

<b>E2</b> E2 HIGH PRECISION TOOL MATERIAL	$\lambda=35^{\circ}\text{-}38^{\circ}$ $\gamma=10^{\circ}$ CUTTING ANGLES 735-38° 710°	angle vif ACUTE ANGLE PRECISION TOOL	 DUAL DIRECTION HELICAL DRILL BIT	$l_1$ 1.5xD 1.5XD DEPTH PRECISION TOOL	 SHORT LENGTH TOOL WEAR BARS	 ADJUSTABLE ANGLE ICON	$\lambda_2$ $\lambda_1$ VARIABLE HELIX DRILL BIT
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MATERIAL COMPATIBILITY

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

MATERIAL	SPECIFICATION	GRP	21111-3-6
<b>Alloyed and non-alloyed steels</b> <small>Non-alloyed steels</small>	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> <small>Stainless steels</small>	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> <small>Hardened steels</small>	44-56 HRC	3a	○○○
	57-67 HRC	3b	○○○
<b>Exotic materials</b> <small>Special alloys</small>	< 32 HRC	4a	○○○
	> 32 HRC	4b	○○○
<b>Graphite</b> <small>Industrial graphite</small>		5	●○○
<b>Cast iron</b> <small>Grey / nodular cast iron</small>	< 32 HRC	6a	○○○
	> 32 HRC	6b	○○○
<b>Titanium</b> <small>Titanium alloys</small>	Rm < 600 N/mm <sup>2</sup>	7a	●●○
	600 < Rm N/mm <sup>2</sup>	7b	●●○
<b>Nickel alloys</b> <small>Inconel, Hastelloy</small>	Rm < 1000 N/mm <sup>2</sup>	8a	○○○
	Rm > 1000 N/mm <sup>2</sup>	8b	○○○
<b>Copper, brass, bronze</b> <small>Copper-based</small>	Rm < 850 N/mm <sup>2</sup>	9a	●●●
	Rm > 850 N/mm <sup>2</sup>	9b	●●●
<b>Aluminum</b> <small>Aluminum alloys</small>	Si < 0.5%	10a	●●○
	0.5% < Si < 5%	10b	●●○
	Si > 5%	10c	○○○
<b>Synthetic materials</b> <small>Engineering plastics</small>	Thermoplastic	11a	●●○
	Thermoset	11b	●●○
<b>Composite materials</b> <small>Reinforced composites</small>	Glass fiber / GFK	12a	●○○
	Carbon fiber / KFK	12b	●○○
<b>Precious metals</b> <small>Gold, platinum, silver</small>	Gold	13a	●●○
	Platinum	13b	○○○

TECHNICAL DRAWING



DIMENSIONS

NOMINAL DIMENSIONS	
D (0 / -0.01)	3 mm
d (h5)	6 mm
L	57 mm
l1	4 mm
l3	-
d3	-
R	-
e	-
Z	4
Chamfer K	-
w° collision	8.4°

