

**YG**

REAMERS

*CARBIDE / HSS-E NC MACHINE REAMERS
HSS HAND REAMERS
HSS-E CHUCKING REAMERS*

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Note The new address above has currently been updated since Korean new postal standard was valid from 2014.
Be noticed that the location of the Headquarters has NOT changed.



Tool specifications are subject to change without prior notice.

REAMERS

CARBIDE / HSS-E NC MACHINE REAMERS
HSS HAND REAMERS
HSS-E CHUCKING REAMERS

SELECTION GUIDE

| ITEM | MODEL | DESCRIPTION | SIZE | | PAGE |
|--------------------------------|-------|---|-------|-------|------|
| | | | MIN | MAX | |
| CARBIDE | | | | | |
| K4101 | | CARBIDE, NC MACHINE REAMERS - STRAIGHT FLUTES | D2.0 | D20.0 | 3 |
| K4111 | | CARBIDE, NC MACHINE REAMERS - LH SPIRAL FLUTES | D2.0 | D20.0 | 4 |
| HSS | | | | | |
| K1143 | | HSS, HAND REAMERS - STRAIGHT FLUTES | D2.0 | D60.0 | 5 |
| K1153 | | HSS, HAND REAMERS - LH SPIRAL FLUTES | D2.0 | D60.0 | 7 |
| K2101 | | HSS-E, STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTES | D2.0 | D20.0 | 9 |
| K2111 | | HSS-E, STRAIGHT SHANK CHUCKING REAMERS - LH SPIRAL FLUTES | D2.0 | D20.0 | 10 |
| K2121 | | HSS-E, STRAIGHT SHANK CHUCKING REAMERS - LH SPIRAL FLUTES(QUICK SPIRAL) | D4.0 | D20.0 | 11 |
| K2102 | | HSS-E, MORSE TAPER SHANK CHUCKING REAMERS - STRAIGHT FLUTES | D10.0 | D50.0 | 12 |
| K2112 | | HSS-E, MORSE TAPER SHANK CHUCKING REAMERS - LH SPIRAL FLUTES | D10.0 | D50.0 | 13 |
| K21B1 | | HSS-E, NC MACHINE REAMERS WITH WHOLE-NUMBER SHANK Ø | D2.0 | D20.0 | 14 |
| RECOMMENDED CUTTING CONDITIONS | | | | | 18 |

GUIDE LINE TO ICONS



Tool Raw Material



Standard of Tools



O.D. Tolerance of Reamer



Helix Angle



Chamfer Angle



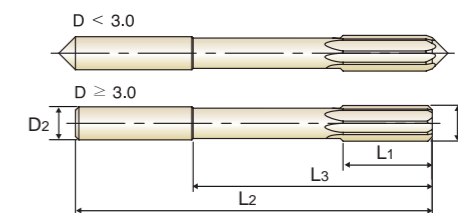
Cutting Condition Pages

CARBIDE, NC MACHINE REAMERS STRAIGHT FLUTES

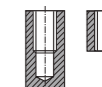
K4101 SERIES

- ▶ 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°



Hole type



Unit : mm

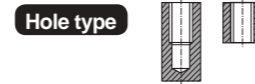
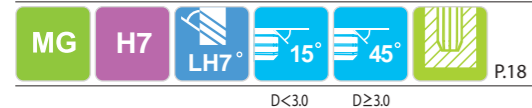
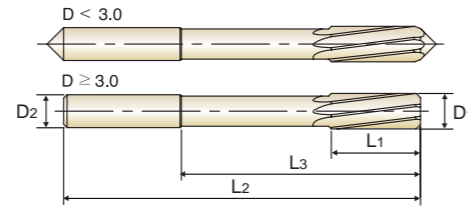
| EDP No. | Nominal SIZE | Shank Diameter | Cutting Length | Neck Length | Overall Length | No. of Flutes |
|------------|--------------|----------------|----------------|-------------|----------------|---------------|
| | D1 | D2 | L1 | L3 | L2 | |
| K410100200 | 2.0 | 4 | 11 | 20 | 50 | 4 |
| K410100250 | 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 |
| K410100550 | 5.5 | 6 | 26 | 56 | 93 | 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 |

