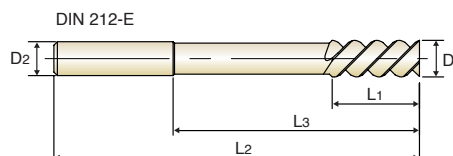


HSS-E, STRAIGHT SHANK CHUCKING REAMERS - LH SPIRAL FLUTES(QUICK SPIRAL)
HSS-E, MASCHINEN - SCHÄLREIBAHLE mit ZYLINDERSCHAFT - SPIRALGENUTET mit LINKSDRAL

- ▶ O.D. Tolerances : DIN 1420 for H7
- ▶ Shank Diameter Tolerances : h8
- ▶ Chamfer Angle - tapered
- ▶ LH High Spiral Flutes / Right Hand Cut

- ▶ Schneiden-Ø Toleranzen : DIN 1420 für H7
- ▶ Schaft-Ø Toleranzen : h8
- ▶ Anschnittwinkel - Konisch
- ▶ Spiralgenutet mit Linksdral / Rechtsschneident



HSS-E
DIN 212
H7
LH45°
FORM E
1327

Hole type

Unit : mm
Unit : mm

| EDP No. | Nominal SIZE | Shank Diameter | Cutting Length | Neck Length | Overall Length | No. of Flutes |
|------------|--------------|----------------|----------------|-------------|----------------|---------------|
| | D1 | D2 | L1 | L3 | L2 | |
| K212100400 | 4.0 | 4 | 19 | 42 | 75 | 3 |
| K212100450 | 4.5 | 4.5 | 21 | 46 | 80 | 3 |
| K212100500 | 5.0 | 5 | 23 | 51 | 86 | 3 |
| K212100550 | 5.5 | 5.6 | 26 | 56 | 93 | 3 |
| K212100600 | 6.0 | 5.6 | 26 | 56 | 93 | 3 |
| K212100650 | 6.5 | 6.3 | 28 | 62 | 101 | 3 |
| K212100700 | 7.0 | 7.1 | 31 | 68 | 109 | 3 |
| K212100800 | 8.0 | 8 | 33 | 74 | 117 | 3 |
| K212100850 | 8.5 | 8 | 33 | 74 | 117 | 3 |
| K212100900 | 9.0 | 9 | 36 | 80 | 125 | 3 |
| K212100950 | 9.5 | 9 | 36 | 80 | 125 | 3 |
| K212101000 | 10.0 | 10 | 38 | 86 | 133 | 3 |
| K212101100 | 11.0 | 10 | 41 | 95 | 142 | 3 |
| K212101200 | 12.0 | 10 | 44 | 104 | 151 | 3 |
| K212101300 | 13.0 | 10 | 44 | 104 | 151 | 3 |
| K212101400 | 14.0 | 12.5 | 47 | 108 | 160 | 4 |
| K212101500 | 15.0 | 12.5 | 50 | 110 | 162 | 4 |
| K212101600 | 16.0 | 12.5 | 52 | 118 | 170 | 4 |
| K212101700 | 17.0 | 14 | 54 | 121 | 175 | 4 |
| K212101800 | 18.0 | 14 | 56 | 128 | 182 | 4 |
| K212101900 | 19.0 | 16 | 58 | 129 | 189 | 4 |
| K212102000 | 20.0 | 16 | 60 | 135 | 195 | 4 |

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 |