



Leading Through Innovation

CARBIDE, HSS & HSS-E

REAMERS

REIBAHLEN

- Carbide NC Machine Reamers
HSS Hand Reamers, HSS-E Chucking Reamers
- Hartmetall NC Maschinenreibahlen
HSS-Handreibahlen, HSS-E Spannfutter-Reibahlen

Carbide NC Machine Reamers
HSS Hand Reamers
HSS-E Chucking Reamers

◎ : Excellent ○ : Good

Recommended cutting conditions : p.A387

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRc					
P	1	Non-alloy steel	About 0.15% C	Annealed	125		⊙		⊙		
	2		About 0.45% C	Annealed	190	13	⊙		⊙		
	3		About 0.45% C	Quenched & Tempered	250	25	⊙		⊙		
	4		About 0.75% C	Annealed	270	28	○		○		
	5		About 0.75% C	Quenched & Tempered	300	32	○		○		
	6	Low alloy steel		Annealed	180	10	⊙		⊙		
	7			Quenched & Tempered	275	29	⊙		⊙		
	8			Quenched & Tempered	300	32	○		○		
	9			Quenched & Tempered	350	38					
	10	High alloyed steel, and tool steel		Annealed	200	15	○		○		
	11			Quenched & Tempered	325	35					
M	12	Stainless steel	Ferritic / Martensitic	Annealed	200	15	○		○		
	13		Martensitic	Quenched & Tempered	240	23	○		○		
	14		Austenitic		180	10	○		○		
K	15	Grey cast iron	Pearlitic / ferritic		180	10	⊙		⊙		
	16		Pearlitic (Martensitic)		260	26	○		○		
	17	Nodular cast iron	Ferritic		160	3	⊙		⊙		
	18		Pearlitic		250	25	○		○		
	19	Malleable cast iron	Ferritic		130		⊙		⊙		
	20		Pearlitic		230	21	○		○		
N	21	Aluminum-wrought alloy	Not Curable		60		○		○		
	22		Curable	Hardened	100		○		○		
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75		○		○		
	24		≤ 12% Si, Curable	Hardened	90		○		○		
	25		> 12% Si, Not Curable		130						
	26	Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%		110		○		○		
	27		CuZn, CuSnZn (Brass)		90		○		○		
	28		CuSn, lead-free copper and electrolytic copper		100		○		○		
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic								
	30		Rubber, Wood, etc.								
S	31	Heat Resistant Super Alloys	Fe Based	Annealed	200	15					
	32			Cured	280	30					
	33			Annealed	250	25					
	34		Ni or Co Based	Cured	350	38					
	35			Cast	320	34					
	36	Titanium Alloys	Pure Titanium		400 Rm						
	37		Alpha + Beta Alloys	Hardened	1050 Rm						
H	38	Hardened steel		Hardened	550	55					
	39			Hardened	630	60					
	40	Chilled Cast Iron		Cast	400	42					
	41	Hardened Cast Iron		Hardened	550	55					

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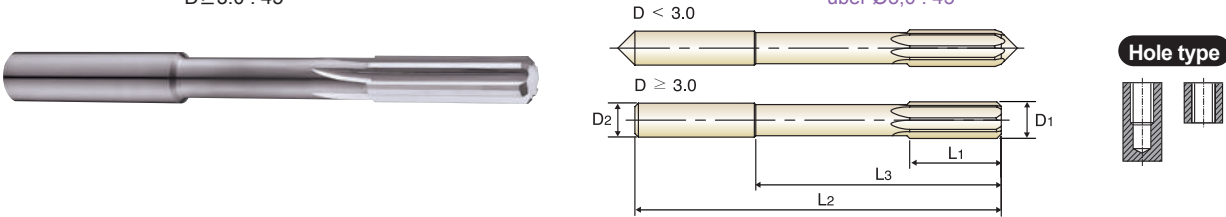
K4101 SERIES

CARBIDE, NC MACHINE REAMERS - STRAIGHT FLUTES

- VHM, NC-MASCHINENREIBAHLEN - GERADEGENUTET
- ALÉSOIRS CARBURE MACHINE CN - ENTRÉE DROITE
- ALESATORI A MACCHINA IN MD - ELICA DRIITA

- ▶ 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≥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°



D<3.0 D≥3.0

Unit : mm

EDP No.	Reamer Diameter	Shank Diameter	Cutting Length	Neck Length	Overall Length	No. of Flute
	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
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

◎ : Excellent ○ : Good

ISO	P										M				K								
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron				
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20			
HRC																							
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230			
Recommended	◎	◎	◎	○	○	◎	◎	○	○	○	○	○	○	○	◎	○	◎	○	◎	○			
ISO	N										S						H						
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41		
HRC																							
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550		
Recommended	○	○	○	○	○	○	○	○															

