

E2 E2 HIGH PRECISION TOOL MATERIAL	$\lambda=30^{\circ}\text{-}35^{\circ}$ $\gamma=8^{\circ}$ CUTTING ANGLES $730^{\circ}\text{-}35^{\circ}$ 78°	$0 \leq \phi \leq 6$ 90° 45° CHAMFER $\phi < 6$ $\phi > 6$ 90° 45°	DUAL DIRECTION HELICAL DRILL BIT	$1.5 \times D$ 1.5XD DEPTH PRECISION TOOL	SHORT LENGTH TOOL WEAR BARS	ADJUSTABLE ANGLE ICON	VARIABLE HELIX DRILL BIT
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MATERIAL COMPATIBILITY

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

MATERIAL	SPECIFICATION	GRP	21062A-2.5-6
Alloyed and non-alloyed steels <small>Non-alloyed steels</small>	$R_m < 450 \text{ N/mm}^2$	1a	●●●
	$R_m 450\text{--}700 \text{ N/mm}^2$	1b	●●●
	$R_m 700\text{--}900 \text{ N/mm}^2$	1c	●●●
	$R_m > 1200 \text{ N/mm}^2$	1d	●●●
Stainless steels <small>Stainless steels</small>	$R_m < 650 \text{ N/mm}^2$	2a	●●●
	$R_m 650\text{--}950 \text{ N/mm}^2$	2b	●●●
	$R_m > 950 \text{ N/mm}^2$	2c	●●●
Hardened steels <small>Hardened steels</small>	44–56 HRC	3a	●●○
	57–67 HRC	3b	●○○
Exotic materials <small>Special alloys</small>	$< 32 \text{ HRC}$	4a	●●○
	$> 32 \text{ HRC}$	4b	●●○
Graphite <small>Industrial graphite</small>		5	●●○
Cast iron <small>Grey / nodular cast iron</small>	$< 32 \text{ HRC}$	6a	●●●
	$> 32 \text{ HRC}$	6b	●●●
Titanium <small>Titanium alloys</small>	$R_m < 600 \text{ N/mm}^2$	7a	●●●
	$600 < R_m \text{ N/mm}^2$	7b	●●●
Nickel alloys <small>Inconel, Hastelloy</small>	$R_m < 1000 \text{ N/mm}^2$	8a	●●●
	$R_m > 1000 \text{ N/mm}^2$	8b	●●●
Copper, brass, bronze <small>Copper-based</small>	$R_m < 850 \text{ N/mm}^2$	9a	●○○
	$R_m > 850 \text{ N/mm}^2$	9b	●○○
Aluminum <small>Aluminum alloys</small>	$Si < 0.5\%$	10a	●○○
	$0.5\% < Si < 5\%$	10b	●○○
	$Si > 5\%$	10c	●●○
Synthetic materials <small>Engineering plastics</small>	Thermoplastic	11a	○○○
	Thermoset	11b	○○○
Composite materials <small>Reinforced composites</small>	Glass fiber / GFK	12a	●●○
	Carbon fiber / KFK	12b	●●○
Precious metals <small>Gold, platinum, silver</small>	Gold	13a	●○○
	Platinum	13b	●○○

TECHNICAL DRAWING



DIMENSIONS

NOMINAL DIMENSIONS	
D (0 / -0.01)	2.5 mm
d (h5)	6 mm
L	50 mm
l1	3 mm
l3	–
d3	–
R	–
e	–
Z	3
Chamfer K	–
w° collision	9.7°

