

SCIE-CIRCULAIRE-DENTURE-FINE-MD-H1S · SLITTING-SAW-FINE-PITCH-SC-H1S · KREISSÄGE-FEINVERZAHNT-HM-H1S



SWISS MADE

25500-63-2

Version 21.06.2026

H1S

H1S HIGH PRECISION CARBIDE DRILL

$\lambda = 0^\circ$
 $\gamma = 8^\circ$

TOOL ANGLES LAMBDA 0° GAMMA 8°

MATERIAL COMPATIBILITY

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

MATERIAL	SPECIFICATION	GRP	25500-63-2
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)	63 mm
d (h5)	16 mm
L	-
l1	-
l3	-
d3	-
R	-
e	2 mm
Z	80
Chamfer K	-
w° collision	-



E-SHOP / EZI CUT
eskenazi.ch/eshop/25500-63-2

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