

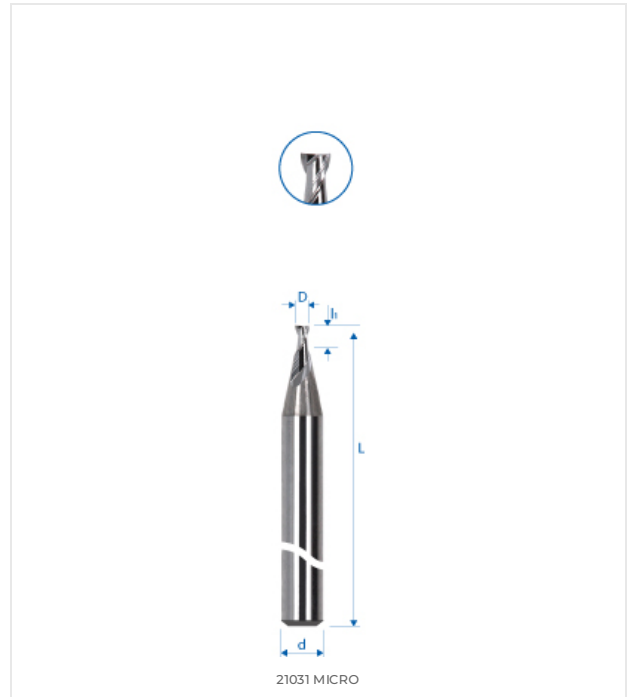
<p><b>E25 UF</b> CARBIDE TOOL MATERIAL E25 UF</p>	<p><math>\lambda = 35^\circ</math> <math>\gamma = 10^\circ</math> CUTTING ANGLES <math>\gamma 35^\circ / 10^\circ</math></p>	<p>angle vif ACUTE ANGLE PRECISION TOOL</p>	<p>DUAL DIRECTION HELICAL DRILL BIT</p>	<p>1.5xD 1.5xD DEPTH PRECISION TOOL</p>	<p>STANDARD TOOL WEAR INDICATOR</p>
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## MATERIAL COMPATIBILITY

●●● Excellent (3/3) ●● Good (2/3) ●○ Possible (1/3) ○○○ Not recommended

MATERIAL	SPECIFICATION	GRP	21031-0.25
<b>Alloyed and non-alloyed steels</b> Non-alloyed steels	Rm < 450 N/mm <sup>2</sup>	1a	●○
	Rm 450–700 N/mm <sup>2</sup>	1b	●○
	Rm 700–900 N/mm <sup>2</sup>	1c	●○
	Rm > 1200 N/mm <sup>2</sup>	1d	○○
<b>Stainless steels</b> Stainless steels	Rm < 650 N/mm <sup>2</sup>	2a	●○
	Rm 650–950 N/mm <sup>2</sup>	2b	●○
	Rm > 950 N/mm <sup>2</sup>	2c	○○
<b>Hardened steels</b> Hardened steels	44–56 HRC	3a	○○
	57–67 HRC	3b	○○
<b>Exotic materials</b> Special alloys	< 32 HRC	4a	○○
	> 32 HRC	4b	○○
<b>Graphite</b> Industrial graphite		5	●○
<b>Cast iron</b> Grey / nodular cast iron	< 32 HRC	6a	○○
	> 32 HRC	6b	○○
<b>Titanium</b> Titanium alloys	Rm < 600 N/mm <sup>2</sup>	7a	●○
	600 < Rm N/mm <sup>2</sup>	7b	●○
<b>Nickel alloys</b> Inconel, Hastelloy	Rm < 1000 N/mm <sup>2</sup>	8a	○○
	Rm > 1000 N/mm <sup>2</sup>	8b	○○
<b>Copper, brass, bronze</b> Copper-based	Rm < 850 N/mm <sup>2</sup>	9a	●●●
	Rm > 850 N/mm <sup>2</sup>	9b	●●●
<b>Aluminum</b> Aluminum alloys	Si < 0.5%	10a	●●●
	0.5% < Si < 5%	10b	●●●
	Si > 5%	10c	○○
<b>Synthetic materials</b> Engineering plastics	Thermoplastic	11a	●●●
	Thermoset	11b	●●●
<b>Composite materials</b> Reinforced composites	Glass fiber / GFK	12a	●○
	Carbon fiber / KFK	12b	●○
<b>Precious metals</b> Gold, platinum, silver	Gold	13a	●●●
	Platinum	13b	○○

## TECHNICAL DRAWING



## DIMENSIONS

### NOMINAL DIMENSIONS

D (0 / -0.01)	0.25 mm
d (h5)	3 mm
L	38 mm
l1	0.35 mm
l3	–
d3	–
R	–
e	–
Z	2
Chamfer K	–
w° collision	12.5°