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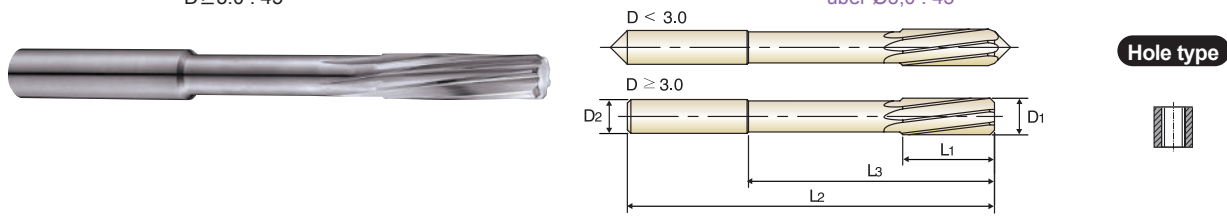
K4111 SERIES

CARBIDE, NC MACHINE REAMERS - LH SPIRAL FLUTES

- VHM, NC-MASCHINENREIBAHLEN - SPIRALGENUTET mit LINKSDRALL
- ALÉSOIRS CARBURE MACHINE CN - HÉLICE À GAUCHE
- ALESATORI A MACCHINA IN MD - ELICA SINISTRA

- ▶ Material - Up to Ø12.0 : Solid Carbide
- Over Ø12.0 : Carbide Head Brazed
- ▶ Left Spiral 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≥3.0 : 45°

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



D<3.0 D≥3.0

Unit : mm

EDP No.	Reamer Diameter	Shank Diameter	Cutting Length	Neck Length	Overall Length	No. of Flute
	D1	D2	L1	L3	L2	
K411100200	2.0	4	11	20	50	4
K411100250	2.5	4	14	26	57	4
K411100300	3.0	4	15	31	61	6
K411100350	3.5	4	18	36	70	6
K411100400	4.0	4	19	42	75	6
K411100450	4.5	6	21	46	80	6
K411100500	5.0	6	23	51	86	6
K411100550	5.5	6	26	56	93	6
K411100600	6.0	6	26	56	93	6
K411100650	6.5	8	28	62	101	6
K411100700	7.0	8	31	68	109	6
K411100750	7.5	8	31	68	109	6
K411100800	8.0	8	33	74	117	6
K411100900	9.0	10	36	80	125	6
K411100950	9.5	10	36	80	125	6
K411101000	10.0	10	38	86	133	6
K411101050	10.5	12	38	86	133	6
K411101100	11.0	12	41	95	142	6
K411101200	12.0	12	44	104	151	6
K411101400	14.0	16	47	108	160	8
K411101600	16.0	16	52	118	170	8
K411101700	17.0	20	54	121	175	8
K411101800	18.0	20	56	128	182	8
K411101900	19.0	20	58	129	189	8
K411102000	20.0	20	60	135	195	8

◎ : Excellent ○ : Good

ISO	P										M				K								
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron				
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20			
HRC		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25					
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230			
Recommended	◎	◎	◎	○	○	◎	◎	○	○	○	○	○	○	○	◎	○	◎	○	◎	○			
ISO	N										S						H						
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)				Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41		
HRC											15	30	25	38	34			55	60	42	55		
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550		
Recommended	○	○	○	○		○	○	○															

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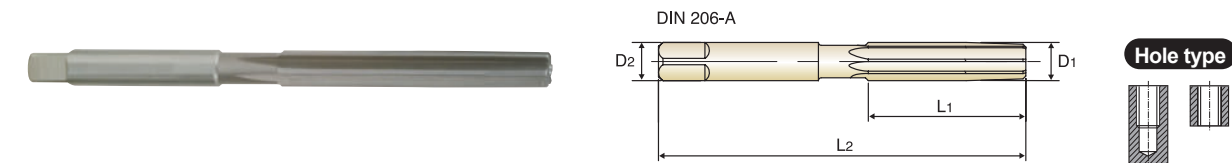
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A367

HSS, HAND REAMERS - STRAIGHT FLUTES

🇪🇺 HSS, HANDREIBAHLEN - GERADEGENUTET
🇫🇷 ALÉSOIRS HSS À MAIN - HÉLICE À GAUCHE
🇮🇹 ALESATORI A MANO IN HSS - ELICA SINISTRA

- ▶ O.D. Tolerances : DIN 1420 for H7
▶ Shank Diameter ≈ Nominal Reamer Diameter
▶ Straight Flutes / Right Hand Cut
▶ Chamfer Angle- tapered
▶ Type of center - Up to Ø3.75 : external centers
- Over Ø3.75 : internal centers
- ▶ Schneiden-Ø Toleranzen : DIN 1420 für H7
▶ Schaft-Ø = Nomineller Reibahlen-Ø
▶ Geradenutet / Rechtsschneidend
▶ Anschnittwinkel - Konisch
▶ Zentrierungsart - bis Ø3,75 mm : Zentrierungszapfen
- über Ø3,75 mm : Zentrierung



HSS DIN 206 H7 Bright

D1=D2

EDP No.	Reamer Diameter	Flute Length	Overall Length	No. of Flute
	D	L1	L2	
K114300200	2.0	25	50	4
K114300220	2.2	27	54	4
K114300250	2.5	29	58	4
K114300280	2.8	31	62	4
K114300300	3.0	31	62	6
K114300350	3.5	35	71	6
K114300400	4.0	38	76	6
K114300450	4.5	41	81	6
K114300500	5.0	44	87	6
K114300550	5.5	47	93	6
K114300600	6.0	47	93	6
K114300700	7.0	54	107	6
K114300800	8.0	58	115	6
K114300900	9.0	62	124	6
K114301000	10.0	66	133	6
K114301100	11.0	71	142	6
K114301200	12.0	76	152	6
K114301400	14.0	81	163	8
K114301500	15.0	81	163	8
K114301600	16.0	87	175	8
K114301700	17.0	87	175	8
K114301800	18.0	93	188	8
K114301900	19.0	93	188	8
K114302000	20.0	100	201	8
K114302200	22.0	107	215	8
K114302400	24.0	115	231	8

