

ECEF TECHNICAL SPECIFICATIONS

WOOD CUTTING TOOLS

FAMILY CLASSIFICATION	01010
DESCRIPTION	FORSTNER TYPE BITS FOR WOOD - TUNGSTEN CARBIDE CUTTING EDGES AND CARBIDE CENTER POINT - TOTAL LENGTH 90 mm
PRODUCT IMAGE	
KIND OF STEEL	C45 - EN 10083-2 INDEFORMABLE
COMPOSITION OF THE BODY	C 0,42-0,50 - Si ≤ 0,40 - Mn 0,50-0,80 - P ≤ 0.045 - S ≤ 0,045 - Cr ≤ 0,40 Ni ≤ 0,40 - Mo ≤ 0,10 -Cr+Mo+Ni ≤ 0,63 C=Carbon - Si=Silicon - Mn=Manganese - P=Phosphorus - S=Sulfur - Cr=Chrome - Mo=Molybdenum Ni=Nickel - Cu=Copper - Ti=Titanium - Al=Aluminium
KIND OF TEETH	TUNGSTEN CARBIDE H.M. ISO K20=Vickers 1710
TOOTHING WELDING	BRAZE TEC 5600 ISO 3677
HARDENING TEMP.	1100°
HARDNESS OF TEETH	78 HRC
SHANK	CYLINDRICAL
MANUFACTURING PROCESS	FULLY GROUND FROM THE SOLID, with CAO System, that grants quality control and product homogeneity.
SURFACE TREATMENT	Natural steel - milled - straight - smooth Black finish by steam oxydation of the head
WORK PIECE MATERIALS	LAMINATED CHIPBOARD - BEAMS - PLYWOOD - HARD WOOD - NATURAL WOOD - SOFT WOOD - DRYWALL - SANDWICH MATERIAL 
REFERENCE TOOL	Power drilling machines after disabling the percussion function; low speed and high pressure. 
PACKAGE	IN SINGLE PLASTIC BOX with hanger



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CUTTING SPEED CONVERSION TABLE - ROUND/MINUTE - DIAMETER				
diameter Ø		SOFT	HARD	SANDWICH
mm	inches	WOOD	WOOD	MATERIAL
14	9/16	1900	1600	1900
15	19/32	1900	1600	1900
16	5/8	1850	1550	1850
18	11/16	1800	1500	1800
20	3/4	1700	1400	1700
22	7/8	1600	1300	1600
24	15/16	1500	1200	1500
25	1"	1500	1200	1500
26	1"1/32	1400	1150	1400
28	1"1/8	1300	1050	1300
30	1"3/16	1200	1000	1200
32	1"1/4	1150	950	1150
34	1"11/32	1100	900	1100
35	1"3/8	1050	850	1050
36	1"27/64	1050	850	1050
38	1"1/2	1000	800	1000
40	1"9/16	900	750	900
42	1"21/32	850	750	850
45	1"3/4	850	750	850
48	1"7/8	800	700	800
50	2"	800	680	800

SECURITY ADVICE



Always use safety glasses



In case of high noise use hearing protection



Wear work gloves