CARBIDE, NC MACHINE REAMERS LH SPIRAL FLUTES

K4111 SERIES

- ▶ 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°



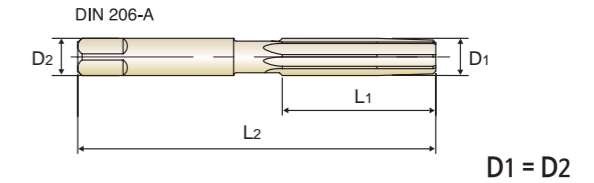
| EDP No. | Nominal SIZE | Shank Diameter D2 | Cutting Length L1 | Neck Length L3 | Overall Length L2 | No. of Flutes |
|------------|--------------|----------------------|----------------------|-------------------|----------------------|---------------|
| | D1 | | | | | |
| K411100200 | 2.0 | 4 | 11 | 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 |

HSS, HAND REAMERS STRAIGHT FLUTES

K1143 SERIES

- ▶ 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



| EDP No. | Nominal SIZE | Flute Length L1 | Overall Length L2 | No. of Flutes |
|------------|--------------|--------------------|----------------------|---------------|
| | D1 | | | |
| 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 |
| K114300320 | 3.2 | 33 | 66 | 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 |
| K114301300 | 13.0 | 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 |

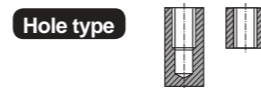
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HSS, HAND REAMERS STRAIGHT FLUTES

K1143 SERIES

- ▶ O.D. Tolerances : DIN 1420 for H7
- ▶ Shank Diameter \approx Nominal Reamer Diameter
- ▶ Straight Flutes / Right Hand Cut

- ▶ Chamfer Angle - tapered
- ▶ Type of center - Up to $\varnothing 3.75$: external centers
- Over $\varnothing 3.75$: internal centers



Unit : mm

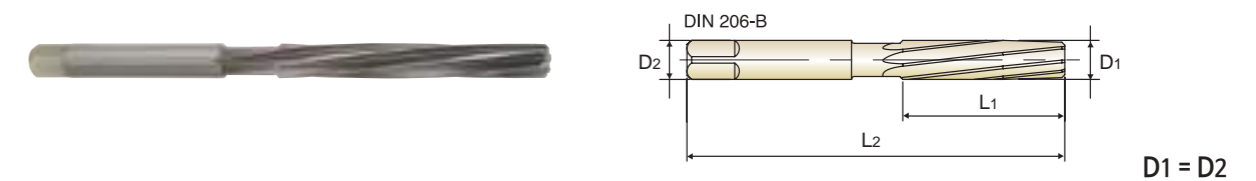
| EDP No. | Nominal SIZE | Flute Length | Overall Length | No. of Flutes |
|------------|--------------|--------------|----------------|---------------|
| | D1 | L1 | L2 | |
| K114302500 | 25.0 | 115 | 231 | 8 |
| K114302600 | 26.0 | 115 | 231 | 8 |
| K114302700 | 27.0 | 124 | 247 | 10 |
| K114302800 | 28.0 | 124 | 247 | 10 |
| K114302900 | 29.0 | 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 |

HSS, HAND REAMERS LH SPIRAL FLUTES

K1153 SERIES

- ▶ O.D. Tolerances : DIN 1420, H7
- ▶ Shank Diameter \approx Nominal Reamer Diameter
- ▶ LH Spiral Flutes / Right Hand Cut

- ▶ Chamfer Angle - tapered
- ▶ Type of center - Up to $\varnothing 3.75$: external centers
- Over $\varnothing 3.75$: internal centers



Unit : mm

| EDP No. | Nominal SIZE | Flute Length | Overall Length | No. of Flutes |
|------------|--------------|--------------|----------------|---------------|
| | D1 | L1 | L2 | |
| 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

HSS, HAND REAMERS LH SPIRAL FLUTES

K1153 SERIES

- ▶ O.D. Tolerances : DIN 1420, H7
- ▶ Shank Diameter \approx Nominal Reamer Diameter
- ▶ LH Spiral Flutes / Right Hand Cut

- ▶ Chamfer Angle - tapered
- ▶ Type of center - Up to $\varnothing 3.75$: external centers
- Over $\varnothing 3.75$: internal centers