▶ NEXT PAGE

ISO	P														M				K									
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel				Grey cast iron		Nodular cast iron		Malleable cast iron							
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20								
HRC		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21								
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230								
Recommended	○	○				○																						
ISO	N										S						H											
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron							
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41							
HRC											15	30	25	38	34			55	60	42	55							
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550							
Recommended	○	○	○	○		○	○	○																				

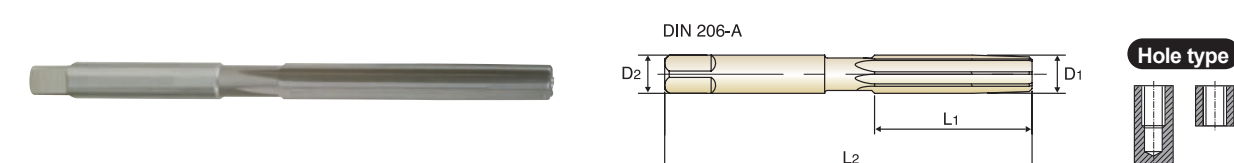
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HSS, HAND REAMERS - STRAIGHT FLUTES

🇪🇺 HSS, HANDREIBAHLEN - GERADEGENUTET
🇫🇷 ALÉSOIRS HSS À MAIN - ENTRÉE DROITE
🇮🇹 ALESATORI A MANO IN HSS - ELICA DRITTA

- ▶ O.D. Tolerances : DIN 1420 for H7
▶ Shank Diameter ≈ Nominal Reamer Diameter
▶ Straight Flutes / Right Hand Cut
▶ Chamfer Angle- tapered
▶ Type of center - Up to Ø3.75 : external centers
- Over Ø3.75 : internal centers
- ▶ Schneiden-Ø Toleranzen : DIN 1420 für H7
▶ Schaft-Ø = Nomineller Reibahlen-Ø
▶ Geradenutet / Rechtsschneidend
▶ Anschnittwinkel - Konisch
▶ Zentrierungsart - bis Ø3,75 mm : Zentrierungszapfen
- über Ø3,75 mm : Zentrierung



HSS DIN 206 H7 Bright

D1=D2

EDP No.	Reamer Diameter	Flute Length	Overall Length	No. of Flute
	D	L1	L2	
K114302500	25.0	115	231	8
K114302600	26.0	115	231	8
K114302700	27.0	124	247	10
K114302800	28.0	124	247	10
K114303000	30.0	124	247	10
K114303100	31.0	133	265	10
K114303200	32.0	133	265	10
K114303300	33.0	133	265	10
K114303400	34.0	142	284	10
K114303500	35.0	142	284	10
K114303600	36.0	142	284	10
K114303700	37.0	142	284	10
K114303800	38.0	152	305	10
K114303810	38.1	152	305	10
K114303900	39.0	152	305	10
K114304000	40.0	152	305	10
K114304100	41.0	152	305	12
K114304200	42.0	152	305	12
K114304300	43.0	163	326	12
K114304400	44.0	163	326	12
K114304500	45.0	163	326	12
K114304600	46.0	163	326	12
K114304700	47.0	163	326	12
K114304800	48.0	174	347	12
K114304900	49.0	174	347	12
K114305200	52.0	174	347	12
K114306000	60.0	184	367	12

◎ : Excellent ○ : Good																				
ISO	P										M				K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRC		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	○	○				○														
ISO	N										S						H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HRC											15	30	25	38	34	36	37	55	60	42
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400
Recommended	○	○	○	○		○	○	○												

