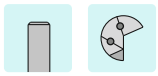
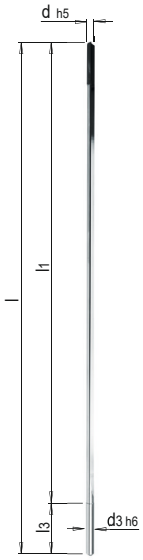
meusburger

CARBIDE SINGLE-FLUTED DEEP HOLE DRILL, 75XD — WZB 50838

< 1.600 N/mm² | 75 x d | Ø 1-4





PRODUCT DESCRIPTION

» Carbide shank

MATERIAL

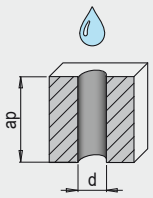
» TiAlN coated

P	M	K	N	S	H
●	●	●	○	○	○

d3	l	l1	l3	d	No.	EUR
3	115	82	28	**1**	WZB 50838/ 1	< >
4	195	165	28	**2**	WZB 50838/ 2	< >
4	255	220	28	**2.5**	WZB 50838/ 2,5	< >
6	290	247	36	**3**	WZB 50838/ 3	< >
6	320	280	36	**3.5**	WZB 50838/ 3,5	< >
6	360	320	36	**4**	WZB 50838/ 4	< >

REFERENCE VALUES FOR DEEP-HOLE DRILLING

WZB 50838



ap = 75 x d

Material	Strength	Vc[1] m/min.	d 1	d 2	d 3	d 4
			f[2] (mm/u)			
1.1730	640 N/mm²	75	0,003	0,006	0,009	0,012
1.2083	780 N/mm²	75	0,002	0,004	0,006	0,008
1.2085	1080 N/mm²	65	0,002	0,004	0,006	0,008
1.2162	660 N/mm²	75	0,002	0,004	0,006	0,008
1.2311	1080 N/mm²	65	0,002	0,004	0,006	0,008
1.2312	1080 N/mm²	65	0,002	0,004	0,006	0,008
1.2316	1010 N/mm²	60	0,002	0,004	0,006	0,008
1.2343	780 N/mm²	75	0,002	0,004	0,006	0,008
1.2379	780 N/mm²	75	0,002	0,004	0,006	0,008
1.2714 HH	1350 N/mm²	55	0,002	0,004	0,006	0,008
1.2767	830 N/mm²	75	0,002	0,004	0,006	0,008
1.2842	775 N/mm²	75	0,002	0,004	0,006	0,008
1.4301	660 N/mm²	45	0,004	0,008	0,012	0,016
1.4305	620 N/mm²	55	0,004	0,008	0,012	0,016
1.4571	600 N/mm²	45	0,004	0,008	0,012	0,016

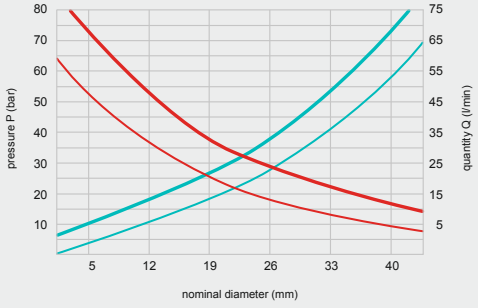
1) Vc: cutting speed (m/min.) 2) f: feed per revolution (mm/rev.)

Further materials and cutting values can be found in the cutting data calculator.

» Pilot drill ≥ 1xd required
» Entry into pilot hole at ~300 rpm (never bring deep hole drill to a higher rotational speed without guiding)
» Switch on the interal cooling supply
» Drill continuously at machining speed without pecking cycle

COOLANT VALUES

— max. coolant pressure
— min. coolant pressure
— max. coolant quantity
— min. coolant quantity



Set the grease content of the emulsion to 10–12%

Meusburger Georg GmbH & Co KG | Kesselstr. 42 | 6960 Wolfurt | Austria
T +43 5574 6706-0 | sales@meusburger.com | www.meusburger.com