

## 6. Drilling

### 6.2 Through-hole drilling

#### 6.2.1 Through-hole drills



#### Shank 8 mm

##### Application:

For drilling through-holes, especially in cabinetry. Suitable for machines where spindle guidance of the drilling bit is insufficient.

##### Machine:

Point-to-point drilling machines, through-feed drilling machines, CNC machining centres, hinge boring machines, multi-spindle units

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (chipboard, MDF, HF etc.), untreated, plastic-coated, veneered etc., laminated woods (plywood etc.), elastomers



##### Technical information:

Can be combined with loose countersink WB 701-0-03. Countersink fixed on flute. Continuously adjustable boring and countersink depth. Good return stroke guidance for tear-free hole edges.

##### GL 67 mm, with heel, Z 2

WB 101-0-11

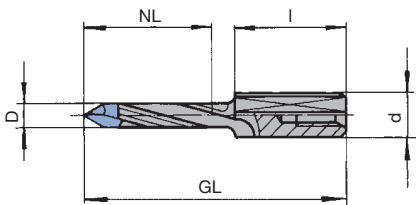
| D<br>mm | GL<br>mm | NL<br>mm | S<br>mm | ID<br>LL | ID<br>RL |
|---------|----------|----------|---------|----------|----------|
| 5       | 67       | 40       | 8x20    | 042654   | 042655   |
| 8       | 67       | 40       | 8x20    | 042656   | 042657   |

**RPM:**  $n = 3000 - 9000 \text{ min}^{-1}$

For diameters below 5 mm use type WB 101-0-04.

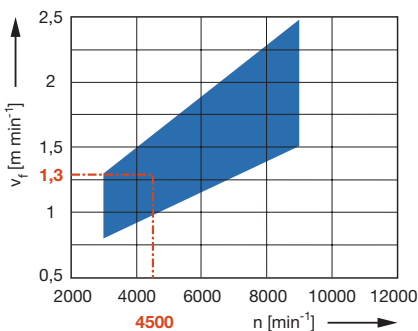
##### Spare parts:

| BEZ         | ABM<br>mm | BEM               | ID     |
|-------------|-----------|-------------------|--------|
| Allen screw | M5x10     | Length adjustment | 005802 |



Design with heel

Feed speed  $v_f$  depending on the spindle RPM  $n$



##### Workpiece material:

Chipboard plastic coated

##### Working step:

Boring

##### Correction factor for $v_f$ :

Veneered = 0.8

MDF = 0.7

Chipboard, untreated = 1.3

## 6. Drilling

### 6.2 Through-hole drilling

#### 6.2.1 Through-hole drills



#### Shank 10 mm

##### Application:

For drilling through-holes, especially in cabinetry.

##### Machine:

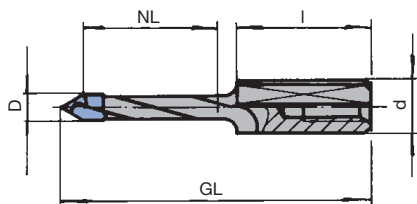
Point-to-point drilling machines, through-feed drilling machines, CNC machining centres, hinge boring machines, multi-spindle units

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (chipboard, MDF, HF etc.), untreated, plastic-coated, veneered etc., laminated woods (plywood etc.), elastomers

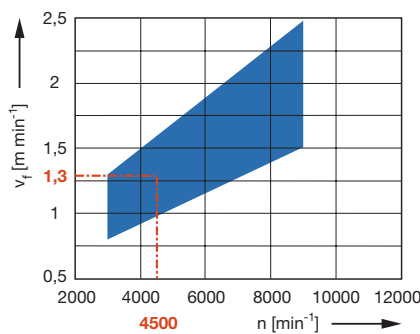
##### Technical information:

Can be combined with loose countersink WB 701-0-02. Countersinks fixed on flute. Recessed flute for minimum friction and feed forces.