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A369

i-ONE
DRILLS

i-DREAM
DRILLS

DREAM
DRILLS
-PRO

DREAM
DRILLS
X

DREAM
DRILLS
-GENERAL

DREAM
DRILLS
-HIGH FEED

DREAM
DRILLS
-FLAT BOTTOM

DREAM
DRILLS
-INOX

DREAM
DRILLS
-ALU

DREAM
DRILLS
-MQL

DREAM DRILLS
for HIGH
HARDENED STEELS

GENERAL
CARBIDE
DRILLS

MULTI-1
DRILLS

HPD
DRILLS

GOLD-P
DRILLS

SUPER-GP
DRILLS

STRAIGHT
SHANK
DRILLS

TAPER SHANK
DRILLS

NC-
SPOTTING
DRILLS

CENTER
DRILLS

SPADE
DRILLS

REAMERS

COUNTER
SINKS

COUNTER
BORES

HSS, HAND REAMERS - LH SPIRAL FLUTES

ALÉSOIRS HSS À MAIN - HÉLICE À GAUCHE

ALESATORI A MANO IN HSS - ELICA SINISTRA

i-ONE
DRILLS

i-DREAM
DRILLS

DREAM
DRILLS
-PRO

DREAM
DRILLS
X

DREAM
DRILLS
-GENERAL

DREAM
DRILLS
-HIGH FEED

DREAM
DRILLS
-FLAT BOTTOM

DREAM
DRILLS
-INOX

DREAM
DRILLS
-ALU

DREAM
DRILLS
-MQL

DREAM DRILLS
for HIGH
HARDENED STEELS

GENERAL
CARBIDE
DRILLS

MULTI-1
DRILLS

HPD
DRILLS

GOLD-P
DRILLS

SUPER-GP
DRILLS

STRAIGHT
SHANK
DRILLS

TAPER SHANK
DRILLS

NC-
SPOTTING
DRILLS

CENTER
DRILLS

SPADE
DRILLS

REAMERS

COUNTER
SINKS

COUNTER
BORES

HSS, HAND REAMERS - LH SPIRAL FLUTES

ALÉSOIRS HSS À MAIN - HÉLICE À GAUCHE

ALESATORI A MANO IN HSS - ELICA SINISTRA

- O.D. Tolerances : DIN 1420, H7

► Shank Diameter ≙ Nominal Reamer Diameter

► LH Spiral Flutes / Right Hand Cut

► Chamfer Angle- tapered

► Type of center - Up to Ø3.75 : external centers

- Over Ø3.75 : internal centers
- Schneiden-Ø Toleranzen : DIN 1420 für H7

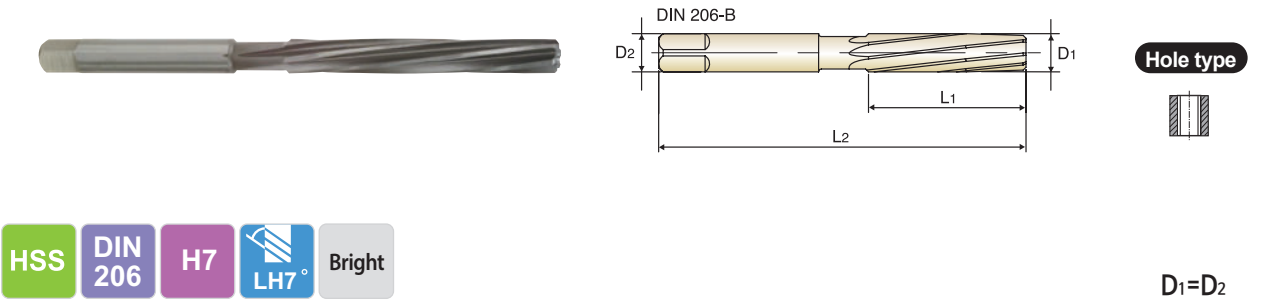
► Schaft-Ø = Nomineller Reibahlen-Ø

► Spiralgenutet mit Linksdrahl / Rechtsschneidend

► Anschnittwinkel - Konisch

► Zentrierungsart - bis Ø3,75 mm : Zentrierungszapfen

- über Ø3,75 mm : Zentrierung



EDP No.	Reamer Diameter	Flute Length	Overall Length	No. of Flute
	D	L1	L2	
K115302500	25.0	115	231	8
K115302600	26.0	115	231	8
K115302700	27.0	124	247	10
K115302800	28.0	124	247	10
K115302900	29.0	124	247	10
K115303000	30.0	124	247	10
K115303100	31.0	133	265	10
K115303200	32.0	133	265	10
K115303300	33.0	133	265	10
K115303400	34.0	142	284	10
K115303500	35.0	142	284	10
K115303810	38.1	152	305	10
K115303900	39.0	152	305	10
K115304100	41.0	152	305	12
K115304200	42.0	152	305	12
K115304300	43.0	163	326	12
K115304500	45.0	163	326	12
K115304600	46.0	163	326	12
K115304700	47.0	163	326	12
K115304800	48.0	174	347	12
K115304900	49.0	174	347	12
K115305200	52.0	174	347	12

ISO	P											M			K								
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron				
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20			
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21			
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230			
Recommended	○	○				○																	
ISO	N										S						H						
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41		
HRc											15	30	25	38	34			55	60	42	55		
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550		
Recommended	○	○	○	○		○	○	○															

◎ : Excellent ○ : Good																							
ISO	P										M				K								
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron				
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20			
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21			
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230			
Recommended	○	○				○																	
ISO	N										S										H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron			
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41		
HRc											15	30	25	38	34	36	37	55	60	42	55		
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550		
Recommended	○	○	○	○		○	○	○															

