

HARTNER



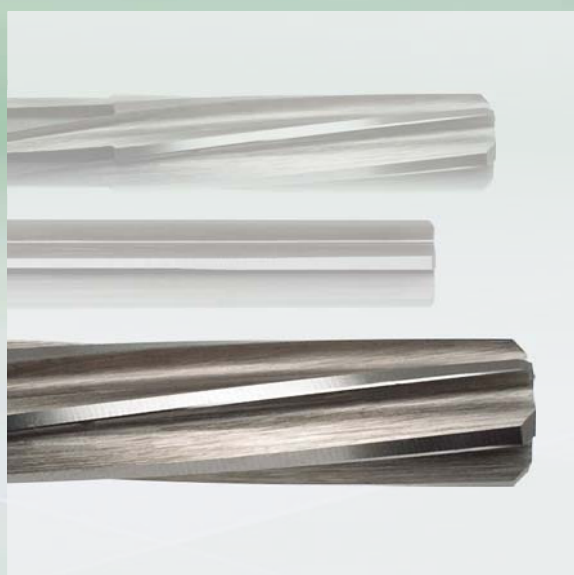
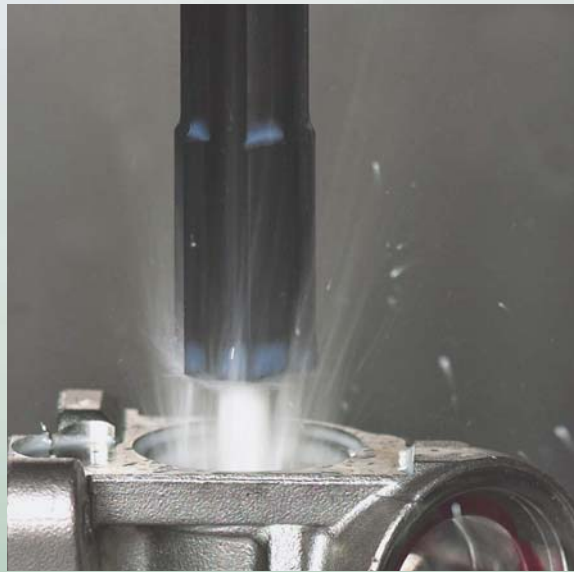
HARTNER

Precision Cutting Tools



REAMERS

TR 300 HP - HIGH-PERFORMANCE REAMERS
SOLID CARBIDE AND HSS-E MACHINE REAMERS | HAND REAMERS

















+ THE FULL PROGRAMME OF REAMERS

ISO code

P	Steel, high-alloyed steel
M	Stainless steel
K	Grey cast iron, spher. graphite iron/malleable cast iron
N	Aluminium and other non-ferrous metals
S	Special, super and titanium alloys
H	Hardened steel and chilled cast iron

Pictograms

Tool material	VHM	HM	HSS	HSS-E
	Solid carbide	Carbide-tipped		
Type	TR 300 HP S	TR 300 HP D		
	Blind hole (S)	Through hole (D)		
Form	A	B		
Hole type				
	Through hole	Blind hole		
Norm	DIN 206	DIN 208	DIN 212	DIN 212-2
			DIN 212-3	~DIN 8050
				~DIN 8051
	to DIN			
		to Hartner standard		
Tolerance on Ø	H7	+0,005	+0,004 +0,005	
Cutting direction				
	right	left		
Shank form				
			Morse taper	
Helix angle				
	straight-fluted	left-hand helix		
Flute spacing				
	unequal	extremely unequal		
Internal cooling				
	with IC	without IC		

Optimal diameters of pre-drilled holes

Recommended stock allowance, in mm		up to Ø6	up to Ø10	up to Ø16	up to Ø25	up to Ø40	up to Ø40
all materials		Ø 0.1-0.2	Ø 0.2	Ø 0.2-0.3	Ø 0.3	Ø 0.3-0.4	Ø 0.4-0.5
hardened steel	H	up to 48 HRC	Ø 0.1-0.2	Ø 0.2	Ø 0.2	Ø 0.3	Ø 0.3
		up to 63 HRC	Ø 0.1	Ø 0.1	Ø 0.1-0.2	Ø 0.2	Ø 0.2