Design without heel

Feed speed  $v_f$  depending on the spindle RPM  $n$



##### Workpiece material:

Chipboard plastic coated

##### Working step:

Boring

##### Correction factor for $v_f$ :

Veneered = 0.8

MDF = 0.7

Chipboard, untreated = 1.3

#### GL 57.5 mm, without heel, Z 2

WB 101-0-02

| D<br>mm | GL<br>mm | NL<br>mm | S<br>mm | ID<br>LL | ID<br>RL |
|---------|----------|----------|---------|----------|----------|
| 5       | 57,5     | 25       | 10x24   | 034000   | 034001 ● |
| 5,1     | 57,5     | 25       | 10x24   | 034004   | 034005 ● |
| 6       | 57,5     | 25       | 10x24   | 034008   | 034009 ● |
| 8       | 57,5     | 25       | 10x24   | 034002   | 034003 ● |

RPM:  $n = 3000 - 9000 \text{ min}^{-1}$

For diameters below 5 mm use type WB 101-0-04.

#### GL 70 mm, without guide heel, Z 2

WB 101-0-07

| D<br>mm | GL<br>mm | NL<br>mm | S<br>mm | ID<br>LL | ID<br>RL |
|---------|----------|----------|---------|----------|----------|
| 5       | 70       | 35       | 10x24   | 034074   | 034075 ● |
| 7       | 70       | 35       | 10x24   | 034106   | 034107 ● |
| 8       | 70       | 35       | 10x24   | 034076   | 034077 ● |
| 9       | 70       | 35       | 10x24   | 034108   | 034109 ● |
| 10      | 70       | 35       | 10x24   | 034110   | 034111 ● |
| 11      | 70       | 35       | 10x24   | 034112   | 034113 ● |

RPM:  $n = 3000 - 9000 \text{ min}^{-1}$

For diameters below 5 mm use type WB 101-0-04.

#### GL 77 mm, without guide heel, Z 2

WB 101-0-03

| D<br>mm | GL<br>mm | NL<br>mm | S<br>mm | ID<br>LL | ID<br>RL |
|---------|----------|----------|---------|----------|----------|
| 5       | 77       | 44       | 10x24   | 034060   | 034061 ● |
| 6       | 77       | 44       | 10x24   | 034068   | 034069 ● |
| 8       | 77       | 44       | 10x24   | 034062   | 034063 ● |
| 10      | 77       | 44       | 10x24   | 034070   | 034071 ● |
| 12      | 77       | 44       | 10x24   | 034072   | 034073 ● |

RPM:  $n = 3000 - 9000 \text{ min}^{-1}$

For diameters below 5 mm use type WB 101-0-04.

##### Spare parts:

| BEZ         | ABM<br>mm | BEM               | ID       |
|-------------|-----------|-------------------|----------|
| Allen screw | M5x10     | Length adjustment | 005802 ● |

● available ex stock

□ available at short notice

## 6. Drilling

### 6.2 Through-hole drilling

#### 6.2.1 Through-hole drills



#### Shank 10 mm

##### Application:

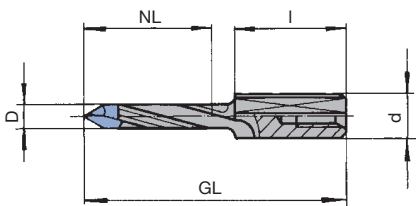
For drilling through-holes, especially in cabinetry. Suitable for machines with insufficient bit guidance.

##### Machine:

Point-to-point drilling machines, through-feed drilling machines, CNC machining centres, hinge boring machines, multi-spindle units.

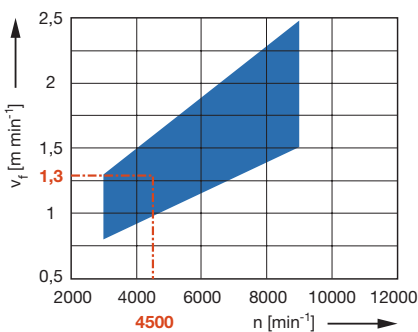
##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (chipboard, MDF, HF etc.), untreated, plastic-coated, veneered etc., laminated woods (plywood etc.), elastomers



Design with heel

Feed speed  $v_f$  depending on the spindle RPM  $n$



##### Workpiece material:

Chipboard plastic coated

##### Working step:

Boring

##### Correction factor for $v_f$ :

Veneered = 0.8

MDF = 0.7

Chipboard, untreated = 1.3

##### Technical information:

Can be combined with loose countersink WB 701-0-02. Countersinks fixed on flute. Continuously adjustable boring and countersink depth. Good return stroke guidance for tear-free hole edges.