HSS-E, MASCHINENREIBAHLE mit ZYLINDERSCHAFT - GERADEGENUTET

ALÉSOIRS HSS-E MACHINE DROIT- ENTRÉE DROITE

ALESATORI IN HSS-E, ATTACCO CILINDRICO - ELICA DRIITA

HSS-E, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTES

HSS-E, MASCHINENREIBAHLE mit ZYLINDERSCHAFT - GERADEGENUTET

ALÉSOIRS HSS-E MACHINE DROIT- ENTRÉE DROITE

ALESATORI IN HSS-E, ATTACCO CILINDRICO - ELICA DRIITA

HSS-E, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTES

► O.D. Tolerances : DIN 1420 for H7

► Shank Diameter Tolerances : h8

► Straight Flute / Right Hand Cut

► Chamfer Angle - Up to Ø3.75 : 15°

- Over Ø3.75 : 45°

► Schneiden-Ø Toleranzen : DIN 1420 für H7

► Schaft-Ø Toleranzen : h8

► Geradegenutet / Rechtsschneidend

► Anschnittwinkel - bis Ø3,75 mm : 15°

- über Ø3,75 mm : 45°

► O.D. Tolerances : DIN 1420 for H7

► Shank Diameter Tolerances : h8

► Straight Flute / Right Hand Cut

► Chamfer Angle - Up to Ø3.75 : 15°

- Over Ø3.75 : 45°

► Schneiden-Ø Toleranzen : DIN 1420 für H7

► Schaft-Ø Toleranzen : h8

► Geradegenutet / Rechtsschneidend

► Anschnittwinkel - bis Ø3,75 mm : 15°

- über Ø3,75 mm : 45°

Hole type

HSS-E

DIN 212

H7

Bright

p.A388

up to Ø3.75 over Ø3.75

Unit : mm

Hole type

HSS-E

DIN 212

H7

Bright

p.A388

up to Ø3.75 over Ø3.75

Unit : mm

EDP No.	Reamer Diameter	Shank Diameter	Cutting Length	Neck Length	Overall Length	No. of Flute
	D1	D2	L1	L3	L2	
K210100220	2.2	2.2	12	-	53	4
K210100250	2.5	2.5	14	-	57	4
K210100260	2.6	2.6	14	-	57	4
K210100280	2.8	2.8	15	-	61	4
K210100300	3.0	3	15	-	61	6
K210100320	3.2	3.2	16	-	65	6
K210100360	3.6	3.6	18	-	70	6
K210100370	3.7	3.7	18	-	70	6
K210100400	4.0	4	19	42	75	6
K210100430	4.3	4.5	21	46	80	6
K210100450	4.5	4.5	21	46	80	6
K210100460	4.6	4.5	21	46	80	6
K210100500	5.0	5	23	51	86	6
K210100550	5.5	5.6	26	56	93	6
K210100560	5.6	5.6	26	56	93	6
K210100600	6.0	5.6	26	56	93	6
K210100650	6.5	6.3	28	62	101	6
K210100700	7.0	7.1	31	68	109	6
K210100720	7.2	7.1	31	68	109	6
K210100800	8.0	8	33	74	117	6
K210100830	8.3	8	33	74	117	6
K210100850	8.5	8	33	74	117	6
K210100900	9.0	9	36	80	125	6

EDP No.	Reamer Diameter	Shank Diameter	Cutting Length	Neck Length	Overall Length	No. of Flute
	D1	D2	L1	L3	L2	
K210100950	9.5	9	36	80	125	6
K210101000	10.0	10	38	86	133	6
K210101050	10.5	10	38	86	133	6
K210101100	11.0	10	41	95	142	6
K210101200	12.0	10	44	104	151	6
K210101300	13.0	10	44	104	151	6
K210101400	14.0	12.5	47	108	160	8
K210101500	15.0	12.5	50	110	162	8
K210101600	16.0	12.5	52	118	170	8
K210101700	17.0	14	54	121	175	8
K210101800	18.0	14	56	128	182	8
K210102000	20.0	16	60	135	195	8

ISO	P										M			K							
	Non-alloy steel					Low alloy steel					Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron			
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRC	125	13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21		
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	○	○		◎	○			○	○	○	○	○	○	○	○	○	○	○	
ISO	N										S					H					
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron	
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRC	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	○	○	○	○		○	○	○													

ISO	P										M			K							
	Non-alloy steel					Low alloy steel					Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron			
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRC	125	13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21		
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	○	○		◎	○			○	○	○	○	○	○	○	○	○	○	○	
ISO	N										S					H					
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron	
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRC	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	○	○	○	○		○	○	○													

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HSS-E, STRAIGHT SHANK CHUCKING REAMERS - LH SPIRAL FLUTES

🇪🇺 HSS-E, MASCHINENREIBAHLE mit ZYLINDERSCHAFT - SPIRALGENUTET mit LINKSDRALL
🇫🇷 ALÉSOIRS HSS-E MACHINE DROIT- HÉLICE À GAUCHE
🇮🇹 ALESATORI IN HSS-E, ATTACCO CILINDRICO - ELICA SINISTRA

- ▶ O.D. Tolerances : DIN 1420 for H7

▶ Shank Diameter Tolerances : h8

▶ LH Spiral Flutes / Right Hand Cut

▶ Chamfer Angle - Up to Ø3.75 : 15°

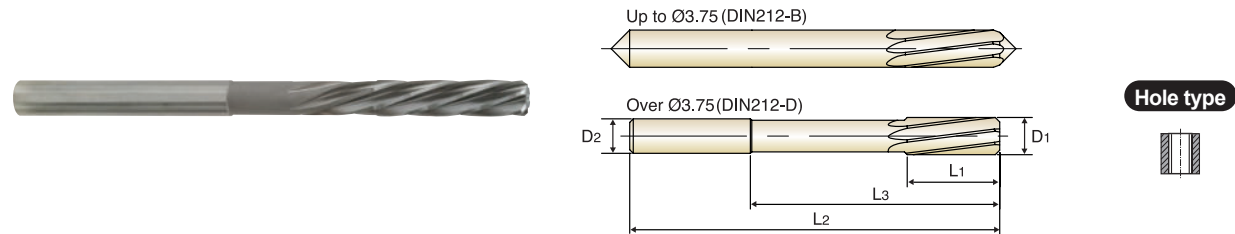
- Over Ø3.75 : 45°
- ▶ Schneiden-Ø Toleranzen : DIN 1420 für H7