D1 = D2



Unit : mm

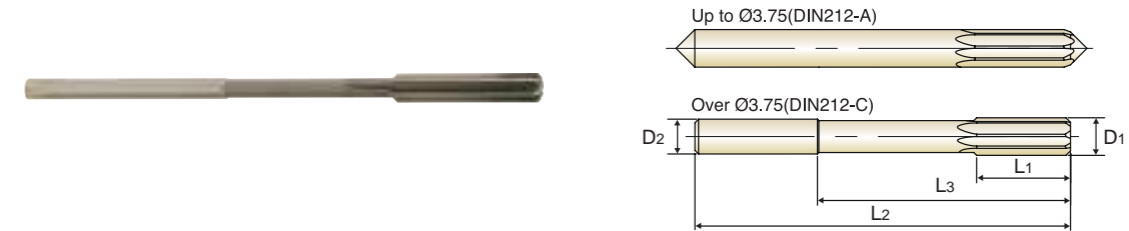
| EDP No. | Nominal SIZE | Flute Length | Overall Length | No. of Flutes |
|------------|--------------|--------------|----------------|---------------|
| | D1 | L1 | L2 | |
| K115302500 | 25.0 | 115 | 231 | 8 |
| K115302600 | 26.0 | 115 | 231 | 8 |
| K115302700 | 27.0 | 124 | 247 | 10 |
| K115302800 | 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 |
| 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 |

HSS-E, STRAIGHT SHANK CHUCKING REAMERS STRAIGHT FLUTES

K2101 SERIES

- ▶ O.D. Tolerances : DIN 1420 for H7
- ▶ Shank Diameter Tolerances : h8
- ▶ Straight Flute / Right Hand Cut

- ▶ Chamfer Angle - Up to $\varnothing 3.75$: 15°
- Over $\varnothing 3.75$: 45°



Unit : mm

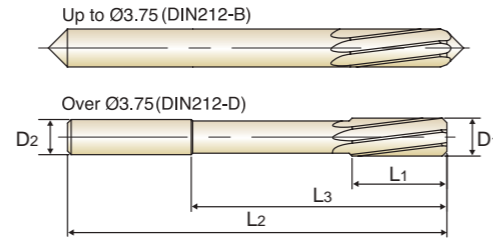
| EDP No. | Nominal SIZE | Shank Diameter | Flute Length | Neck Length | Overall Length | No. of Flutes |
|------------|--------------|----------------|--------------|-------------|----------------|---------------|
| | D1 | D2 | L1 | L3 | L2 | |
| K210100200 | 2.0 | 2 | 11 | - | 49 | 4 |
| K210100220 | 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 |
| K210100310 | 3.1 | 3.1 | 16 | - | 65 | 6 |
| K210100320 | 3.2 | 3.2 | 16 | - | 65 | 6 |
| K210100350 | 3.5 | 3.5 | 18 | - | 70 | 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 |
| 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 |
| K210101900 | 19.0 | 16 | 58 | 129 | 189 | 8 |
| K210102000 | 20.0 | 16 | 60 | 135 | 195 | 8 |

HSS-E, STRAIGHT SHANK CHUCKING REAMERS LH SPIRAL FLUTES

K2111 SERIES

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

- ▶ Chamfer Angle - Up to $\varnothing 3.75$: 15°
- Over $\varnothing 3.75$: 45°



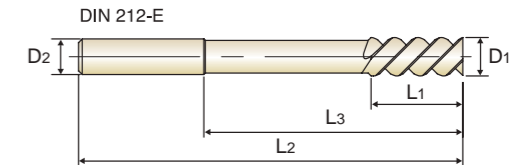
| EDP No. | Nominal SIZE | Shank Diameter D2 | Flute Length L1 | Neck Length L3 | Overall Length L2 | No. of Flutes |
|------------|--------------|----------------------|--------------------|-------------------|----------------------|---------------|
| | D1 | | | | | |
| K211100200 | 2.0 | 2 | 11 | - | 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 |
| K211100370 | 3.7 | 3.7 | 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 |
| K211100460 | 4.6 | 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 |
| K211100830 | 8.3 | 8 | 33 | 74 | 117 | 6 |
| 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 |
| K211101200 | 12.0 | 10 | 44 | 104 | 151 | 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 |

Unit : mm

HSS-E, STRAIGHT SHANK CHUCKING REAMERS LH SPIRAL FLUTES (QUICK SPIRAL)