TR 300 HP
High-performance reamers

page 4



Solid carbide reamers

page 11



HSS-E- machine reamers

page 19



Hand reamers

page 32

Technical section

page 36



High-performance reamers

Standard	Form	Shank form	Diameter tolerance	Tool material	Surface finish	Hole type	d1	Order no.	Discount group	Standard range page
----------	------	------------	--------------------	---------------	----------------	-----------	----	-----------	----------------	---------------------

High-performance reamers



Hartner Standard	TR 300 HP S	HA	H7	Solid carbide			3.000 - 20.000	88400	166	5
------------------	-------------	----	----	---------------	--	--	----------------	--------------	-----	---

¹/₁₀₀



Hartner Standard	TR 300 HP S	HA	+0.005	Solid carbide			2.970 - 12.030	88402	166	5
------------------	-------------	----	--------	---------------	--	--	----------------	--------------	-----	---



Hartner Standard	TR 300 HP D	HA	H7	Solid carbide			3.000 - 20.000	88401	166	8
------------------	-------------	----	----	---------------	--	--	----------------	--------------	-----	---

¹/₁₀₀



Hartner Standard	TR 300 HP D	HA	+0.005	Solid carbide			2.970 - 12.030	88403	166	8
------------------	-------------	----	--------	---------------	--	--	----------------	--------------	-----	---

High-performance reamers

TR 300
HP S



Solid carbide

H7



+0.005

The solid carbide HPC reamer HR 500 S operates with highest cutting rates and produces extremely high-quality holes. Therefore, it often enables considerable savings in the process costs. In addition, it provides very high process reliability.

Order no.
P (N/mm²)
M
K
N
S
H (HRC)
Surface finish
Discount group

88400

88402

•

•

•

•

○

○

•

•

•

•

63

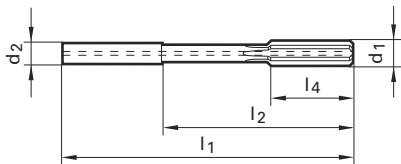
63

a

a

166

166



Availability

Code no.	d1 mm	d2 h6 mm	l1 mm	l2 mm	l4 mm	Z	Availability
2.970	2.970	4.000	68.00	40.00	12.00	4	•
2.980	2.980	4.000	68.00	40.00	12.00	4	•
2.990	2.990	4.000	68.00	40.00	12.00	4	•
3.000	3.000	4.000	68.00	40.00	12.00	4	•
3.010	3.010	4.000	68.00	40.00	12.00	4	•
3.020	3.020	4.000	68.00	40.00	12.00	4	•
3.030	3.030	4.000	68.00	40.00	12.00	4	•
3.500	3.500	4.000	68.00	40.00	12.00	4	•
3.970	3.970	4.000	68.00	40.00	12.00	4	•
3.980	3.980	4.000	68.00	40.00	12.00	4	•
3.990	3.990	4.000	68.00	40.00	12.00	4	•
4.000	4.000	4.000	68.00	40.00	12.00	4	•
4.010	4.010	4.000	68.00	40.00	12.00	4	•
4.020	4.020	4.000	68.00	40.00	12.00	4	•
4.030	4.030	4.000	68.00	40.00	12.00	4	•
4.500	4.500	6.000	76.00	40.00	12.00	4	•
4.970	4.970	6.000	76.00	40.00	12.00	4	•
4.980	4.980	6.000	76.00	40.00	12.00	4	•
4.990	4.990	6.000	76.00	40.00	12.00	4	•
5.000	5.000	6.000	76.00	40.00	12.00	4	•
5.010	5.010	6.000	76.00	40.00	12.00	4	•
5.020	5.020	6.000	76.00	40.00	12.00	4	•
5.030	5.030	6.000	76.00	40.00	12.00	4	•
5.500	5.500	6.000	76.00	40.00	12.00	4	•
5.970	5.970	6.000	76.00	40.00	12.00	4	•
5.980	5.980	6.000	76.00	40.00	12.00	4	•
5.990	5.990	6.000	76.00	40.00	12.00	4	•
6.000	6.000	6.000	76.00	40.00	12.00	4	•
6.010	6.010	6.000	76.00	40.00	12.00	4	•
6.020	6.020	6.000	76.00	40.00	12.00	4	•