▶ Schaft-Ø Toleranzen : h8

▶ Spiralgenutet mit Linksdrahl / Rechtsschneidend

▶ Anschnittwinkel - bis Ø3,75 mm : 15°

- über Ø3,75 mm : 45°



EDP No.	Reamer Diameter	Shank Diameter	Cutting Length	Neck Length	Overall Length	No. of Flute
	D1	D2	L1	L3	L2	
K211100200	2.0	2	11	-	49	4
K211100220	2.2	2.2	12	-	53	4
K211100250	2.5	2.5	14	-	57	4
K211100260	2.6	2.6	14	-	57	4
K211100280	2.8	2.8	15	-	61	4
K211100300	3.0	3	15	-	61	6
K211100310	3.1	3.1	16	-	65	6
K211100320	3.2	3.2	16	-	65	6
K211100350	3.5	3.5	18	-	70	6
K211100360	3.6	3.6	18	-	70	6
K211100400	4.0	4	19	42	75	6
K211100430	4.3	4.5	21	46	80	6
K211100450	4.5	4.5	21	46	80	6
K211100500	5.0	5	23	51	86	6
K211100550	5.5	5.6	26	56	93	6
K211100560	5.6	5.6	26	56	93	6
K211100600	6.0	5.6	26	56	93	6
K211100650	6.5	6.3	28	62	101	6
K211100700	7.0	7.1	31	68	109	6
K211100720	7.2	7.1	31	68	109	6
K211100800	8.0	8	33	74	117	6

▶ NEXT PAGE

HSS-E, STRAIGHT SHANK CHUCKING REAMERS - LH SPIRAL FLUTES

🇪🇺 HSS-E, MASCHINENREIBAHLE mit ZYLINDERSCHAFT - SPIRALGENUTET mit LINKSDRALL
🇫🇷 ALÉSOIRS HSS-E MACHINE DROIT- HÉLICE À GAUCHE
🇮🇹 ALESATORI IN HSS-E, ATTACCO CILINDRICO - ELICA SINISTRA

- ▶ O.D. Tolerances : DIN 1420 for H7

▶ Shank Diameter Tolerances : h8

▶ LH Spiral Flutes / Right Hand Cut

▶ Chamfer Angle - Up to Ø3.75 : 15°

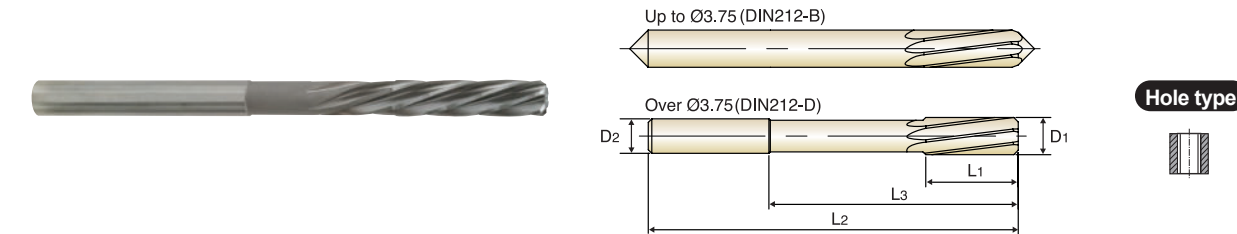
- Over Ø3.75 : 45°
- ▶ Schneiden-Ø Toleranzen : DIN 1420 für H7

▶ Schaft-Ø Toleranzen : h8

▶ Spiralgenutet mit Linksdrahl / Rechtsschneidend

▶ Anschnittwinkel - bis Ø3,75 mm : 15°

- über Ø3,75 mm : 45°



EDP No.	Reamer Diameter	Shank Diameter	Cutting Length	Neck Length	Overall Length	No. of Flute
	D1	D2	L1	L3	L2	
K211100850	8.5	8	33	74	117	6
K211100900	9.0	9	36	80	125	6
K211100950	9.5	9	36	80	125	6
K211101000	10.0	10	38	86	133	6
K211101050	10.5	10	38	86	133	6
K211101100	11.0	10	41	95	142	6
K211101300	13.0	10	44	104	151	6
K211101400	14.0	12.5	47	108	160	8
K211101500	15.0	12.5	50	110	162	8
K211101600	16.0	12.5	52	118	170	8
K211101700	17.0	14	54	121	175	8
K211101800	18.0	14	56	128	182	8
K211101900	19.0	16	58	129	189	8
K211102000	20.0	16	60	135	195	8