K2121 SERIES

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



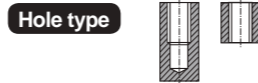
| EDP No. | Nominal SIZE | Shank Diameter D2 | Flute Length L1 | Neck Length L3 | Overall Length L2 | No. of Flutes |
|------------|--------------|----------------------|--------------------|-------------------|----------------------|---------------|
| | D1 | | | | | |
| K212100400 | 4.0 | 4 | 19 | 42 | 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 |

Unit : mm

HSS-E, MORSE TAPER SHANK CHUCKING REAMERS STRAIGHT FLUTES

K2102 SERIES

- ▶ O.D. Tolerances : DIN 1420 for H7
- ▶ Straight Flute / Right Hand Cut
- ▶ Chamfer Angle : 45°



Unit : mm

| EDP No. | Nominal SIZE D1 | No. of Morse Taper | Cutting Length L1 | Overall Length L2 | No. of Flutes |
|------------|--------------------|--------------------|----------------------|----------------------|---------------|
| K210201000 | 10.0 | 1 | 38 | 168 | 6 |
| K210201100 | 11.0 | 1 | 41 | 175 | 6 |
| K210201200 | 12.0 | 1 | 44 | 182 | 6 |
| K210201300 | 13.0 | 1 | 44 | 182 | 6 |
| K210201400 | 14.0 | 1 | 47 | 189 | 8 |
| K210201500 | 15.0 | 2 | 50 | 204 | 8 |
| K210201600 | 16.0 | 2 | 52 | 210 | 8 |
| K210201700 | 17.0 | 2 | 54 | 214 | 8 |
| K210201800 | 18.0 | 2 | 56 | 219 | 8 |
| K210201900 | 19.0 | 2 | 58 | 223 | 8 |
| K210202000 | 20.0 | 2 | 60 | 228 | 8 |
| K210202100 | 21.0 | 2 | 62 | 232 | 8 |
| K210202200 | 22.0 | 2 | 64 | 237 | 8 |
| K210202300 | 23.0 | 2 | 66 | 241 | 8 |
| K210202400 | 24.0 | 3 | 68 | 268 | 8 |
| K210202500 | 25.0 | 3 | 68 | 268 | 8 |
| K210202600 | 26.0 | 3 | 70 | 273 | 8 |
| K210202700 | 27.0 | 3 | 71 | 277 | 10 |
| K210202800 | 28.0 | 3 | 71 | 277 | 10 |
| K210202900 | 29.0 | 3 | 73 | 281 | 10 |
| K210203000 | 30.0 | 3 | 73 | 281 | 10 |
| K210203100 | 31.0 | 3 | 75 | 285 | 10 |
| K210203200 | 32.0 | 4 | 77 | 317 | 10 |
| K210203400 | 34.0 | 4 | 78 | 321 | 10 |
| K210203500 | 35.0 | 4 | 78 | 321 | 10 |
| K210203600 | 36.0 | 4 | 79 | 325 | 10 |
| K210203800 | 38.0 | 4 | 81 | 329 | 10 |
| K210204000 | 40.0 | 4 | 81 | 329 | 10 |
| K210204100 | 41.0 | 4 | 82 | 333 | 12 |
| K210204200 | 42.0 | 4 | 82 | 333 | 12 |
| K210204300 | 43.0 | 4 | 83 | 336 | 12 |
| K210204400 | 44.0 | 4 | 83 | 336 | 12 |
| K210204500 | 45.0 | 4 | 83 | 336 | 12 |
| K210204600 | 46.0 | 4 | 84 | 340 | 12 |
| K210204700 | 47.0 | 4 | 84 | 340 | 12 |
| K210204800 | 48.0 | 4 | 86 | 344 | 12 |
| K210205000 | 50.0 | 4 | 86 | 344 | 12 |

HSS-E, MORSE TAPER SHANK CHUCKING REAMERS LH SPIRAL FLUTES

K2112 SERIES

- ▶ O.D. Tolerances : DIN 1420 for H7
- ▶ LH Spiral Flutes / Right Hand Cut
- ▶ Chamfer Angle : 45°