a AlTiN nano

High-performance reamers

High-performance reamers

High-performance reamers

TR 300
HP S

WN

HA



EU

R



Solid carbide

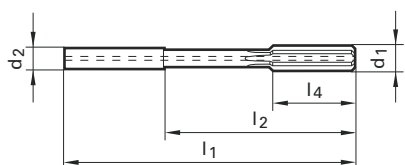
H7



+0.005

The solid carbide HPC reamer TR 300 HP S operates with highest cutting rates and produces extremely high-quality holes. Therefore, it often enables considerable savings in the process costs. In addition, it provides very high process reliability.

Order no.	88400	88402
P (N/mm ²)	●	●
M	●	●
K	○	○
N		
S	●	●
H (HRC)	63	63
Surface finish	a	a
Discount group	166	166



Code no.	d1 mm	d2 h6 mm	l1 mm	l2 mm	l4 mm	Z	Availability
6.030	6.030	6.000	76.00	40.00	12.00	4	●
6.500	6.500	8.000	101.00	65.00	16.00	6	●
7.000	7.000	8.000	101.00	65.00	16.00	6	●
7.500	7.500	8.000	101.00	65.00	16.00	6	●
7.970	7.970	8.000	101.00	65.00	16.00	6	●
7.980	7.980	8.000	101.00	65.00	16.00	6	●
7.990	7.990	8.000	101.00	65.00	16.00	6	●
8.000	8.000	8.000	101.00	65.00	16.00	6	●
8.010	8.010	8.000	101.00	65.00	16.00	6	●
8.020	8.020	8.000	101.00	65.00	16.00	6	●
8.030	8.030	8.000	101.00	65.00	16.00	6	●
8.500	8.500	10.000	101.00	61.00	19.00	6	●
9.000	9.000	10.000	101.00	61.00	19.00	6	●
9.500	9.500	10.000	101.00	61.00	19.00	6	●
9.970	9.970	10.000	101.00	61.00	19.00	6	●
9.980	9.980	10.000	101.00	61.00	19.00	6	●
9.990	9.990	10.000	101.00	61.00	19.00	6	●
10.000	10.000	10.000	101.00	61.00	19.00	6	●
10.010	10.010	10.000	101.00	61.00	19.00	6	●
10.020	10.020	10.000	101.00	61.00	19.00	6	●
10.030	10.030	10.000	101.00	61.00	19.00	6	●
10.500	10.500	12.000	130.00	85.00	19.00	6	●
11.000	11.000	12.000	130.00	85.00	19.00	6	●
11.500	11.500	12.000	130.00	85.00	19.00	6	●
11.970	11.970	12.000	130.00	85.00	19.00	6	●
11.980	11.980	12.000	130.00	85.00	19.00	6	●
11.990	11.990	12.000	130.00	85.00	19.00	6	●
12.000	12.000	12.000	130.00	85.00	19.00	6	●
12.010	12.010	12.000	130.00	85.00	19.00	6	●
12.020	12.020	12.000	130.00	85.00	19.00	6	●

a AITiN nano

High-performance reamers

TR 300
HP S



Solid carbide

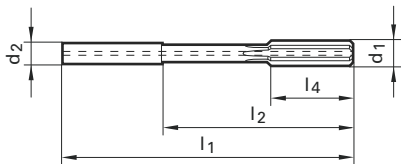
H7



+0,005

The solid carbide HPC reamer TR 300 HP S operates with highest cutting rates and produces extremely high-quality holes. Therefore, it often enables considerable savings in the process costs. In addition, it provides very high process reliability.

