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|--|--|--|--------------------------------------|---|----------------------------------|---------------------------|--|
| E2 E2 HIGH PRECISION TOOL MATERIAL | $\lambda=32^{\circ}-38^{\circ}$ $Y=10^{\circ}$ ADJUSTABLE CUTTING ANGLES 32°-38° | $\phi < 6$ $\phi > 6$ 90° 45° CHAMFER $\phi < 6$ $\phi > 6$ 90° 45° | DUAL DIRECTION HELICAL DRILL BIT | h_1 2.2xD 2.2XD DEPTH FOR TOOLS | STANDARD TOOL WEAR INDICATOR | ADJUSTABLE ANGLE ICON | λ_2 λ_1 VARIABLE HELIX DRILL BIT |
|--|--|--|--------------------------------------|---|----------------------------------|---------------------------|--|

MATERIAL COMPATIBILITY

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

| MATERIAL | SPECIFICATION | GRP | 21302A-0.6 |
|--|------------------------------|-----|------------|
| Alloyed and non-alloyed steels <small>Non-alloyed steels</small> | 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 <small>Stainless steels</small> | Rm < 650 N/mm ² | 2a | ●●● |
| | Rm 650–950 N/mm ² | 2b | ●●● |
| | Rm > 950 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 HRC | 4a | ●●○ |
| | > 32 HRC | 4b | ●●○ |
| Graphite <small>Industrial graphite</small> | | 5 | ●●○ |
| Cast iron <small>Grey / nodular cast iron</small> | < 32 HRC | 6a | ●●○ |
| | > 32 HRC | 6b | ●●○ |
| Titanium <small>Titanium alloys</small> | Rm < 600 N/mm ² | 7a | ●●● |
| | 600 < Rm N/mm ² | 7b | ●●● |
| Nickel alloys <small>Inconel, Hastelloy</small> | Rm < 1000 N/mm ² | 8a | ●●○ |
| | Rm > 1000 N/mm ² | 8b | ●●○ |
| Copper, brass, bronze <small>Copper-based</small> | Rm < 850 N/mm ² | 9a | ●○● |
| | Rm > 850 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) | 0.6 mm |
| d (h5) | 3 mm |
| L | 38 mm |
| l1 | 1.8 mm |
| l3 | – |
| d3 | – |
| R | – |
| e | – |
| Z | 3 |
| Chamfer K | – |
| w° collision | 10° |