##### GL 57.5 mm, with heel, Z 2

WB 101-0-05

| D<br>mm | GL<br>mm | NL<br>mm | S<br>mm | ID<br>LL      | ID<br>RL          |
|---------|----------|----------|---------|---------------|-------------------|
| 5       | 57,5     | 25       | 10x24   | <b>042630</b> | ● <b>042631</b> ● |
| 6       | 57,5     | 25       | 10x24   | <b>042636</b> | ● <b>042637</b> ● |
| 8       | 57,5     | 25       | 10x24   | <b>042638</b> | ● <b>042639</b> ● |

RPM:  $n = 3000 - 9000 \text{ min}^{-1}$

For diameters below 5 mm use type WB 101-0-04.

##### GL 77 mm, with heel, Z 2

WB 101-0-06

| D<br>mm | GL<br>mm | NL<br>mm | S<br>mm | ID<br>LL      | ID<br>RL          |
|---------|----------|----------|---------|---------------|-------------------|
| 5       | 77       | 44       | 10x24   | <b>042640</b> | ● <b>042641</b> ● |
| 5,1     | 77       | 44       | 10x24   | <b>042642</b> | ● <b>042643</b> ● |
| 5,2     | 77       | 44       | 10x24   | <b>042644</b> | ● <b>042645</b> ● |
| 6       | 77       | 44       | 10x24   | <b>042646</b> | ● <b>042647</b> ● |
| 8       | 77       | 44       | 10x24   | <b>042648</b> | ● <b>042649</b> ● |
| 10      | 77       | 44       | 10x24   | <b>042650</b> | ● <b>042651</b> ● |
| 12      | 77       | 44       | 10x24   | <b>042652</b> | ● <b>042653</b> ● |

RPM:  $n = 3000 - 9000 \text{ min}^{-1}$

For diameters below 5 mm use type WB 101-0-04.

##### Spare parts:

| BEZ         | ABM         | BEM               | ID              |
|-------------|-------------|-------------------|-----------------|
| Allen screw | M5x10<br>mm | Length adjustment | <b>005802</b> ● |

## 6. Drilling

### 6.2 Through-hole drilling 6.2.2 Through-hole drill, Marathon design



#### Shank 10 mm

##### Application:

For drilling tear-free through-holes, especially in cabinetry, with maximum quality at the hole exit side.

##### Machine:

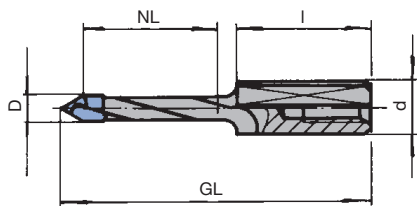
Point-to-point drilling machines, through-feed drilling machines, CNC machining centres, hinge boring machines, multi-spindle units

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (chipboard, MDF, HF etc.), untreated, plastic-coated, veneered etc., laminated woods (plywood etc.)

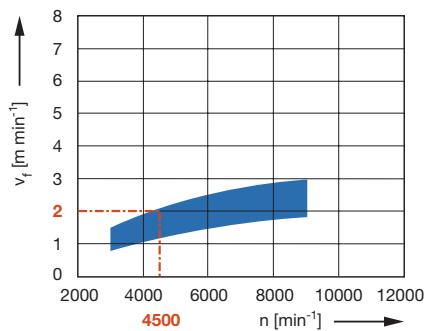
##### Technical information:

V-point ground with 2 bevels for maximum quality on the hole exit side. High wear-resistant tungsten carbide quality for maximum life time. Can be combined with loose countersink WB 701-0-02. Countersink fixed on flute. Recessed flute for minimum friction and feed forces.



