

ECEF TECHNICAL SPECIFICATIONS

WOOD CUTTING TOOLS

FAMILY CLASSIFICATION	00870
DESCRIPTION	BRAD POINT WOODWORKING DRILLS - GROUND CENTER TIP AND 2 CUTTING EDGES
PRODUCT IMAGE	
KIND OF STEEL	C45 - EN 10083-2 INDEFORMABLE
COMPOSITION %	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
HARDENING TEMP.	1100°
HARDNESS	50 HRC
DIN	7487
KIND OF DRILL	RN right hand helix
SPIRAL ANGLE	15° - 25° WITH HIGH CHEAP EVACUATION GEOMETRY
SHANK	CYLINDRICAL
MANUFACTURING PROCESS	HOT ROLL-FORGING
SHARPENING	GROUND CENTERING TIP + 2 CUTTING EDGES 
SURFACE TREATMENT	External surface of the flute in natural steel color - milled - straight - smooth Inner flute with black finish by steam oxydation Corrosion protection, high temperature resistant
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 WALLET



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CUTTING SPEED CONVERSION TABLE - ROUND/MINUTE - DIAMETER				
diameter Ø		SOFT	HARD	SANDWICH
mm	inches	WOOD	WOOD	MATERIAL
3	1/8	1400	1200	1500
4	5/32	1400	1200	1500
5	3/16	1300	1150	1400
6	15/64	1300	1150	1400
6,5	1/4	1250	1100	1300
7	9/32	1250	1100	1300
8	5/16	1200	1000	1250
9	11/32	1200	1000	1250
10	3/8	1100	950	1200
11	7/16	1050	950	1200
12	15/32	1000	900	1150
13	1/2	1000	900	1150
14	9/16	950	850	1100
15	19/32	950	850	1100
16	5/8	900	800	1000
18	11/16	900	800	1000
20	3/4	850	750	900
22	7/8	850	750	900
24	15/16	850	750	900
26	1"1/32	800	700	850
28	1"1/8	800	700	850
30	1"3/16	800	700	850

SECURITY ADVICE



Always use safety glasses



In case of high noise use hearing protection



Wear work gloves