Unit : mm

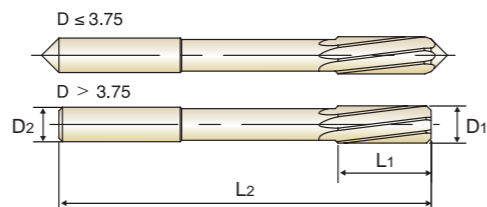
| EDP No. | Nominal SIZE D1 | No. of Morse Taper | Cutting Length L1 | Overall Length L2 | No. of Flutes |
|------------|--------------------|--------------------|----------------------|----------------------|---------------|
| K211201000 | 10.0 | 1 | 38 | 168 | 6 |
| K211201100 | 11.0 | 1 | 41 | 175 | 6 |
| K211201200 | 12.0 | 1 | 44 | 182 | 6 |
| K211201300 | 13.0 | 1 | 44 | 182 | 6 |
| K211201400 | 14.0 | 1 | 47 | 189 | 8 |
| K211201500 | 15.0 | 2 | 50 | 204 | 8 |
| K211201600 | 16.0 | 2 | 52 | 210 | 8 |
| K211201700 | 17.0 | 2 | 54 | 214 | 8 |
| K211201800 | 18.0 | 2 | 56 | 219 | 8 |
| K211201900 | 19.0 | 2 | 58 | 223 | 8 |
| K211202000 | 20.0 | 2 | 60 | 228 | 8 |
| K211202100 | 21.0 | 2 | 62 | 232 | 8 |
| K211202200 | 22.0 | 2 | 64 | 237 | 8 |
| K211202300 | 23.0 | 2 | 66 | 241 | 8 |
| K211202400 | 24.0 | 3 | 68 | 268 | 8 |
| K211202500 | 25.0 | 3 | 68 | 268 | 8 |
| K211202600 | 26.0 | 3 | 70 | 273 | 8 |
| K211202700 | 27.0 | 3 | 71 | 277 | 10 |
| K211202800 | 28.0 | 3 | 71 | 277 | 10 |
| K211202900 | 29.0 | 3 | 73 | 281 | 10 |
| K211203000 | 30.0 | 3 | 73 | 281 | 10 |
| K211203100 | 31.0 | 3 | 75 | 285 | 10 |
| K211203200 | 32.0 | 4 | 77 | 317 | 10 |
| K211203400 | 34.0 | 4 | 78 | 321 | 10 |
| K211203500 | 35.0 | 4 | 78 | 321 | 10 |
| K211203600 | 36.0 | 4 | 79 | 325 | 10 |
| K211203800 | 38.0 | 4 | 81 | 329 | 10 |
| K211204000 | 40.0 | 4 | 81 | 329 | 10 |
| K211204100 | 41.0 | 4 | 82 | 333 | 12 |
| K211204200 | 42.0 | 4 | 82 | 333 | 12 |
| K211204300 | 43.0 | 4 | 83 | 336 | 12 |
| K211204400 | 44.0 | 4 | 83 | 336 | 12 |
| K211204500 | 45.0 | 4 | 83 | 336 | 12 |
| K211204600 | 46.0 | 4 | 84 | 340 | 12 |
| K211204700 | 47.0 | 4 | 84 | 340 | 12 |
| K211204800 | 48.0 | 4 | 86 | 344 | 12 |
| K211205000 | 50.0 | 4 | 86 | 344 | 12 |

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

K21B1 SERIES

- ▶ 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°



Hole type



| EDP No. | Nominal SIZE | Shank Diameter D2 | Flute Length L1 | Overall Length L2 |
|------------|--------------|----------------------|--------------------|----------------------|
| | D1 | | | |
| K21B100200 | 2.0 | 2 | 11 | 49 |
| K21B100201 | 2.01 | 2 | 11 | 49 |
| K21B100202 | 2.02 | 2 | 11 | 49 |
| K21B100203 | 2.03 | 2 | 11 | 49 |
| K21B100210 | 2.1 | 2 | 11 | 49 |
| K21B100220 | 2.2 | 3 | 12 | 53 |
| K21B100230 | 2.3 | 3 | 12 | 53 |
| K21B100240 | 2.4 | 3 | 14 | 57 |
| K21B100247 | 2.47 | 3 | 14 | 57 |
| K21B100248 | 2.48 | 3 | 14 | 57 |
| K21B100249 | 2.49 | 3 | 14 | 57 |
| K21B100250 | 2.5 | 3 | 14 | 57 |
| K21B100251 | 2.51 | 3 | 14 | 57 |
| K21B100252 | 2.52 | 3 | 14 | 57 |
| K21B100253 | 2.53 | 3 | 14 | 57 |
| K21B100260 | 2.6 | 3 | 14 | 57 |
| K21B100270 | 2.7 | 3 | 15 | 61 |
| K21B100280 | 2.8 | 3 | 15 | 61 |
| K21B100290 | 2.9 | 3 | 15 | 61 |
| K21B100297 | 2.97 | 3 | 15 | 61 |
| K21B100298 | 2.98 | 3 | 15 | 61 |
| K21B100299 | 2.99 | 3 | 15 | 61 |
| K21B100300 | 3.0 | 3 | 15 | 61 |
| K21B100301 | 3.01 | 4 | 16 | 65 |
| 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 |