Design without heel

Feed speed  $v_f$  depending on the spindle RPM  $n$



##### Workpiece material:

Chipboard plastic coated

##### Working step:

Boring

##### Correction factor for $v_f$ :

Veneered = 0.8

MDF, solid wood = 0.7

Chipboard, untreated = 1.3

#### GL 57.5 mm, Z 2

WB 101-0-10

| D<br>mm | GL<br>mm | NL<br>mm | S<br>mm | ID<br>LL | ID<br>RL |
|---------|----------|----------|---------|----------|----------|
| 5       | 57,5     | 25       | 10x25   | 033960   | 033961   |
| 8       | 57,5     | 25       | 10x25   | 033962   | 033963   |

RPM:  $n = 3000 - 9000 \text{ min}^{-1}$

(recommended  $n = 4500-9000 \text{ min}^{-1}$ )

#### GL 70 mm, Z 2

WB 101-0-10

| D<br>mm | GL<br>mm | NL<br>mm | S<br>mm | ID<br>LL | ID<br>RL |
|---------|----------|----------|---------|----------|----------|
| 5       | 70       | 35       | 10x25   | 033964   | 033965   |
| 8       | 70       | 35       | 10x25   | 033966   | 033967   |

RPM:  $n = 3000 - 9000 \text{ min}^{-1}$

(recommended  $n = 4500-9000 \text{ min}^{-1}$ )

##### Spare parts:

| BEZ         | ABM<br>mm | BEM               | ID     |
|-------------|-----------|-------------------|--------|
| Allen screw | M5x10     | Length adjustment | 005802 |
| Allen screw | M3x2,5    | Locking device    | 007889 |

## 6. Drilling

### 6.2 Through-hole drilling 6.2.3 Through-hole drill, HW-solid



#### Shank 10 mm

##### Application:

For drilling tear-free through-holes, especially in cabinetry, with maximum quality at the hole exit side.

##### Machine:

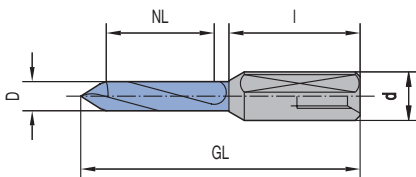
Point-to-point drilling machines, through-feed drilling machines, CNC machining centres, hinge boring machines, multi-spindle units

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (chipboard, MDF, HF etc.), untreated, plastic-coated, veneered etc., laminated woods (plywood etc.)

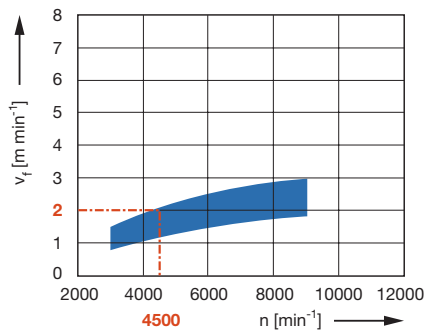
##### Technical information:

V-point ground with 2 bevels for maximum quality on the exit side of the hole. Solid tungsten carbide design with high wear-resistant tungsten carbide quality. High stability and long life time. Polished gullet for minimum friction and feed forces.



Design without heel

Feed speed  $v_f$  depending on the spindle RPM  $n$



##### Workpiece material:

Chipboard plastic coated

##### Working step:

Boring

##### Correction factor for $v_f$ :

Veneered = 0.8

MDF, solid wood = 0.7

Chipboard, untreated = 1.3

#### GL 57.5 mm, without heel, Z 2

WB 101-0-02

| D<br>mm | GL<br>mm | NL<br>mm | S<br>mm | ID<br>LL | ID<br>RL |
|---------|----------|----------|---------|----------|----------|
| 5       | 57,5     | 25       | 10x27   | 034018   | 034019 ● |
| 6       | 57,5     | 25       | 10x27   | 034020   | 034021 ● |
| 8       | 57,5     | 25       | 10x27   | 034022   | 034023 ● |

RPM:  $n = 3000 - 12000 \text{ min}^{-1}$

For diameters below 5 mm use type WB 101-0-04.

