 | 0.115 | 0.125 | 0.140 | 0.150 | 0.170 | 0.190 | 0.190 |
| 1.2343 | 780 N/mm ² | 11 | 0.100 | 0.120 | 0.130 | 0.150 | 0.160 | 0.180 | 0.200 | 0.200 |
| 1.2379 | 780 N/mm ² | 8 | 0.100 | 0.120 | 0.130 | 0.150 | 0.160 | 0.180 | 0.200 | 0.200 |
| 1.2767 | 830 N/mm ² | 11 | 0.100 | 0.120 | 0.130 | 0.150 | 0.160 | 0.180 | 0.200 | 0.200 |
| 1.2842 | 775 N/mm ² | 11 | 0.100 | 0.120 | 0.130 | 0.150 | 0.160 | 0.180 | 0.200 | 0.200 |

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.