

E2

E2 HIGH PRECISION TOOL MATERIAL

$\lambda=20^\circ$

20° LAMBDA CUTTING ANGLE

90°

90° RIGHT ANGLE DRILL BIT



TOOL LENGTH MEASUREMENT BARS



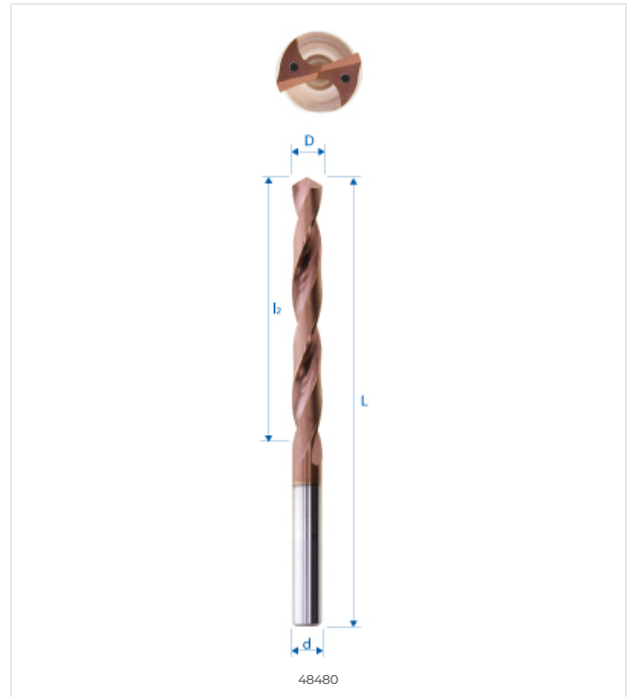
CENTRAL COOLANT DRILL BIT

MATERIAL COMPATIBILITY

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

| MATERIAL  | SPECIFICATION                | GRP | 48480S-5.1 |
|---|------------------------------|-----|------------|
| <b>Alloyed and non-alloyed steels</b><br>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><br>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><br>Hardened steels                   | 44–56 HRC                    | 3a  | ●○○        |
|   | 57–67 HRC                    | 3b  | ○○○        |
| <b>Exotic materials</b><br>Special alloys                   | < 32 HRC                     | 4a  | ●●●        |
|   | > 32 HRC                     | 4b  | ●●●        |
| <b>Graphite</b><br>Industrial graphite                      |                              | 5   | ●●●        |
| <b>Cast iron</b><br>Grey / nodular cast iron                | < 32 HRC                     | 6a  | ●●●        |
|   | > 32 HRC                     | 6b  | ●●●        |
| <b>Titanium</b><br>Titanium alloys                          | Rm < 600 N/mm <sup>2</sup>   | 7a  | ●●●        |
|   | 600 < Rm N/mm <sup>2</sup>   | 7b  | ●●●        |
| <b>Nickel alloys</b><br>Inconel, Hastelloy                  | Rm < 1000 N/mm <sup>2</sup>  | 8a  | ●●○        |
|   | Rm > 1000 N/mm <sup>2</sup>  | 8b  | ●●○        |
| <b>Copper, brass, bronze</b><br>Copper-based                | Rm < 850 N/mm <sup>2</sup>   | 9a  | ●●●        |
|   | Rm > 850 N/mm <sup>2</sup>   | 9b  | ●●●        |
| <b>Aluminum</b><br>Aluminum alloys                          | Si < 0.5%                    | 10a | ●●●        |
|   | 0.5% < Si < 5%               | 10b | ●●●        |
|   | Si > 5%                      | 10c | ●●●        |
| <b>Synthetic materials</b><br>Engineering plastics          | Thermoplastic                | 11a | ●●●        |
|   | Thermoset                    | 11b | ●●●        |
| <b>Composite materials</b><br>Reinforced composites         | Glass fiber / GFK            | 12a | ●●●        |
|   | Carbon fiber / KFK           | 12b | ●●●        |
| <b>Precious metals</b><br>Gold, platinum, silver            | Gold                         | 13a | ●●●        |
|   | Platinum                     | 13b | ●●○        |

TECHNICAL DRAWING



DIMENSIONS

NOMINAL DIMENSIONS

|               |        |
|---------------|--------|
| D (0 / -0.01) | 5.1 mm |
| d (h5)        | 6 mm   |
| L             | 82 mm  |
| l1            | 44 mm  |
| l3            | –      |
| d3            | –      |
| R             | –      |
| e             | –      |
| Z             | 2      |
| Chamfer K     | –      |
| w° collision  | 0.6°   |