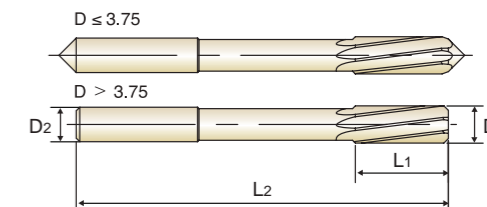
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HSS-E, NC MACHINE REAMERS WITH WHOLE NUMBER SHANK Ø

K21B1 SERIES

- ▶ 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°



Hole type



| EDP No. | Nominal SIZE | Shank Diameter D2 | Flute Length L1 | Overall Length L2 |
|------------|--------------|----------------------|--------------------|----------------------|
| | D1 | | | |
| 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 |
| K21B100470 | 4.7 | 5 | 21 | 80 |
| 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 |
| K21B100530 | 5.3 | 5 | 23 | 86 |
| K21B100540 | 5.4 | 6 | 26 | 93 |
| 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 |

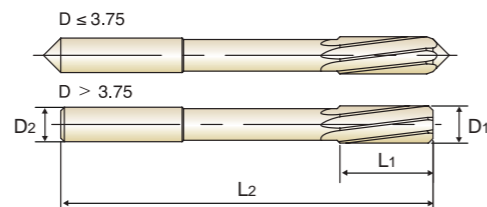
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HSS-E, NC MACHINE REAMERS WITH WHOLE NUMBER SHANK Ø

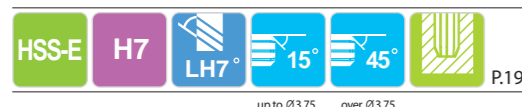
K21B1 SERIES

▶ 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°



Hole type



up to Ø3.75 over Ø3.75

Unit : mm

| EDP No. | Nominal SIZE | Shank Diameter D2 | Flute Length L1 | Overall Length L2 |
|------------|--------------|----------------------|--------------------|----------------------|
| | D1 | | | |
| K21B100610 | 6.1 | 6 | 28 | 101 |
| K21B100620 | 6.2 | 6 | 28 | 101 |
| K21B100630 | 6.3 | 6 | 28 | 101 |
| K21B100640 | 6.4 | 6 | 28 | 101 |
| K21B100650 | 6.5 | 6 | 28 | 101 |
| K21B100660 | 6.6 | 6 | 28 | 101 |
| K21B100670 | 6.7 | 6 | 28 | 101 |
| K21B100680 | 6.8 | 8 | 31 | 109 |
| K21B100690 | 6.9 | 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 |
| K21B100760 | 7.6 | 8 | 33 | 117 |
| 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 |
| 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 |
| K21B100890 | 8.9 | 10 | 36 | 125 |
| K21B100900 | 9.0 | 10 | 36 | 125 |

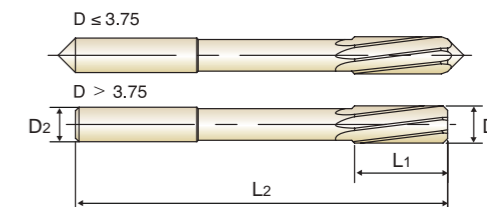
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HSS-E, NC MACHINE REAMERS WITH WHOLE NUMBER SHANK Ø