Order no.	88400	88402
P (N/mm ²)	●	●
M	●	●
K	○	○
N		
S	●	●
H (HRC)	63	63
Surface finish	a	a
Discount group	166	166



Code no.	d1 mm	d2 h6 mm	l1 mm	l2 mm	l4 mm	Z	Availability
12.030	12.030	12.000	130.00	85.00	19.00	6	●
13.000	13.000	14.000	130.00	85.00	22.00	6	●
14.000	14.000	14.000	130.00	85.00	22.00	6	●
15.000	15.000	16.000	150.00	102.00	22.00	6	●
16.000	16.000	16.000	150.00	102.00	22.00	6	●
17.000	17.000	18.000	150.00	102.00	25.00	6	●
18.000	18.000	18.000	150.00	102.00	25.00	6	●
19.000	19.000	20.000	150.00	100.00	25.00	6	●
20.000	20.000	20.000	150.00	100.00	25.00	6	●

High-performance reamers

High-performance reamers

TR 300
HP D



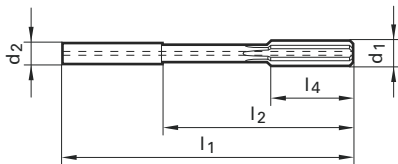
Solid carbide

H7



+0.005

The solid carbide HPC reamer TR 300 HP D operates with highest cutting rates and produces extremely high-quality holes. Therefore, it often enables considerable savings in the process costs. In addition, it provides very high process reliability. The special coolant supply with flutes in the shank ensures optimal chip evacuation and reliable cooling.



Order no.	88401	88403
P (N/mm ²)	●	●
M	●	●
K	○	○
N		
S	●	●
H (HRC)	63	63
Surface finish	a	a
Discount group	166	166



Code no.	d1 mm	d2 h6 mm	l1 mm	l2 mm	l4 mm	Z	Availability
6.030	6.030	6.000	76.00	40.00	12.00	4	●
6.500	6.500	8.000	101.00	65.00	16.00	6	●
7.000	7.000	8.000	101.00	65.00	16.00	6	●
7.500	7.500	8.000	101.00	65.00	16.00	6	●
7.970	7.970	8.000	101.00	65.00	16.00	6	●
7.980	7.980	8.000	101.00	65.00	16.00	6	●
7.990	7.990	8.000	101.00	65.00	16.00	6	●
8.000	8.000	8.000	101.00	65.00	16.00	6	●
8.010	8.010	8.000	101.00	65.00	16.00	6	●
8.020	8.020	8.000	101.00	65.00	16.00	6	●
8.030	8.030	8.000	101.00	65.00	16.00	6	●
8.500	8.500	10.000	101.00	61.00	19.00	6	●
9.000	9.000	10.000	101.00	61.00	19.00	6	●
9.500	9.500	10.000	101.00	61.00	19.00	6	●
9.970	9.970	10.000	101.00	61.00	19.00	6	●
9.980	9.980	10.000	101.00	61.00	19.00	6	●
9.990	9.990	10.000	101.00	61.00	19.00	6	●
10.000	10.000	10.000	101.00	61.00	19.00	6	●
10.010	10.010	10.000	101.00	61.00	19.00	6	●
10.020	10.020	10.000	101.00	61.00	19.00	6	●
10.030	10.030	10.000	101.00	61.00	19.00	6	●
10.500	10.500	12.000	130.00	85.00	19.00	6	●
11.000	11.000	12.000	130.00	85.00	19.00	6	●
11.500	11.500	12.000	130.00	85.00	19.00	6	●
11.970	11.970	12.000	130.00	85.00	19.00	6	●
11.980	11.980	12.000	130.00	85.00	19.00	6	●
11.990	11.990	12.000	130.00	85.00	19.00	6	●
12.000	12.000	12.000	130.00	85.00	19.00	6	●
12.010	12.010	12.000	130.00	85.00	19.00	6	●
12.020	12.020	12.000	130.00	85.00	19.00	6	●

