

E2

SUBMICRON GRAIN GRADE
HIGH-SPEED
MACHINING OF
ABRASIVE
MATERIALS

$\lambda=40^{\circ}-45^{\circ}$
 $\gamma=18^{\circ}$

VARIABLE HELIX
ANGLES 40° -
45° AND
CUTTING ANGLE
18°

$\phi \leq 6$ $\phi > 6$
90° 45°

SHARP EDGE
 $\phi \leq 6$ AND
CHAMFER AT 45°
 $\phi > 6$

SIDE AND
CENTER CUT

l_1
2.2xD

CUTTING EDGE
LENGTH 2.2xD

l_3

CUTTING
LENGTH

FITTING LENGTH
STANDARD

IRREGULAR
TOOTHING

λ_2
 λ_1

VARIABLE HELIX
ANGLES

MATERIAL COMPATIBILITY

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

Product material compatibility				
CATEGORY	MATERIAL	SPECIFICATION	GRP	21325-12
Alloyed and non-alloyed steels	Non-alloyed steels	Rm < 450 N/mm²	1a	○○○ 0/3
		Rm 450–700 N/mm²	1b	○○○ 0/3
		Rm 700–900 N/mm²	1c	○○○ 0/3
		Rm > 1200 N/mm²	1d	○○○ 0/3
Stainless steels	Stainless steels	Rm < 650 N/mm²	2a	○○○ 0/3
		Rm 650–950 N/mm²	2b	○○○ 0/3
		Rm > 950 N/mm²	2c	○○○ 0/3
Hardened steels	Hardened steels	44–56 HRC	3a	○○○ 0/3
		57–67 HRC	3b	○○○ 0/3
Exotic materials	Special alloys	< 32 HRC	4a	○○○ 0/3
		> 32 HRC	4b	○○○ 0/3
Graphite	Industrial graphite		5	●○○ 1/3
Cast iron	Grey / nodular cast iron	< 32 HRC	6a	○○○ 0/3
		> 32 HRC	6b	○○○ 0/3
Titanium	Titanium alloys	Rm < 600 N/mm²	7a	○○○ 0/3
		600 < Rm N/mm²	7b	○○○ 0/3
Nickel alloys	Inconel, Hastelloy	Rm < 1000 N/mm²	8a	○○○ 0/3
		Rm > 1000 N/mm²	8b	○○○ 0/3
Copper, brass, bronze	Copper-based	Rm < 850 N/mm²	9a	●●● 3/3
		Rm > 850 N/mm²	9b	●●● 3/3
Aluminum	Aluminum alloys	Si < 0.5%	10a	●●○ 2/3
		0.5% < Si < 5%	10b	●●○ 2/3
		Si > 5%	10c	○○○ 0/3
Synthetic materials	Engineering plastics	Thermoplastic	11a	●●● 3/3
		Thermoset	11b	●●● 3/3
Composite materials	Reinforced composites	Glass fiber / GFK	12a	●○○ 1/3
		Carbon fiber / KFK	12b	●○○ 1/3
Precious metals	Gold, platinum, silver	Gold	13a	●○○ 1/3
		Platinum	13b	○○○ 0/3

TECHNICAL DRAWING



DIMENSIONS

NOMINAL DIMENSIONS	
D (0 / -0.01)	12 mm
d (h5)	12 mm
L	83 mm
l1	26 mm
l3	37 mm
d3	–
R	–
e	–
Z	3
Chamfer K	0.1
w° collision angle	–