K21B1 SERIES

▶ 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°



Hole type



up to Ø3.75 over Ø3.75

Unit : mm

| EDP No. | Nominal SIZE | Shank Diameter D2 | Flute Length L1 | Overall Length L2 |
|------------|--------------|----------------------|--------------------|----------------------|
| | D1 | | | |
| K21B100901 | 9.01 | 10 | 36 | 125 |
| K21B100902 | 9.02 | 10 | 36 | 125 |
| K21B100903 | 9.03 | 10 | 36 | 125 |
| K21B100910 | 9.1 | 10 | 36 | 125 |
| K21B100920 | 9.2 | 10 | 36 | 125 |
| K21B100930 | 9.3 | 10 | 36 | 125 |
| K21B100940 | 9.4 | 10 | 36 | 125 |
| K21B100950 | 9.5 | 10 | 36 | 125 |
| K21B100960 | 9.6 | 10 | 38 | 133 |
| K21B100970 | 9.7 | 10 | 38 | 133 |
| K21B100980 | 9.8 | 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 |
| K21B101197 | 11.97 | 10 | 41 | 151 |
| K21B101198 | 11.98 | 10 | 41 | 151 |
| K21B101199 | 11.99 | 10 | 41 | 151 |
| K21B101200 | 12.0 | 10 | 44 | 151 |
| K21B101201 | 12.01 | 10 | 44 | 151 |
| K21B101202 | 12.02 | 10 | 44 | 151 |
| K21B101203 | 12.03 | 10 | 44 | 151 |
| K21B101300 | 13.0 | 10 | 44 | 151 |
| K21B101400 | 14.0 | 14 | 47 | 160 |
| K21B101500 | 15.0 | 14 | 50 | 162 |
| K21B101600 | 16.0 | 14 | 52 | 170 |
| K21B101700 | 17.0 | 14 | 54 | 175 |
| K21B101800 | 18.0 | 14 | 56 | 182 |
| K21B101900 | 19.0 | 16 | 58 | 189 |
| K21B102000 | 20.0 | 16 | 60 | 195 |

CARBIDE, NC MACHINE REAMER

| Material | Cutting Speed (m/min.) | Feed(mm/rev.) | | | | |
|--|---------------------------|---------------|-----------|-----------|-----------|-----------|
| | | Up to Ø4 | Ø4 ~ Ø8 | Ø8 ~ Ø12 | Ø12 ~ Ø16 | Ø16 ~ Ø20 |
| Structural and Low carbon steel | 15~18 | 0.10~0.12 | 0.12~0.20 | 0.20~0.25 | 0.25~0.30 | 0.30~0.40 |
| Carbon Steels < 500N/mm ² | 15~18 | 0.10~0.12 | 0.12~0.20 | 0.20~0.25 | 0.25~0.30 | 0.30~0.40 |
| Alloy Steels 500-1000N/mm ² | 12~14 | 0.08~0.10 | 0.10~0.16 | 0.16~0.20 | 0.20~0.25 | 0.25~0.30 |
| Hardened Steels ~ HRc40 | 10~12 | 0.08~0.10 | 0.10~0.16 | 0.16~0.20 | 0.20~0.25 | 0.25~0.30 |
| Cast Iron < 200HB | 15~20 | 0.10~0.12 | 0.12~0.20 | 0.20~0.25 | 0.25~0.30 | 0.30~0.40 |
| > 200HB | 12~15 | 0.10~0.12 | 0.12~0.20 | 0.20~0.25 | 0.25~0.30 | 0.30~0.40 |
| Aluminium and Al-alloys | 20~30 | 0.12~0.16 | 0.16~0.25 | 0.25~0.30 | 0.30~0.40 | 0.40~0.50 |
| Magnesium alloys | 20~30 | 0.10~0.12 | 0.12~0.20 | 0.20~0.25 | 0.25~0.30 | 0.30~0.40 |
| Copper, Brass | 20~25 | 0.10~0.12 | 0.12~0.20 | 0.20~0.25 | 0.25~0.30 | 0.30~0.40 |
| Stainless Steels | 6~8 | 0.08~0.10 | 0.10~0.16 | 0.16~0.20 | 0.20~0.25 | 0.25~0.30 |
| Plastics | 15~20 | 0.12~0.16 | 0.16~0.25 | 0.25~0.30 | 0.30~0.40 | 0.40~0.50 |

REAMING ALLOWANCE

| Size Range | Up to Ø6 | Ø6 ~ Ø10 | Ø10 ~ Ø16 | Ø16 ~ Ø25 | Over Ø25 |
|----------------|-----------|-----------|-----------|-----------|-----------|
| Removal Amount | 0.1 ~ 0.2 | 0.2 ~ 0.3 | 0.2 ~ 0.4 | 0.3 ~ 0.5 | 0.3 ~ 0.6 |

* For machine reaming
* Unit : mm

HSS-E, STRAIGHT & LH SPIRAL FLUTE CHUCKING REAMER, NC MACHINE REAMER

| 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

| 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 |



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