

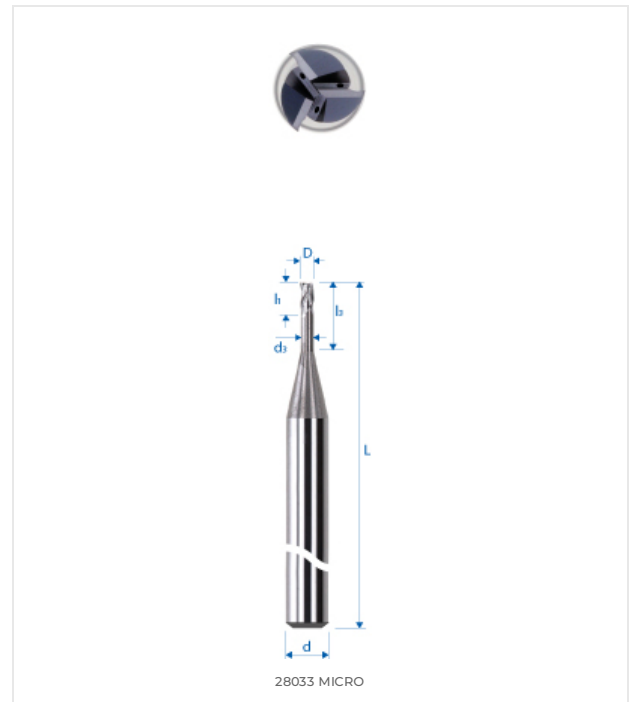
<p>E25 UF</p> <p>CARBIDE TOOL MATERIAL E25 UF</p>	<p>$\lambda=30^{\circ}\text{-}35^{\circ}$ $\gamma=8^{\circ}$</p> <p>CUTTING ANGLES λ30°-35° γ8°</p>	<p>angle vif</p> <p>ACUTE ANGLE PRECISION TOOL</p>	<p>DUAL DIRECTION HELICAL DRILL BIT</p>	<p>l₁ 1.2xD</p> <p>DRILLING DEPTH 1.2xD</p>	<p>l₃ 3xD</p> <p>DRILL DEPTH 3xD LENGTH L3</p>	<p>STANDARD TOOL WEAR INDICATOR</p>	<p>ADJUSTABLE ANGLE ICON</p>	<p>λ2 λ1</p> <p>VARIABLE HELIX DRILL BIT</p>
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MATERIAL COMPATIBILITY

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

MATERIAL	SPECIFICATION	GRP	28033A-1.8
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)	1.8 mm
d (h5)	3 mm
L	38 mm
l1	2.4 mm
l3	5.4 mm
d3	-
R	-
e	-
Z	3
Chamfer K	-
w° collision	4.5°



E-SHOP / EZI CUT
eskenazi.ch/eshop/28033A-1.8