AITiN nano

High-performance reamers

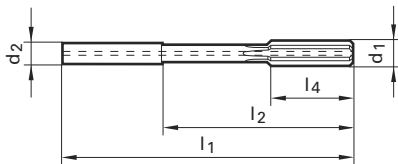
High-performance reamers

High-performance reamers

TR 300
HP D



The solid carbide HPC reamer TR 300 HP D operates with highest cutting rates and produces extremely high-quality holes. Therefore, it often enables considerable savings in the process costs. In addition, it provides very high process reliability. The special coolant supply with flutes in the shank ensures optimal chip evacuation and reliable cooling.



Code no.	d1 mm	d2 h6 mm	l1 mm	l2 mm	l4 mm	Z
12.030	12.030	12.000	130.00	85.00	19.00	6
13.000	13.000	14.000	130.00	85.00	22.00	6
14.000	14.000	14.000	130.00	85.00	22.00	6
15.000	15.000	16.000	150.00	102.00	22.00	6
16.000	16.000	16.000	150.00	102.00	22.00	6
17.000	17.000	18.000	150.00	102.00	25.00	6
18.000	18.000	18.000	150.00	102.00	25.00	6
19.000	19.000	20.000	150.00	100.00	25.00	6
20.000	20.000	20.000	150.00	100.00	25.00	6

Solide carbide



H7



+0,005

Order no.
P (N/mm²)
M
K
N
S
H (HRC)
Surface finish
Discount group

88401

88403



Availability







●
●
●
●
●
●
●
●
●
●















Machine reamers

Standard	Form	Shank form	Diameter tolerance	Tool material	Surface finish	Hole type	d1	Order no.	Discount group	Standard range page
----------	------	------------	--------------------	---------------	----------------	-----------	----	-----------	----------------	---------------------

NC machine reamers

										
Hartner Standard	B	HA	+0.004 +0.005	Solid carbide			0.980 - 12.050	88350	120	12
										
Hartner Standard	B	HA	H7	Solid carbide			3.000 - 12.000	88351	120	12

Machine reamers

										
~ DIN 8050	A	cyl.	H7	Carbide			5.000 - 20.000	88352	120	17
										
~ DIN 8050	B	cyl.	H7	Carbide			5.000 - 20.000	88353	120	17
										
~ DIN 8051	A	MK	H7	Carbide			5.000 - 40.000	88354	120	18
										
~ DIN 8051	B	MK	H7	Carbide			6.000 - 32.000	88355	120	18

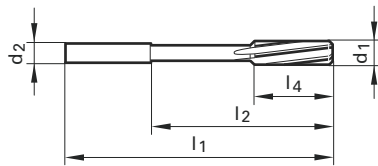
 bright

NC machine reamers



Ø > 3.75 mm with extremely unequal flute spacing
 Tolerance for Order no. 88350:
 ≤ Ø 5.50 mm: 0.000/+0.004
 > Ø 5.50 mm: 0.000/+0.005

NC machine reamers similar to DIN 8093 with straight shank (h6) for standardised tool clamping in hydraulic or shrink fit chucks offer highest concentricity and process reliability for the production of holes to required tolerances.



Solid carbide

		+0.004 +0.005		H7
Order no.	88350		88351	
P (N/mm²)	●		●	
M	○		○	
K	●		●	
N	●		●	
S	○		○	
H (HRC)	52		52	
Surface finish	○		○	
Discount group	120		120	