#### GL 70 mm, without heel, Z 2

WB 101-0-07

| D<br>mm | GL<br>mm | NL<br>mm | S<br>mm | ID<br>LL | ID<br>RL |
|---------|----------|----------|---------|----------|----------|
| 5       | 70       | 35       | 10x27   | 034100   | 034101 ● |
| 6       | 70       | 35       | 10x27   | 034102   | 034103 ● |
| 8       | 70       | 35       | 10x25   | 034104   | 034105 ● |

RPM:  $n = 3000 - 12000 \text{ min}^{-1}$

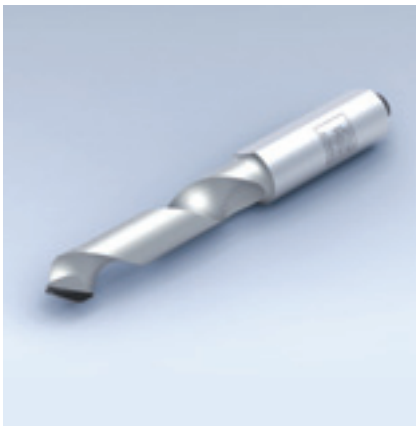
For diameters below 5 mm use type WB 101-0-04.

##### Spare parts:

| BEZ                    | ABM<br>mm | BEM               | ID       |
|------------------------|-----------|-------------------|----------|
| Allen screw for S10x27 | M5x8      | Length adjustment | 006378 ● |

## 6. Drilling

### 6.2 Through-hole drilling 6.2.4 Through-hole drill, DP-design



#### Shank 10 mm

##### Application:

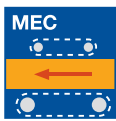
For drilling tear-free through-holes. Suitable for drilling panel materials coated with abrasive additional material (fire-proof material etc.).

##### Machine:

Point-to-point drilling machines, through-feed drilling machines, CNC machining centres, hinge boring machines, multi-spindle units

##### Workpiece material:

Gypsum-bonded particle and fibre materials, cement-bonded particle and fibre materials, flame-resistant particle and fibre materials, solid resin laminated boards, fibre-reinforced plastics



##### Technical information:

PCD through-hole drilling bit for maximum life time, especially in abrasive materials. Large gullet for optimum chip removal from the hole.

##### GL 70 mm, Z 1

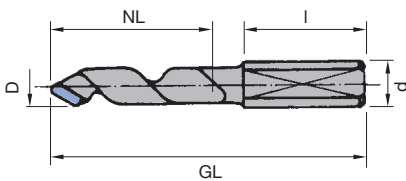
WB 100-0-50

| D<br>mm | GL<br>mm | NL<br>mm | S<br>mm | Z | ID<br>LL | ID<br>RL |
|---------|----------|----------|---------|---|----------|----------|
| 5       | 70       | 30       | 10x27   | 1 | 091186   | 091185 ● |
| 6       | 70       | 30       | 10x27   | 1 | 091188   | 091187 ● |
| 8       | 70       | 30       | 10x27   | 1 | 091192   | 091191 ● |
| 10      | 70       | 30       | 10x27   | 1 | 091194   | 091193 ● |

RPM:  $n = 4000 - 9000 \text{ min}^{-1}$

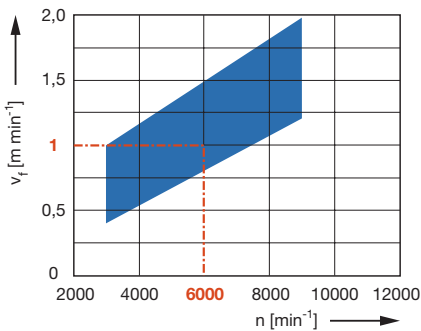
##### Spare parts:

| BEZ         | ABM<br>mm | BEM               | ID       |
|-------------|-----------|-------------------|----------|
| Allen screw | M5x10     | Length adjustment | 005802 ● |



WB 100-0-50

Feed speed  $v_f$  depending on the spindle RPM  $n$



##### Workpiece material:

Chipboard plastic coated

##### Working step:

Boring

##### Correction factor for $v_f$ :

MDF = 0.7

Chipboard, untreated = 1.2