

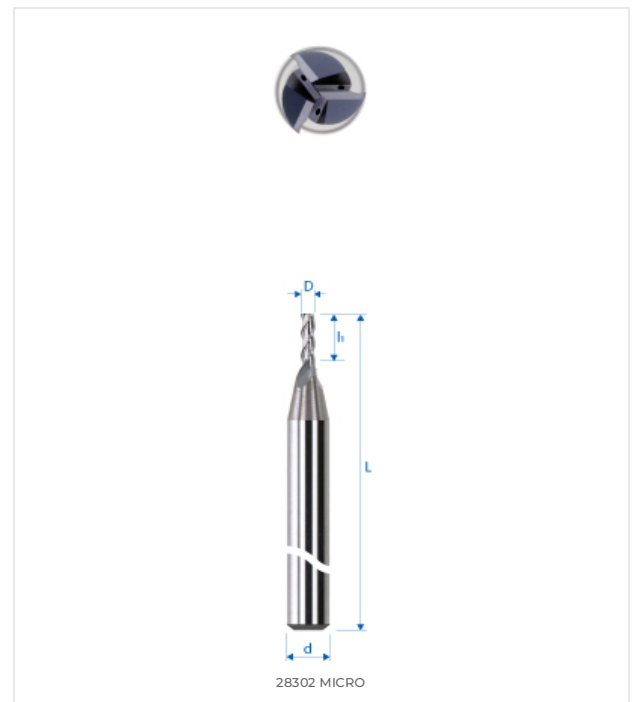
<b>E25 UF</b> CARBIDE TOOL MATERIAL E25 UF	$\lambda=32^{\circ}-38^{\circ}$ $Y=10^{\circ}$ ADJUSTABLE CUTTING ANGLES 32°-38°	angle vif ACUTE ANGLE PRECISION TOOL	 DUAL DIRECTION HELICAL DRILL BIT	$l_3$ 8xD 8XD LENGTH L3 CUTTING TOOL	 TOOL LENGTH MEASUREMENT BARS	 ADJUSTABLE ANGLE ICON	$\lambda_2$ $\lambda_1$ VARIABLE HELIX DRILL BIT
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MATERIAL COMPATIBILITY

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

MATERIAL	SPECIFICATION	GRP	28302A-1.5
<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)	1.5 mm
d (h5)	3 mm
L	38 mm
l	4 mm
l3	–
d3	–
R	–
e	–
Z	3
Chamfer K	–
w° collision	6.2°

