

E2

E2 HIGH PRECISION TOOL MATERIAL

$\lambda=20^\circ$

20° LAMBDA CUTTING ANGLE



V-GROOVE CHAMFER TOOL SHAPE

## MATERIAL COMPATIBILITY

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

MATERIAL	SPECIFICATION	GRP	48052-60-1
<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)	1 mm
d (h5)	3 mm
L	38 mm
l	1.5 mm
l3	–
d3	–
R	60 mm
e	0.15 mm
Z	2
Chamfer K	–
w° collision	10°