Code no.	d1 mm	d2 h6 mm	l1 mm	l2 mm	l4 mm	Z	Availability
3.030	3.030	4.000	64.00	36.00	17.00	6	●
3.100	3.100	4.000	68.00	40.00	18.00	6	●
3.200	3.200	4.000	68.00	40.00	18.00	6	●
3.300	3.300	4.000	68.00	40.00	18.00	6	●
3.400	3.400	4.000	74.00	46.00	20.00	6	●
3.500	3.500	4.000	74.00	46.00	20.00	6	●
3.600	3.600	4.000	74.00	46.00	20.00	6	●
3.700	3.700	4.000	74.00	46.00	20.00	6	●
3.800	3.800	4.000	77.00	45.00	21.00	6	●
3.970	3.970	4.000	77.00	45.00	21.00	6	●
3.980	3.980	4.000	77.00	45.00	21.00	6	●
3.990	3.990	4.000	77.00	45.00	21.00	6	●
4.000	4.000	4.000	77.00	45.00	21.00	6	●
4.010	4.010	4.000	77.00	45.00	21.00	6	●
4.020	4.020	4.000	77.00	45.00	21.00	6	●
4.030	4.030	4.000	77.00	45.00	21.00	6	●
4.100	4.100	6.000	82.00	50.00	23.00	6	●
4.200	4.200	6.000	82.00	50.00	23.00	6	●
4.300	4.300	6.000	82.00	50.00	23.00	6	●
4.400	4.400	6.000	82.00	50.00	23.00	6	●
4.500	4.500	6.000	82.00	50.00	23.00	6	●
4.600	4.600	6.000	82.00	50.00	23.00	6	●
4.700	4.700	6.000	82.00	50.00	23.00	6	●
4.800	4.800	6.000	93.00	59.00	26.00	6	●
4.900	4.900	6.000	93.00	59.00	26.00	6	●
4.970	4.970	6.000	93.00	59.00	26.00	6	●
4.980	4.980	6.000	93.00	59.00	26.00	6	●
4.990	4.990	6.000	93.00	59.00	26.00	6	●
5.000	5.000	6.000	93.00	59.00	26.00	6	●
5.010	5.010	6.000	93.00	59.00	26.00	6	●

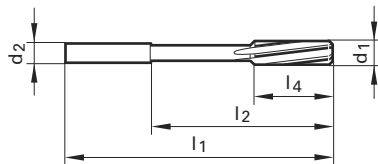
○ bright

NC machine reamers



Ø > 3.75 mm with extremely unequal flute spacing
 Tolerance for Order no. 88350:
 ≤ Ø 5.50 mm: 0.000/+0.004
 > Ø 5.50 mm: 0.000/+0.005

NC machine reamers similar to DIN 8093 with straight shank (h6) for standardised tool clamping in hydraulic or shrink fit chucks offer highest concentricity and process reliability for the production of holes to required tolerances.



Solid carbide



Order no.	88350	88351
P (N/mm ²)	●	●
M	○	○
K	●	●
N	●	●
S	○	○
H (HRC)	52	52
Surface finish	○	○
Discount group	120	120



Code no.	d1 mm	d2 h6 mm	l1 mm	l2 mm	l4 mm	Z	Availability
5.020	5.020	6.000	93.00	59.00	26.00	6	●
5.030	5.030	6.000	93.00	59.00	26.00	6	●
5.100	5.100	6.000	93.00	59.00	26.00	6	●
5.200	5.200	6.000	93.00	59.00	26.00	6	●
5.300	5.300	6.000	93.00	59.00	26.00	6	●
5.500	5.500	6.000	93.00	57.00	26.00	6	●
5.600	5.600	6.000	93.00	57.00	26.00	6	●
5.700	5.700	6.000	93.00	57.00	26.00	6	●
5.800	5.800	6.000	93.00	57.00	26.00	6	●
5.970	5.970	6.000	93.00	57.00	26.00	6	●
5.980	5.980	6.000	93.00	57.00	26.00	6	●
5.990	5.990	6.000	93.00	57.00	26.00	6	●
6.000	6.000	6.000	93.00	57.00	26.00	6	●
6.010	6.010	6.000	93.00	57.00	26.00	6	●
6.020	6.020	6.000	93.00	57.00	26.00	6	●
6.030	6.030	6.000	93.00	57.00	26.00	6	●
6.100	6.100	8.000	101.00	63.00	28.00	6	●
6.200	6.200	8.000	101.00	63.00	28.00	6	●
6.300	6.300	8.000	101.00	63.00	28.00	6	●
6.400	6.400	8.000	101.00	63.00	28.00	6	●
6.500	6.500	8.000	101.00	63.00	28.00	6	●
6.600	6.600	8.000	101.00	63.00	28.00	6	●
6.700	6.700	8.000	101.00	63.00	28.00	6	●
6.800	6.800	8.000	109.00	69.00	31.00	6	●
7.000	7.000	8.000	109.00	69.00	31.00	6	●
7.100	7.100	8.000	109.00	69.00	31.00	6	●
7.200	7.200	8.000	109.00	69.00	31.00	6	●
7.400	7.400	8.000	109.00	69.00	31.00	6	●
7.500	7.500	8.000	109.00	69.00	31.00	6	●
7.700	7.700	8.000	117.00	75.00	33.00	6	●

