

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-7.7
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)	7.7 mm
d (h5)	8 mm
L	91 mm
l1	53 mm
l3	–
d3	–
R	–
e	–
Z	2
Chamfer K	–
w° collision	0.1°

