



Shank 10 mm

Application:

For drilling blind holes, particularly dowel holes on the side of panel furniture parts.

Machine:

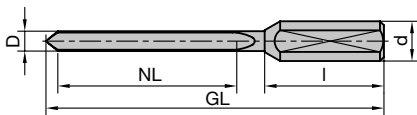
Point-to-point drilling machines, through feed drilling machines, CNC machining centres, hinge boring machines, multi spindle units.

Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

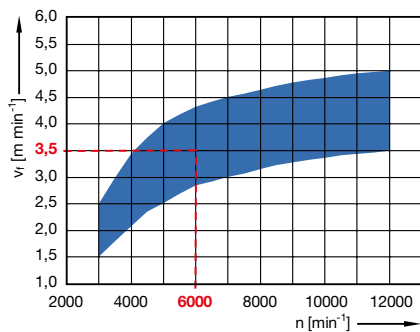
Technical information:

Solid tungsten carbide design for high performance time. Large resharping area. Tool suitable for RH and LH rotation. Drill design D = 3 mm particularly suitable for pre-drilling screw holes in plastic coated and veneered furniture parts. Infeed depth in hardwood and glulam maximum 2 x D.



Boring pin WB 100 0 01

Feed speed v_f depending on the spindle RPM n



Workpiece material:

Chipboard / MDF

Operation:

Horizontal edge drilling

GL 57.5 / GL 70 mm, Z 1/1

WB 100 0 01

D mm	GL mm	NL mm	S mm	DRI	ID
3	57.5	25	10x27	LH, RH	230200 ●
3	70	35	10x27	LH, RH	230201 ●
5	70	35	10x27	LH, RH	230208 ●
6	70	35	10x27	LH, RH	230209 ●
8	70	35	10x27	LH, RH	230210 ●
5	57.5	25	10x27	LH, RH	230211 ●
6	57.5	25	10x27	LH, RH	230212 ●
8	57.5	25	10x27	LH, RH	230213 ●

GL 85 mm, Z 1/1

WB 100 0 01

D mm	GL mm	NL mm	S mm	DRI	ID
5	85	45	10x30	LH, RH	230202 ●
8	85	45	10x30	LH, RH	230204 ●

GL 105 mm, Z 1/1

WB 100 0 01

D mm	GL mm	NL mm	S mm	DRI	ID
5	105	65	10x30	LH, RH	230205 ●
8	105	65	10x30	LH, RH	230207 ●

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

Note:

When using the bore pins in hardwood and glulam, the potential bore depth is restricted. Interim chip removal (return stroke) then is obligatory.

Boring pins require more power compared to dowel drills. The maximum number of boring pins, used in one drilling unit, depends on the power of the machine.

Spare parts:

BEZ	for S mm	ABM mm	BEM	ID
Allen screw	10x27	M5x8	Length adjustment	006378 ●
Allen screw	10x30	M5x10	Length adjustment	005802 ●
Anti-twist allen screw		M5x10	Length adjustment	007438 ●
Length adjustment screw		M5x17	for quick-change drill	009157 ●
Torx® 20			adaptors	

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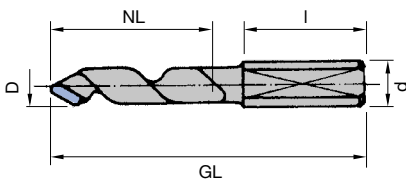
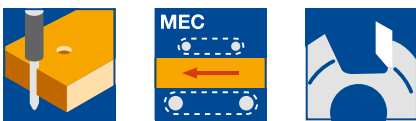
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6. Drilling

6.2 Through hole drilling 6.2.4 Through hole drills, DP



WB 100 0 50

Shank 10 mm

Application:

For drilling tear-free through holes. Particularly suitable for drilling panel materials with abrasive components (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 glulam, fibre reinforced plastics.

Technical information:

DP tipped through hole boring bit for maximum lifetime, particularly in abrasive materials. Large gullet for optimum chip removal.

GL 70 mm, Z 1

WB 100 0 50

D mm	GL mm	NL mm	S mm	Z	ID LH	ID RH
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 mm	BEM	ID
Allen screw	M5x10	Length adjustment	005802 ●
Anti-twist allen screw	M5x10	Length adjustment	007438 ●
Length adjustment screw Torx® 20	M5x17	for quick-change drill adaptors	009157 ●