◎ : Excellent ○ : Good																					
ISO	P										M				K						
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRC		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21	
HB		125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	○	○		◎	○			○	○	○	○	○	○	○	○	○	○	○	○
ISO	N										S						H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)				Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRC											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	○	○	○	○		○	○	○													

ISO	P											M			K							
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron			
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20		
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21		
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230		
Recommended	◎	◎	○	○		◎	○			○	○	○	○	○	○	○	○	○	○	○		
ISO	N										S						H					
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)				Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron		
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRc											15	30	25	38	34			55	60	42	55	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550	
Recommended	○	○	○	○		○	○	○														

CARBIDE

HSS

REAMERS

K2112

SERIES

HSS-E, NC MACHINE REAMERS WITH WHOLE-NUMBER SHANK Ø

HSS-E, NC-MASCHINENREIBAHLEN mit GERADZÄHLIGEN SCHAFT Ø

ALÉSOIRS HSS-E MACHINE CN AVEC DIFFÉRENTES TOLÉRANCES DE QUEUE

ALESATORI A MACCHINA IN HSS-E CON GAMMA Ø NOMINALI

O.D. Tolerances

Whole-number Ø and 1/10 size : DIN 1420 for H7

1/100 size : from Ø2.01 to Ø5.03 : +0.004/-0.000mm

from Ø5.97 to Ø12.03 : +0.005/-0.000mm

Shank Diameter Tolerances : h6

LH Spiral Flutes / Right Hand Cut

Chamfer Angle - Up to Ø3.75 : 15°

- Over Ø3.75 : 45°

Ø Toleranzen:

ganzzahlige Ø und 1/10 Größen : DIN 1420 für H7

1/100 Größen : ab Ø2,01 bis Ø5,03 : +0.004/-0.000mm

von Ø5,97 bis Ø12,03 : +0.005/-0.000mm

Schaft-Durchmesser Toleranzen : h6

linksspiralig/ rechtsscheidend

Anschnittwinkel - bis Ø3,75 : 15°

- über Ø3,75 : 45°

D ≤ 3.75

D > 3.75

D2

D1

L1

L2

Hole type

D ≤ 3.75

D > 3.75

D2

D1

L1

L2

Hole type

HSS-E

H7

LH7°

15°

45°

Bright

p.A388

up to Ø3.75 over Ø3.75

Unit : mm

EDP No.	Reamer Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	L2
K21B100302	3.02	4	16	65
K21B100303	3.03	4	16	65
K21B100310	3.1	4	16	65
K21B100320	3.2	4	16	65
K21B100330	3.3	4	16	65
K21B100340	3.4	4	18	70
K21B100350	3.5	4	18	70
K21B100360	3.6	4	18	70
K21B100370	3.7	4	18	70
K21B100380	3.8	4	19	75
K21B100390	3.9	4	19	75
K21B100397	3.97	4	19	75
K21B100398	3.98	4	19	75
K21B100399	3.99	4	19	75
K21B100400	4.0	4	19	75
K21B100401	4.01	4	19	75
K21B100402	4.02	4	19	75
K21B100403	4.03	4	19	75
K21B100410	4.1	4	19	75
K21B100420	4.2	4	19	75
K21B100430	4.3	5	21	80
K21B100440	4.4	5	21	80
K21B100450	4.5	5	21	80
K21B100460	4.6	5	21	80

► NEXT PAGE

◎ : Excellent ○ : Good

ISO	P										M				K							
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20		
HRc	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	21			
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230		
Recommended	◎	◎	○	○		◎	○				○	○	○	○	○	○	○	○	○	○	○	○

ISO	N										S					H									
Material Description	Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials		Heat Resistant Super Alloys			Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41				
HRc	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41				
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550				
Recommended	○	○	○	○		○	○	○																	

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YG-1 CO., LTD.

CARBIDE

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SERIES

HSS-E, NC MACHINE REAMERS WITH WHOLE-NUMBER SHANK Ø

HSS-E, NC-MASCHINENREIBAHLEN mit GERADZÄHLIGEN SCHAFT Ø

ALÉSOIRS HSS-E MACHINE CN AVEC DIFFÉRENTES TOLÉRANCES DE QUEUE

ALESATORI A MACCHINA IN HSS-E CON GAMMA Ø NOMINALI

O.D. Tolerances

Whole-number Ø and 1/10 size : DIN 1420 for H7

1/100 size : from Ø2.01 to Ø5.03 : +0.004/-0.000mm

from Ø5.97 to Ø12.03 : +0.005/-0.000mm

Shank Diameter Tolerances : h6

LH Spiral Flutes / Right Hand Cut

Chamfer Angle - Up to Ø3.75 : 15°

- Over Ø3.75 : 45°

Ø Toleranzen:

