

SCIE-CIRCULAIRE-DENTURE-FINE-MD-H1S · SLITTING-
SAW-FINE-PITCH-SC-H1S · KREISSÄGE-FEINVERZAHNT-
HM-H1S



SWISS MADE

25500-15-2 Version 10.09.2026

H1S

UNIVERSAL GRADE WITH GOOD WEAR RESISTANCE

$\lambda = 0^\circ$
 $\gamma = 6^\circ$

HELIX ANGLE 0° AND CUTTING ANGLE 6°

MATERIAL COMPATIBILITY

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

Product material compatibility

CATEGORY	MATERIAL	SPECIFICATION	GRP	25500-15-2
Alloyed and non-alloyed steels	Non-alloyed steels	Rm < 450 N/mm ²	1a	●○ 1/3
		Rm 450–700 N/mm ²	1b	●○ 1/3
		Rm 700–900 N/mm ²	1c	●○ 1/3
		Rm > 1200 N/mm ²	1d	●○ 1/3
Stainless steels	Stainless steels	Rm < 650 N/mm ²	2a	●○ 1/3
		Rm 650–950 N/mm ²	2b	●○ 1/3
		Rm > 950 N/mm ²	2c	●○ 1/3
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	●○ 1/3
		> 32 HRC	6b	●○ 1/3
Titanium	Titanium alloys	Rm < 600 N/mm ²	7a	●○ 1/3
		600 < Rm N/mm ²	7b	●○ 1/3
Nickel alloys	Inconel, Hastelloy	Rm < 1000 N/mm ²	8a	○○ 0/3
		Rm > 1000 N/mm ²	8b	○○ 0/3
Copper, brass, bronze	Copper-based	Rm < 850 N/mm ²	9a	●● 3/3
		Rm > 850 N/mm ²	9b	●● 3/3
Aluminum	Aluminum alloys	Si < 0.5%	10a	●● 2/3
		0.5% < Si < 5%	10b	●● 2/3
		Si > 5%	10c	●○ 1/3
Synthetic materials	Engineering plastics	Thermoplastic	11a	●● 2/3
		Thermoset	11b	●● 2/3
Composite materials	Reinforced composites	Glass fiber / GFK	12a	●○ 1/3
		Carbon fiber / KFK	12b	●○ 1/3
Precious metals	Gold, platinum, silver	Gold	13a	●● 3/3
		Platinum	13b	○○ 0/3

TECHNICAL DRAWING



DIMENSIONS

NOMINAL DIMENSIONS

D (0 / -0.01)	15 mm
d (h5)	5 mm
L	–
l1	–
l3	–
d3	–
R	–
e	2 mm
Z	40
Chamfer K	–
w° collision angle	–



E-SHOP / EZI CUT
eskenazi.ch/eshop/25500-15-2

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