GL 77 mm, without heel, Z 2

WB 101 0 03

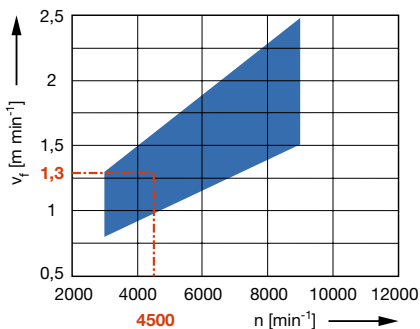
D mm	GL mm	NL mm	S mm	ID LH	ID RH
5	77	44	10x24	034060 ●	034061 ●
6	77	44	10x24	034068 ●	034069 ●
8	77	44	10x24	034062 ●	034063 ●
10	77	44	10x24	034070 ●	034071 ●
12	77	44	10x24	034072 ●	034073 ●

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

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

Spare parts:

BEZ	ABM mm	BEM	ID
Allen screw	M5x10	Length adjustment	005802 ●
Anti-twist allen screw	M5x10	Length adjustment	007438 ●
Length adjustment screw Torx® 20	M5x17	for quick-change drill adaptors	009157 ●



Workpiece material:

Chipboard plastic coated

Operation:

Drilling

Correction factor for v_f :

Veneered = 0.8

MDF = 0.7

Chipboard, uncoated = 1.3

6. Drilling

6.2 Through hole drilling

6.2.1 Through hole drills



Shank 10 mm

Application:

For drilling through holes, particularly in furniture construction. Recommended on drill spindles with limited rigidity

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 (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), elastomers.



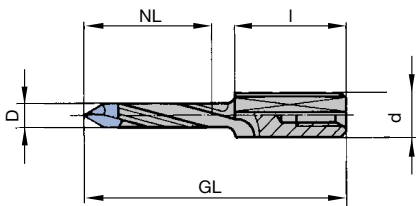
Technical information:

Drills can be combined with countersink WB 701 0 03. Countersinks fixed on heel. Continuously adjustable boring and countersink depth. Good guidance on return stroke for tear-free holes.

GL 57.5 mm, with heel, Z 2

WB 101 0 05

D	GL	NL	S	ID	ID
mm	mm	mm	mm	LH	RH
5	57.5	25	10x24	042630 ●	042631 ●



Design with heel

GL 77 mm, with heel, Z 2

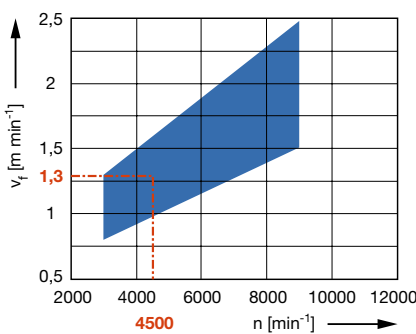
WB 101 0 06

D	GL	NL	S	ID	ID
mm	mm	mm	mm	LH	RH
5	77	44	10x24	042640 ●	042641 ●
5.2	77	44	10x24	042644 ●	042645 ●
6	77	44	10x24		042647 ●
8	77	44	10x24	042648 ●	042649 ●
10	77	44	10x24		042651 ●
12	77	44	10x24		042653 ●

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

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

Feed speed v_f depending on the spindle RPM n



Spare parts:

BEZ	ABM	BEM	ID
	mm		
Allen screw	M5x10	Length adjustment	005802 ●
Anti-twist allen screw	M5x10	Length adjustment	007438 ●
Length adjustment screw Torx® 20	M5x17	for quick-change drill adaptors	009157 ●

Workpiece material:

Chipboard plastic coated

Operation:

Drilling

Correction factor for v_f :

Veneered = 0.8

MDF = 0.7

Chipboard, uncoated = 1.3

5. Routing

5.5 Portable routers 5.5.5 Drills for portable routers

Dowel drill, HW, Z 2 / V 2



Application:

For drilling blind holes, particularly dowel holes in furniture construction.

Machine:

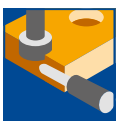
Portable routers.

Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

Technical information:

Spurs geometry with shear cut. Tool body with reduced diameter for minimum friction and feed force. Cylindrical shank without clamping flat.

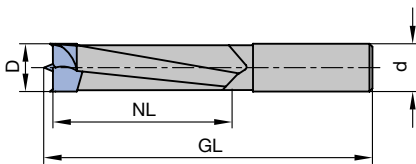


Dowel drill, HW, Z 2 / V 2

WB 101 0, WB 120 0

D	GL	NL	S	DRI	ID
mm	mm	mm	mm		
3	55	16	8x30	RH	072597 □
5	60.5	30	8x27	RH	072752 □
6	60.5	30	8x27	RH	072753 □
8	60.5	30	8x27	RH	072754 □
10	60.5	30	8x27	RH	072755 □

RPM: n = 3000 - 9000 min⁻¹



Dowel drill Z 2 / V 2

6. Drilling

6.2 Through hole drilling 6.2.2 Through hole drills - Premium

Shank 10 mm, HW tipped



Application:

For drilling tear-free through holes, particularly in furniture construction, with maximised quality on the bottom side (exit).

