

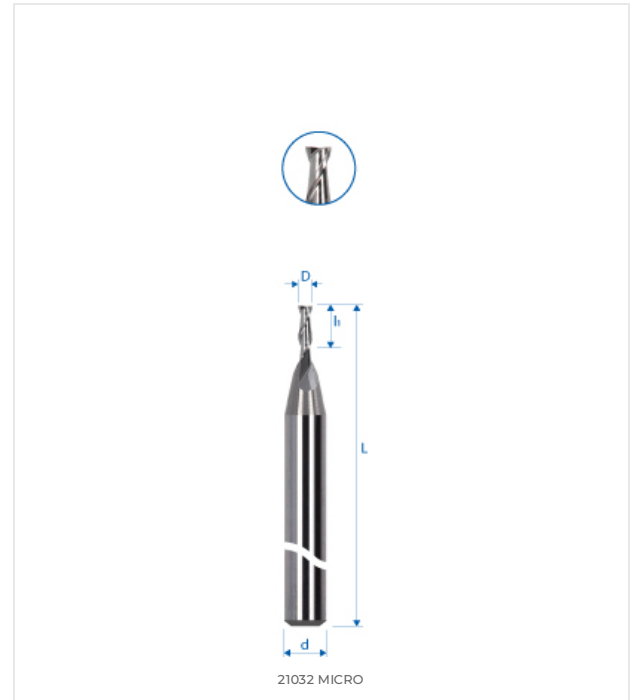
<p>E25 UF</p> <p>CARBIDE TOOL MATERIAL E25 UF</p>	<p>$\lambda = 35^\circ$ $\gamma = 10^\circ$</p> <p>CUTTING ANGLES $\gamma 35^\circ$? 10°</p>	<p>angle vif</p> <p>ACUTE ANGLE PRECISION TOOL</p>	<p>DUAL DIRECTION HELICAL DRILL BIT</p>	<p>2.2xD</p> <p>2.2xD DEPTH FOR TOOLS</p>	<p>TOOL LENGTH MEASUREMENT BARS</p>
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MATERIAL COMPATIBILITY

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

MATERIAL	SPECIFICATION	GRP	21032-1.9
Alloyed and non-alloyed steels Non-alloyed steels	Rm < 450 N/mm ²	1a	●○○
	Rm 450–700 N/mm ²	1b	●○○
	Rm 700–900 N/mm ²	1c	●○○
	Rm > 1200 N/mm ²	1d	○○○
Stainless steels Stainless steels	Rm < 650 N/mm ²	2a	●○○
	Rm 650–950 N/mm ²	2b	●○○
	Rm > 950 N/mm ²	2c	○○○
Hardened steels Hardened steels	44–56 HRC	3a	○○○
	57–67 HRC	3b	○○○
Exotic materials Special alloys	< 32 HRC	4a	○○○
	> 32 HRC	4b	○○○
Graphite Industrial graphite		5	●○○
Cast iron Grey / nodular cast iron	< 32 HRC	6a	○○○
	> 32 HRC	6b	○○○
Titanium Titanium alloys	Rm < 600 N/mm ²	7a	●○○
	600 < Rm N/mm ²	7b	●○○
Nickel alloys Inconel, Hastelloy	Rm < 1000 N/mm ²	8a	○○○
	Rm > 1000 N/mm ²	8b	○○○
Copper, brass, bronze Copper-based	Rm < 850 N/mm ²	9a	●●●
	Rm > 850 N/mm ²	9b	●●●
Aluminum Aluminum alloys	Si < 0.5%	10a	●●●
	0.5% < Si < 5%	10b	●●●
	Si > 5%	10c	○○○
Synthetic materials Engineering plastics	Thermoplastic	11a	●●●
	Thermoset	11b	●●●
Composite materials Reinforced composites	Glass fiber / GFK	12a	●○○
	Carbon fiber / KFK	12b	●○○
Precious metals Gold, platinum, silver	Gold	13a	●●●
	Platinum	13b	○○○

TECHNICAL DRAWING



DIMENSIONS

NOMINAL DIMENSIONS	
D (0 / -0.01)	1.9 mm
d (h5)	3 mm
L	38 mm
l1	5 mm
l3	–
d3	–
R	–
e	–
Z	2
Chamfer K	–
w° collision	4.5°

