

MICRO-FRAISE-D'ÉBAUCHE-AVEC-ARROSAGE-CENTRAL
· ROUGHING-MICRO-ENDMILL-WITH-INTERNAL-
COOLING · MIKROSCHRUPPFÄRER-MIT-
INNENKÜHLUNG



SWISS MADE

28525A-2.0 Version 10.09.2026

E2
SUBMICRON GRAIN GRADE
HIGH-SPEED
MACHINING OF
ABRASIVE
MATERIALS

$\lambda=45^{\circ}-47^{\circ}$
 $\gamma=15^{\circ}$
VARIABLE HELIX
ANGLES 45° -
 47° AND
CUTTING ANGLE
 15°

45°
CHAMFER AT 45°

SIDE AND
CENTER CUT

l_1
 $1.5 \times D$
CUTTING EDGE
LENGTH $1.5 \times D$

l_3
 $3 \times D$
CUTTING
LENGTH $3 \times D$

FITTING LENGTH
STANDARD

IRREGULAR
TOOTHING

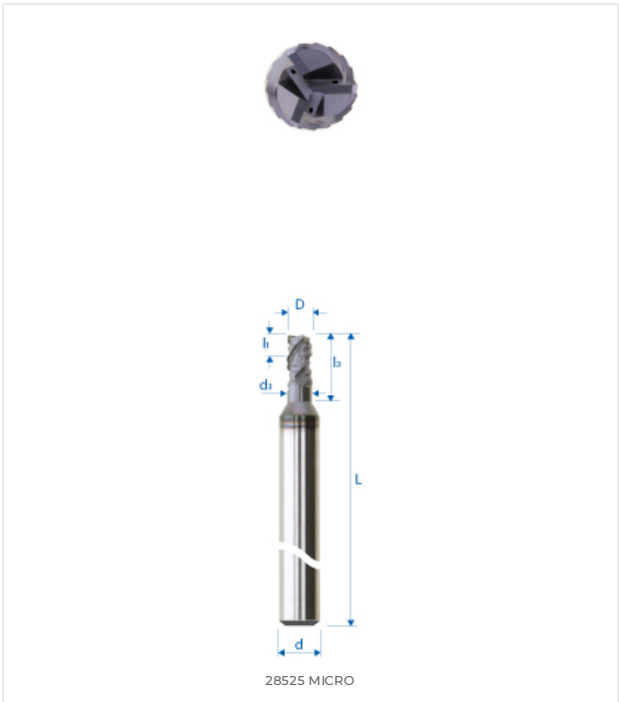
λ_2
 λ_1
VARIABLE HELIX
ANGLES

MATERIAL COMPATIBILITY

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

Product material compatibility				
CATEGORY	MATERIAL	SPECIFICATION	GRP	28525A-2.0
Alloyed and non-alloyed steels	Non-alloyed steels	$R_m < 450 \text{ N/mm}^2$	1a	●●● 3/3
		$R_m 450-700 \text{ N/mm}^2$	1b	●●● 3/3
		$R_m 700-900 \text{ N/mm}^2$	1c	●●● 3/3
		$R_m > 1200 \text{ N/mm}^2$	1d	●●○ 2/3
Stainless steels	Stainless steels	$R_m < 650 \text{ N/mm}^2$	2a	●●● 3/3
		$R_m 650-950 \text{ N/mm}^2$	2b	●●● 3/3
		$R_m > 950 \text{ N/mm}^2$	2c	●●● 3/3
Hardened steels	Hardened steels	44-56 HRC	3a	○○○ 0/3
		57-67 HRC	3b	○○○ 0/3
Exotic materials	Special alloys	$< 32 \text{ HRC}$	4a	●●○ 2/3
		$> 32 \text{ HRC}$	4b	●●○ 2/3
Graphite	Industrial graphite		5	●○○ 1/3
Cast iron	Grey / nodular cast iron	$< 32 \text{ HRC}$	6a	●●● 3/3
		$> 32 \text{ HRC}$	6b	●●● 3/3
Titanium	Titanium alloys	$R_m < 600 \text{ N/mm}^2$	7a	●●● 3/3
		$600 < R_m \text{ N/mm}^2$	7b	●●● 3/3
Nickel alloys	Inconel, Hastelloy	$R_m < 1000 \text{ N/mm}^2$	8a	●●○ 2/3
		$R_m > 1000 \text{ N/mm}^2$	8b	●●○ 2/3
Copper, brass, bronze	Copper-based	$R_m < 850 \text{ N/mm}^2$	9a	●●● 3/3
		$R_m > 850 \text{ N/mm}^2$	9b	●●● 3/3
Aluminum	Aluminum alloys	$Si < 0.5\%$	10a	○○○ 0/3
		$0.5\% < Si < 5\%$	10b	○○○ 0/3
		$Si > 5\%$	10c	○○○ 0/3
Synthetic materials	Engineering plastics	Thermoplastic	11a	○○○ 0/3
		Thermoset	11b	○○○ 0/3
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	●●○ 2/3

TECHNICAL DRAWING



DIMENSIONS

NOMINAL DIMENSIONS	
D (0 / -0.01)	2 mm
d (h5)	3 mm
L	38 mm
l1	3 mm
l3	6 mm
d3	—
R	—
e	—
Z	3
Chamfer K	0.15
w° collision angle	3.7°



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E-SHOP / E21001
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