ganzzahlige Ø und 1/10 Größen : DIN 1420 für H7

1/100 Größen : ab Ø2,01 bis Ø5,03 : +0.004/-0.000mm

von Ø5,97 bis Ø12,03 : +0.005/-0.000mm

Schaft-Durchmesser Toleranzen : h6

linksspiralig/ rechtsscheidend

Anschnittwinkel - bis Ø3,75 : 15°

- über Ø3,75 : 45°

D ≤ 3.75

D > 3.75

D2

D1

L1

L2

Hole type

D ≤ 3.75

D > 3.75

D2

D1

L1

L2

Hole type

HSS-E

H7

LH7°

15°

45°

Bright

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up to Ø3.75 over Ø3.75

Unit : mm

EDP No.	Reamer Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	L2
K21B100480	4.8	5	23	86
K21B100490	4.9	5	23	86
K21B100497	4.97	5	23	86
K21B100498	4.98	5	23	86
K21B100499	4.99	5	23	86
K21B100500	5.0	5	23	86
K21B100501	5.01	5	23	86
K21B100502	5.02	5	23	86
K21B100503	5.03	5	23	86
K21B100510	5.1	5	23	86
K21B100520	5.2	5	23	86
K21B100550	5.5	6	26	93
K21B100560	5.6	6	26	93
K21B100570	5.7	6	26	93
K21B100580	5.8	6	26	93
K21B100590	5.9	6	26	93
K21B100597	5.97	6	26	93
K21B100598	5.98	6	26	93
K21B100599	5.99	6	26	93
K21B100600	6.0	6	26	93
K21B100601	6.01	6	28	101
K21B100602	6.02	6	28	101
K21B100603	6.03	6	28	101
K21B100610	6.1	6	28	101

► NEXT PAGE

◎ : Excellent ○ : Good

ISO	P										M				K							
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20		
HRc	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	21			
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230		
Recommended	◎	◎	○	○		◎	○				○	○	○	○	○	○	○	○	○	○	○	○

ISO	N										S					H									
Material Description	Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials		Heat Resistant Super Alloys			Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41				
HRc	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41				
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550				
Recommended	○	○	○	○		○	○	○																	

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Whole-number Ø and 1/10 size : DIN 1420 for H7

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from Ø5.97 to Ø12.03 : +0.005/-0.000mm

► Shank Diameter Tolerances : h6

► LH Spiral Flutes / Right Hand Cut

► Chamfer Angle - Up to Ø3.75 : 15°

- Over Ø3.75 : 45°

► Ø Toleranzen:

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1/100 Größen : ab Ø2,01 bis Ø5,03 : +0.004/-0.000mm

von Ø5,97 bis Ø12,03 : +0.005/-0.000mm

► Schaft-Durchmesser Toleranzen : h6

► linksspiralig/ rechtsscheidend

► Anschnittwinkel - bis Ø3,75 : 15°

- über Ø3,75 : 45°

HSS-E

H7

LH7°

15°

45°

Bright

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up to Ø3.75 over Ø3.75

EDP No.	Reamer Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	L2
K21B100620	6.2	6	28	101
K21B100630	6.3	6	28	101
K21B100640	6.4	6	28	101
K21B100660	6.6	6	28	101
K21B100670	6.7	6	28	101
K21B100680	6.8	8	31	109
K21B100700	7.0	8	31	109
K21B100710	7.1	8	31	109
K21B100720	7.2	8	31	109
K21B100730	7.3	8	31	109
K21B100740	7.4	8	31	109
K21B100750	7.5	8	31	109
K21B100770	7.7	8	33	117
K21B100780	7.8	8	33	117
K21B100790	7.9	8	33	117
K21B100797	7.97	8	33	117
K21B100798	7.98	8	33	117
K21B100799	7.99	8	33	117
K21B100800	8.0	8	33	117
K21B100801	8.01	8	33	117
K21B100802	8.02	8	33	117
K21B100803	8.03	8	33	117
K21B100810	8.1	8	33	117
K21B100820	8.2	8	33	117

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ISO	P										M					K				
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel					Stainless steel				
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRC	125	13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	○	○		◎	○			○	○	○	○	○	○	○	○	○	○	○
ISO	N										S					H				
	Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials				
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HRC	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400
Recommended	○	○	○	○		○	○	○												

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SUPER-GP
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HSS-E

H7

LH7°

15°

45°

Bright

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up to Ø3.75 over Ø3.75

EDP No.	Reamer Diameter	Shank Diameter	Flute Length	Overall Length
	D1	D2	L1	L2
K21B100830	8.3	8	33	117
K21B100840	8.4	8	33	117
K21B100850	8.5	8	33	117
K21B100860	8.6	10	36	125
K21B100870	8.7	10	36	125
K21B100880	8.8	10	36	125
K21B100900	9.0	10	36	125
K21B100902	9.02	10	36	125
K21B100910	9.1	10	36	125
K21B100920	9.2	10	36	125
K21B100950	9.5	10	36	125
K21B100960	9.6	10	38	133
K21B100970	9.7	10	38	133
K21B100990	9.9	10	38	133
K21B100997	9.97	10	38	133
K21B100998	9.98	10	38	133
K21B100999	9.99	10	38	133
K21B101000	10.0	10	38	133
K21B101001	10.01	10	38	133
K21B101002	10.02	10	38	133
K21B101003	10.03	10	38	133
K21B101100	11.0	10	41	142
K21B101198	11.98	10	41	151
K21B101199	11.99	10	41	151

► NEXT PAGE

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Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRC	125	13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	○	○		◎	○			○	○	○	○	○	○	○	○	○	○	○
ISO	N										S					H				
	Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials				
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HRC	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400
Recommended	○	○	○	○		○	○	○												

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Vc = m/min.
RPM = rev./min.
FEED = mm/rev.

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