

E2

E2 HIGH PRECISION TOOL MATERIAL

$\lambda=20^\circ$

20° LAMBDA CUTTING ANGLE



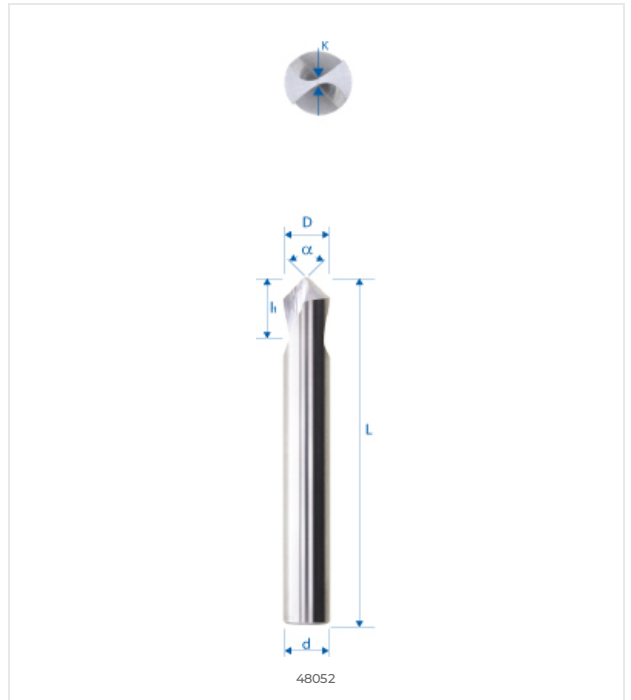
V-GROOVE CHAMFER TOOL SHAPE

MATERIAL COMPATIBILITY

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

MATERIAL	SPECIFICATION	GRP	48052-90-1
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 mm
d (h5)	3 mm
L	38 mm
l	1.5 mm
l3	–
d3	–
R	–
e	–
Z	2
Chamfer K	–
w° collision	10°

