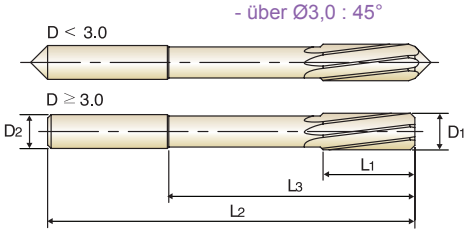
CARBIDE, NC MACHINE REAMERS - LH SPIRAL FLUTES

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°





Hole type



CARBIDE | H7 | LH7° | 15° (D<3.0) | 45° (D≥3.0) | Bright

p.A405

Recommended ToolHolder: Plain Shank, ER COLLET CHUCK

Unit : mm

EDP No.	Reamer Diameter D1	Shank Diameter D2	Cutting Length L1	Neck Length L3	Overall Length L2	No. of Flute
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
K411100850	8.5	10	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
K411101300	13.0	16	44	104	151	6
K411101400	14.0	16	47	108	160	8
K411101500	15.0	16	50	110	162	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		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	○	○	○	○		○	○	○													