Machine:

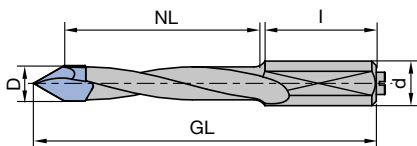
Point-to-point drilling machines, through feed drilling machines, CNC machining centres, hinge boring machines, multi spindle units.

Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

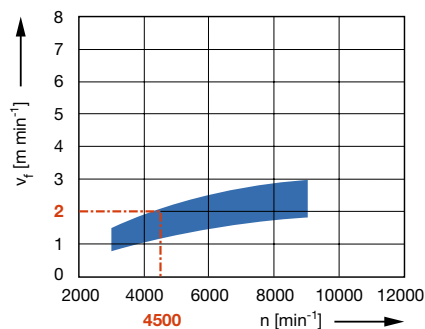
Technical information:

V-point tip with 2 bevels for maximised quality on the bottom side (exit). High wear resistant tungsten carbide grade for maximum lifetime. Drills can be combined with countersink WB 701 0 02. Countersinks can be clamped on the shank. Recessed flute for minimised friction and feed forces.



Design without heel

Feed speed v_f depending on the spindle RPM n



Workpiece material:

Chipboard plastic coated

Operation:

Drilling

Correction factor for v_f :

Veneered = 0.8

MDF, solid wood = 0.7

Chipboard, uncoated = 1.3

GL 57.5 mm, Z 2

WB 101 0 10

D	GL	NL	S	ID	ID
mm	mm	mm	mm	LH	RH
5	57.5	25	10x25	033960 ●	033961 ●
8	57.5	25	10x25	033962 ●	033963 ●

GL 70 mm, Z 2

WB 101 0 10

D	GL	NL	S	ID	ID
mm	mm	mm	mm	LH	RH
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	BEM	ID
	mm		
Allen screw	M5x10	Length adjustment	005802 ●
Anti-twist allen screw	M5x10	Length adjustment	007438 ●
Length adjustment screw Torx® 20	M5x17	for quick-change drill adaptors	009157 ●

6. Drilling

6.4 Multi-purpose drilling

6.4.1 Twist drills



HW solid, Z 2, V-point, Marathon

Application:

For drilling very deep holes without interim clearance strokes at high feed speed particularly for timber frame and window construction.

Machine:

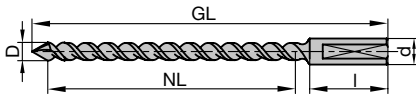
Stationary routers with/without CNC control, machining centres, special cutting machines to machine frame parts, column drilling machines, drilling machines, multi spindle units, portable drills.

Workpiece material:

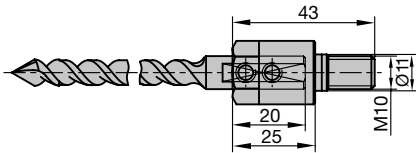
Softwood and hardwood, modified timber for window construction, laminated veneer lumber (plywood, multiplex etc.), glued lumber.

Technical information:

Solid tungsten carbide design, Z 2 with V-point. Marathon coating for increased performance time. Large gullets for perfect chip removal. Shank design with reduced clamping area for good centering in shrink and collet chucks.

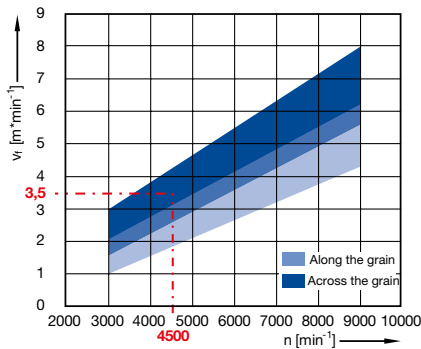


WB 101 0 12,
twist drill with V-point



WB 101 0 12,
twist drill with V-point, with adaptor

Feed speed v_f depending on the spindle
RPM n



GL 130 / 160 mm

WB 101 0 12

D mm	GL mm	NL mm	S mm	DRI	ID with adaptor	ID without adaptor
6	130	90	10x30	RH	230400 □	230300 ●
7	130	90	10x30	RH	230401 □	230301 ●
8	160	120	10x30	RH	230405 □	230305 ●
9	160	120	10x30	RH	230402 □	230302 ●
10	160	120	10x30	RH	230403 □	230303 ●
12	160	120	10x30	RH	230404 □	230304 ●

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

Diameter:

$D = 6 - 12 \text{ mm}$

Workpiece material:

Softwood

Operation:

Drilling, through hole

Correction factor for v_f :

Hardwood = 0.8

Laminated veneer lumber = 1.2

6. Drilling

6.4 Multi-purpose drilling

6.4.1 Twist drills



HW solid, Z 2, V-point

Application:

For drilling deep holes. Particularly for timber frame and window construction.

