YG REAMERS

K1153 SERIES

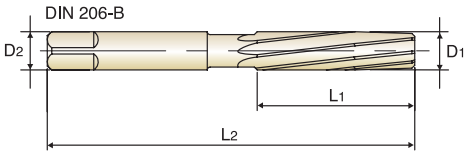
HSS, HAND REAMERS - LH SPIRAL FLUTES

- 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 Linksdrall / Rechtsschneidend
- ▶ Anschnittwinkel - Konisch
- ▶ Zentrierungsart - bis Ø3,75 mm : Zentrierungszapfen
  - über Ø3,75 mm : Zentrierung





Hole type



$D_1=D_2$

HSS | DIN 206 | H7 | LH7° | Bright

Recommended ToolHolder — Plain Shank, ER COLLET CHUCK

Unit : mm

EDP No.	Reamer Diameter D	Flute Length L_1	Overall Length L_2	No. of Flute
K115300200	2.0	25	50	4
K115300220	2.2	27	54	4
K115300250	2.5	29	58	4
K115300280	2.8	31	62	4
K115300300	3.0	31	62	6
K115300320	3.2	33	66	6
K115300350	3.5	35	71	6
K115300400	4.0	38	76	6
K115300450	4.5	41	81	6
K115300500	5.0	44	87	6
K115300550	5.5	47	93	6
K115300600	6.0	47	93	6
K115300700	7.0	54	107	6
K115300800	8.0	58	115	6
K115300900	9.0	62	124	6
K115301000	10.0	66	133	6
K115301100	11.0	71	142	6
K115301200	12.0	76	152	6
K115301300	13.0	76	152	6
K115301400	14.0	81	163	8
K115301500	15.0	81	163	8
K115301600	16.0	87	175	8
K115301700	17.0	87	175	8
K115301800	18.0	93	188	8
K115301900	19.0	93	188	8
K115302000	20.0	100	201	8
K115302200	22.0	107	215	8
K115302400	24.0	115	231	8

▶ 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	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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YG-1 CO., LTD.

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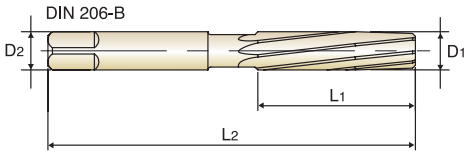

Hole type



$D_1=D_2$

HSS | DIN 206 | H7 | LH7° | Bright

Recommended ToolHolder | Plain Shank | ER COLLET CHUCK

Unit : mm

EDP No.	Reamer Diameter D	Flute Length L_1	Overall Length L_2	No. of Flute
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
K115303600	36.0	142	284	10
K115303700	37.0	142	284	10
K115303800	38.0	152	305	10
K115303810	38.1	152	305	10
K115303900	39.0	152	305	10
K115304000	40.0	152	305	10
K115304100	41.0	152	305	12
K115304200	42.0	152	305	12
K115304300	43.0	163	326	12
K115304400	44.0	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
K115306000	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	
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HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
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HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	○	○	○	○		○	○	○													