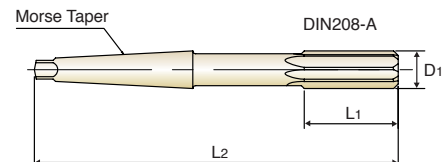


HSS-E, MORSE TAPER SHANK CHUCKING REAMERS - STRAIGHT FLUTES

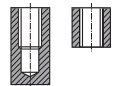
HSS-E, MASCHINENREIBAHLE mit MK - GERADEGENUTET

- ▶ O.D. Tolerances : DIN 1420 for H7
- ▶ Straight Flute / Right Hand Cut
- ▶ Chamfer Angle : 45°

- ▶ Schneiden-Ø Toleranzen : DIN 1420 für H7
- ▶ Geradegenutet / Rechtsschneiden†
- ▶ Anschnittwinkel : 45°



Hole type



Unit : mm

EDP No.	Nominal SIZE D1	No. of Morse Taper	Cutting Length L1	Overall Length L2	No. of Flutes
K210201000	10.0	1	38	168	6
K210201100	11.0	1	41	175	6
K210201200	12.0	1	44	182	6
K210201300	13.0	1	44	182	6
K210201400	14.0	1	47	189	8
K210201500	15.0	2	50	204	8
K210201600	16.0	2	52	210	8
K210201700	17.0	2	54	214	8
K210201800	18.0	2	56	219	8
K210201900	19.0	2	58	223	8
K210202000	20.0	2	60	228	8
K210202100	21.0	2	62	232	8
K210202200	22.0	2	64	237	8
K210202300	23.0	2	66	241	8
K210202400	24.0	3	68	268	8
K210202500	25.0	3	68	268	8
K210202600	26.0	3	70	273	8
K210202700	27.0	3	71	277	10
K210202800	28.0	3	71	277	10
K210202900	29.0	3	73	281	10
K210203000	30.0	3	73	281	10
K210203100	31.0	3	75	285	10
K210203200	32.0	4	77	317	10
K210203400	34.0	4	78	321	10
K210203500	35.0	4	78	321	10
K210203600	36.0	4	79	325	10
K210203800	38.0	4	81	329	10
K210204000	40.0	4	81	329	10
K210204100	41.0	4	82	333	12
K210204200	42.0	4	82	333	12
K210204300	43.0	4	83	336	12
K210204400	44.0	4	83	336	12
K210204500	45.0	4	83	336	12
K210204600	46.0	4	84	340	12
K210204700	47.0	4	84	340	12
K210204800	48.0	4	86	344	12
K210205000	50.0	4	86	344	12

HSS-E, STRAIGHT & LH SPIRAL FLUTE CHUCKING REAMER, NC MACHINE REAMER
HSS-E, GERADEGENUTETE MASCHINENREIBAHLEN, SPIRALGENUTETE MASCHINENREIBAHLEN

Material	Cutting Speed (m/min.)	Feed(mm/rev.)					
		Ø2 ~ Ø4	Ø4 ~ Ø8	Ø8 ~ Ø13	Ø13 ~ Ø20	Ø20 ~ Ø30	> Ø30
Steels < 500N/mm ²	12 ~ 16	0.05~0.15	0.10~0.20	0.15~0.25	0.20~0.30	0.25~0.40	0.35~0.50
Steels 500-700N/mm ²	10 ~ 12	0.05~0.15	0.10~0.20	0.15~0.25	0.20~0.30	0.25~0.40	0.35~0.50
Steels 700-800N/mm ²	6 ~ 8	0.05~0.10	0.08~0.16	0.10~0.20	0.15~0.25	0.20~0.30	0.30~0.40
Alloy Steel or Carbon Steel castings < 500N/mm ²	6 ~ 10	0.05~0.10	0.08~0.16	0.10~0.20	0.15~0.25	0.20~0.30	0.30~0.40
Alloy Steel or Carbon Steel castings > 500N/mm ²	4 ~ 6	0.05~0.10	0.08~0.16	0.10~0.20	0.15~0.25	0.20~0.30	0.30~0.40
Alloy Steel or Carbon Steel forgings	4 ~ 6	0.03~0.08	0.06~0.10	0.08~0.15	0.10~0.20	0.15~0.25	0.20~0.30
Cast Iron < 200HB	12 ~ 14	0.05~0.15	0.10~0.20	0.15~0.25	0.20~0.30	0.25~0.40	0.35~0.50
Cast Iron > 200HB	10 ~ 12	0.05~0.10	0.08~0.16	0.10~0.20	0.15~0.25	0.20~0.30	0.30~0.40
Aluminum or Aluminum Alloy	16 ~ 20	0.10~0.20	0.15~0.25	0.20~0.30	0.25~0.40	0.35~0.50	0.40~0.60
Magnesium or Magnesium Alloy	10 ~ 16	0.10~0.20	0.15~0.25	0.20~0.30	0.25~0.40	0.35~0.50	0.40~0.60
Copper, Brass	16 ~ 18	0.10~0.20	0.15~0.25	0.20~0.30	0.25~0.40	0.35~0.50	0.40~0.60
Stainless Steels	4 ~ 6	0.03~0.08	0.06~0.10	0.08~0.15	0.10~0.20	0.15~0.25	0.20~0.30
Plastics	8 ~ 12	0.10~0.20	0.20~0.30	0.30~0.40	0.40~0.50	0.50~0.60	0.60~0.80

HSS-E, CHUCKING REAMER-QUICK SPIRAL
HSS-E, MASCHINEN - SCHÄLREIBAHLEN

Material	Cutting Speed (m/min.)	Feed(mm/rev.)			
		Ø2 ~ Ø4	Ø4 ~ Ø8	Ø8 ~ Ø13	Ø13 ~ Ø20
Steels < 500N/mm ²	16 ~ 18	0.08~0.16	0.16~0.25	0.20~0.30	0.30~0.40
Steels 500-700N/mm ²	14 ~ 16	0.08~0.16	0.16~0.25	0.20~0.30	0.30~0.40
Aluminum or Aluminum Alloy	18 ~ 22	0.10~0.20	0.20~0.30	0.30~0.40	0.40~0.60
Magnesium or Magnesium Alloy	10 ~ 16	0.08~0.16	0.16~0.25	0.20~0.30	0.30~0.40
Copper, Brass	16 ~ 20	0.08~0.16	0.16~0.25	0.20~0.30	0.30~0.40
Plastics	12 ~ 14	0.10~0.20	0.20~0.30	0.30~0.40	0.40~0.60