

Special Reamer Quote Form

HR 500 ACTIVE

Solid carbide step reamers made to measure

Order

Inquiry

Name/customer no. if available New customer

Street no.

Telephone

Date

Contact for questions

Order no.

Zip code

Fax

Signature

Quantity

Minimum order quantity 5 tools

Hole Ø / tol.

or

Reamers

manufact. Ø / tol.

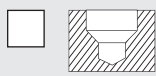
Example


| | | | | | | | |
|-----------------------|----------------------|-----------------------|----------------------|----------------------|----------------------|----------------------|----------------------|
| <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="text"/> |
| nom.-Ø d ₁ | upper/lower limit | step Ø d ₃ | upper/lower limit | Example | Example | Example | Example |
| <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="text"/> |
| | | | | Ø 12 | +0,01 -0,004 | Ø 10 | +0,01 -0,004 |

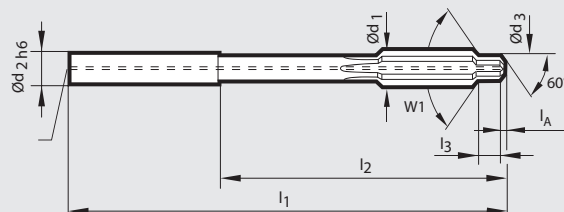
**cyl. step length/
countersink
angle**

Step length $l_{3 \pm 0,1}$

Blind hole

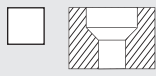
 Hole and countersink

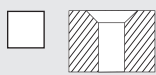


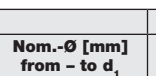


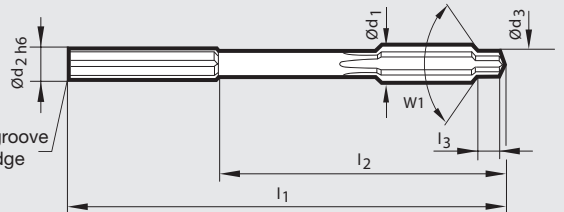
Through hole

- with internal cooling
- without internal cooling

 Stepped hole

 Hole and countersink

 one coolant groove per cutting edge



Dimensions

- long version
- short version

Further dimensions on request

| Nom.-Ø [mm] from - to d ₁ | smallest poss. step-Ø d ₃ | long version | | short version | | Chamfer length l ₁ (only blind holes) | Shank-Ø h6 DIN 6535 d ₂ |
|--------------------------------------|--------------------------------------|----------------|----------------------|----------------|----------------------|--|------------------------------------|
| | | l ₁ | Reach l ₂ | l ₁ | Reach l ₂ | | |
| 2.950 – 4.1 | d1x0.7 (min.Ø2.95) | 68 | 40 | - | - | 0.4 | 4 |
| 4.101 – 6.1 | d1x0.7 (min.Ø2.95) | 76 | 40 | - | - | 0.4 | 6 |
| 6.101 – 8.1 | d1 x 0.8 | 101 | 65 | 76 | 40 | 0.4 | 8 |
| 8.101 – 10.1 | d1 x 0.8 | 101 | 61 | 76 | 36 | 0.4 | 10 |
| 10.101 – 12.1 | d1 x 0.8 | 130 | 85 | 80 | 35 | 0.5 | 12 |
| 12.101 – 14.1 | d1 x 0.8 | 130 | 85 | 90 | 45 | 0.5 | 14 |
| 14.101 – 16.1 | d1 x 0.8 | 150 | 102 | 90 | 42 | 0.5 | 16 |
| 16.101 – 18.1 | d1 x 0.8 | 150 | 102 | 100 | 52 | 0.5 | 18 |
| 18.101 – 20.1 | d1 x 0.8 | 150 | 100 | 100 | 50 | 0.5 | 20 |

Coating

- TiAlN (optimal for the machining of steel and universal application)
- Zenit (optimal for the machining of titanium)
- nano-Si (optimal for the machining of cast iron)
- Carbo (optimal for the machining of Al)

Material

- steel/hardened steel/special alloys/VA
- Cast iron
- HR 500 CAST
- Al-wrought-cast alloys