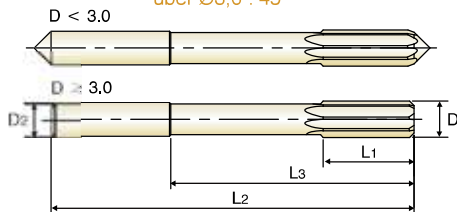


CARBIDE, NC MACHINE REAMERS - STRAIGHT FLUTES
Germany VHM, NC-MASCHINENREIBAHLEN - GERADEGENUTET
France ALÉSOIRS CARBURE MACHINE CN - ENTRÉE DROITE
Italy ALESATORI A MACCHINA IN MD - ELICA DRITTA

- ▶ Material - Up to Ø12.0 : Solid Carbide
- Over Ø12.0 : Carbide Head Brazed
- ▶ Straight Flutes, Right Hand Cut
- ▶ Unequal Flute Spacing
- ▶ O.D. Tolerances : DIN 1420 for H7
- ▶ Shank : DIN 6535-HA
- ▶ Chamfer Angle - $D < 3.0$: 15°
- $D \geq 3.0$: 45°

- ▶ Material - bis Ø12,0 : VHM
- über Ø12,0 : gelötete VHM-Köpfe
- ▶ geradegenutet, rechtsschneidend
- ▶ Ungleichteilung
- ▶ Ø Toleranzen : DIN 1420 für H7
- ▶ Schaft : DIN 6535-HA
- ▶ Anschnittwinkel - bis Ø3,0 : 15°
- über Ø3,0 : 45°



MG

H7

D < 3.0 D ≥ 3.0 P.1532



Unit : mm

EDP No.	Nominal SIZE	Shank Diameter	Cutting Length	Neck Length	Overall Length	No. of Flutes
	D1	D2	L1	L3	L2	
K410100200	2.0	4	11	20	50	4
K410100250	2.5	4	14	26	57	4
K410100300	3.0	4	15	31	61	6
K410100350	3.5	4	18	36	70	6
K410100400	4.0	4	19	42	75	6
K410100450	4.5	6	21	46	80	6
K410100500	5.0	6	23	51	86	6
K410100550	5.5	6	26	56	93	6
K410100600	6.0	6	26	56	93	6
K410100650	6.5	8	28	62	101	6
K410100700	7.0	8	31	68	109	6
K410100750	7.5	8	31	68	109	6
K410100800	8.0	8	33	74	117	6
K410100850	8.5	10	33	74	117	6
K410100900	9.0	10	36	80	125	6
K410100950	9.5	10	36	80	125	6
K410101000	10.0	10	38	86	133	6
K410101050	10.5	12	38	86	133	6
K410101100	11.0	12	41	95	142	6
K410101200	12.0	12	44	104	151	6
K410101300	13.0	16	44	104	151	6
K410101400	14.0	16	47	108	160	8
K410101500	15.0	16	50	110	162	8
K410101600	16.0	16	52	118	170	8
K410101700	17.0	20	54	121	175	8
K410101800	18.0	20	56	128	182	8
K410101900	19.0	20	58	129	189	8
K410102000	20.0	20	60	135	195	8

CARBIDE, NC MACHINE REAMER
VHM, NC-MASCHINENREIBAHLEN

Material	Cutting Speed (m/min.)	Feed(mm/rev.)				
		Up to Ø4	Ø4 ~ Ø8	Ø8 ~ Ø12	Ø12 ~ Ø16	Ø16 ~ Ø20
Structural and Low carbon steel	15~18	0.10~0.12	0.12~0.20	0.20~0.25	0.25~0.30	0.30~0.40
Carbon Steels < 500N/mm ²	15~18	0.10~0.12	0.12~0.20	0.20~0.25	0.25~0.30	0.30~0.40
Alloy Steels 500-1000N/mm ²	12~14	0.08~0.10	0.10~0.16	0.16~0.20	0.20~0.25	0.25~0.30
Hardened Steels ~ HRc40	10~12	0.08~0.10	0.10~0.16	0.16~0.20	0.20~0.25	0.25~0.30
Cast Iron < 200HB	15~20	0.10~0.12	0.12~0.20	0.20~0.25	0.25~0.30	0.30~0.40
> 200HB	12~15	0.10~0.12	0.12~0.20	0.20~0.25	0.25~0.30	0.30~0.40
Aluminium and Al-alloys	20~30	0.12~0.16	0.16~0.25	0.25~0.30	0.30~0.40	0.40~0.50
Magnesium alloys	20~30	0.10~0.12	0.12~0.20	0.20~0.25	0.25~0.30	0.30~0.40
Copper, Brass	20~25	0.10~0.12	0.12~0.20	0.20~0.25	0.25~0.30	0.30~0.40
Stainless Steels	6~8	0.08~0.10	0.10~0.16	0.16~0.20	0.20~0.25	0.25~0.30
Plastics	15~20	0.12~0.16	0.16~0.25	0.25~0.30	0.30~0.40	0.40~0.50

REAMING ALLOWANCE
REIB-ZUGABE

Size Range	Up to Ø6	Ø6 ~ Ø10	Ø10 ~ Ø16	Ø16 ~ Ø25	Over Ø25
Removal Amount	0.1 ~ 0.2	0.2 ~ 0.3	0.2 ~ 0.4	0.3 ~ 0.5	0.3 ~ 0.6

* For machine reaming
* Unit : mm