

<b>E2</b> E2 HIGH PRECISION TOOL MATERIAL	$\lambda = 35^\circ$ $\gamma = 10^\circ$ CUTTING ANGLES $\gamma 35^\circ ? 10^\circ$	$\phi < \phi_1$ $\phi > \phi_2$ 90° 45° CHAMFER $\phi < \phi > 6$ 90° 45°	 DUAL DIRECTION HELICAL DRILL BIT	$l_1$ 1.5xD 1.5xD DEPTH PRECISION TOOL	 STANDARD TOOL WEAR INDICATOR
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MATERIAL COMPATIBILITY

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

MATERIAL	SPECIFICATION	GRP	22202A-4-6
<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)	4 mm
d (h5)	6 mm
L	57 mm
l1	8 mm
l3	–
d3	–
R	–
e	–
Z	2
Chamfer K	–
w° collision	4.9°