Machine:

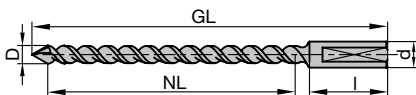
Stationary routers with/without CNC control, machining centres, special cutting machines to machine frame parts, column drilling machines, drilling machines, multi spindle units, portable drills.

Workpiece material:

Softwood and hardwood, modified timber for window construction, laminated veneer lumber (plywood, multiplex etc.), glued lumber.

Technical information:

Solid tungsten carbide design, Z 2 with V-point. Design with double heel for improved guidance while drilling and return stroke from the hole. Shank design with reduced clamping area for good centering in shrink and collet chucks.



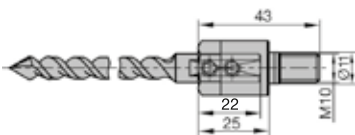
WB 101 0 13, twist drill with V-point

GL 130 / 160 mm

WB 101 0 13

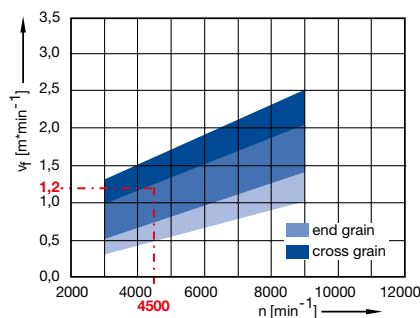
D mm	GL mm	NL mm	S mm	QAL	DRI	ID with adaptor	ID without adaptor
7	130	90	10x30	HW solid	RH	230451 □	230351 ●
8	160	120	10x30	HW solid	RH	230455 □	230355 ●
9	160	120	10x30	HW solid	RH	230452 □	230352 ●
10	160	120	10x30	HW solid	RH	230453 □	230353 ●
12	160	120	10x30	HW solid	RH	230454 □	230354 ●

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



WB 101 0 13, twist drill with V-point, with adaptor

Feed speed v_f depending on the spindle RPM n



Workpiece material:

Softwood

Operation:

Drilling

Correction factor for v_f :

Hardwood = 0.8

Laminated veneer lumber = 1.1

6. Drilling

6.4 Multi-purpose drilling

6.4.2 Levin type drills



HW, Z 1 / V 1

Application:

For drilling deep holes. Suitable for depths up to 75 mm without interim clearance strokes. Particularly suitable for producing joint holes in timber frame construction.

Machine:

Column drilling machines, drilling machines, multi spindle units, special purpose drilling machines, portable drills.

Workpiece material:

Softwood and hardwood, laminated veneer lumber (plywood, multiplex plywood etc.), glued lumber.

Technical information:

Tungsten carbide design, Z 1/V 1 and centre point. Very large gullets for good chip removal, particularly when drilling in end grain.



Drill point for blind holes

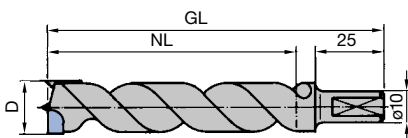
WB 110 0

D	GL	NL	S	QAL	ID	ID
mm	mm	mm	mm		LH	RH
12	110	80	10x25	HW	036174 ●	036175 ●
14	110	80	10x25	HW		036177 ●
16	110	80	10x25	HW	036178 ●	036179 ●

RPM: $n = 3000 - 7500 \text{ min}^{-1}$

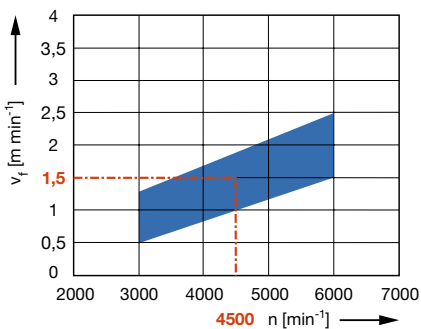
Spare parts:

BEZ	ABM	BEM	ID
	mm		
Allen screw	M5x10	Length adjustment	005802 ●
Anti-twist allen screw	M5x10	Length adjustment	007438 ●



WB 110 0, shank with clamping flat and adjusting screw

Feed speed v_f depending on the spindle RPM n



Workpiece material:

Solid wood

Operation:

Drilling

Correction factor for v_f :

Drilling depth $> 4 \times D = 0.8$

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