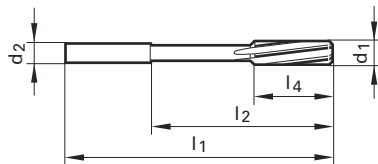
○ bright

NC machine reamers



Ø > 3.75 mm with extremely unequal flute spacing
 Tolerance for Order no. 88350:
 ≤ Ø 5.50 mm: 0.000/+0.004
 > Ø 5.50 mm: 0.000/+0.005

NC machine reamers similar to DIN 8093 with straight shank (h6) for standardised tool clamping in hydraulic or shrink fit chucks offer highest concentricity and process reliability for the production of holes to required tolerances.



Solid carbide

		+0,004 +0,005		H7
Order no.	88350		88351	
P (N/mm²)	●		●	
M	○		○	
K	●		●	
N	●		●	
S	○		○	
H (HRC)	52		52	
Surface finish	○		○	
Discount group	120		120	



Code no.	d1 mm	d2 h6 mm	l1 mm	l2 mm	l4 mm	Z	Availability
7.800	7.800	8.000	117.00	75.00	33.00	6	●
7.900	7.900	8.000	117.00	75.00	33.00	6	●
7.970	7.970	8.000	117.00	75.00	33.00	6	●
7.980	7.980	8.000	117.00	75.00	33.00	6	●
7.990	7.990	8.000	117.00	75.00	33.00	6	●
8.000	8.000	8.000	117.00	75.00	33.00	6	●
8.010	8.010	8.000	117.00	75.00	33.00	6	●
8.020	8.020	8.000	117.00	75.00	33.00	6	●
8.030	8.030	8.000	117.00	75.00	33.00	6	●
8.040	8.040	8.000	117.00	75.00	33.00	6	●
8.100	8.100	10.000	117.00	75.00	33.00	6	●
8.200	8.200	10.000	117.00	75.00	33.00	6	●
8.300	8.300	10.000	117.00	75.00	33.00	6	●
8.400	8.400	10.000	117.00	75.00	33.00	6	●
8.500	8.500	10.000	117.00	75.00	33.00	6	●
8.600	8.600	10.000	117.00	75.00	33.00	6	●
8.700	8.700	10.000	125.00	81.00	36.00	6	●
8.800	8.800	10.000	125.00	81.00	36.00	6	●
8.900	8.900	10.000	125.00	81.00	36.00	6	●
9.000	9.000	10.000	125.00	81.00	36.00	6	●
9.100	9.100	10.000	125.00	81.00	36.00	6	●
9.300	9.300	10.000	125.00	81.00	36.00	6	●
9.500	9.500	10.000	125.00	81.00	36.00	6	●
9.600	9.600	10.000	125.00	81.00	36.00	6	●
9.700	9.700	10.000	133.00	87.00	38.00	6	●
9.800	9.800	10.000	133.00	87.00	38.00	6	●
9.900	9.900	10.000	133.00	87.00	38.00	6	●
9.970	9.970	10.000	133.00	87.00	38.00	6	●
9.980	9.980	10.000	133.00	87.00	38.00	6	●
9.990	9.990	10.000	133.00	87.00	38.00	6	●

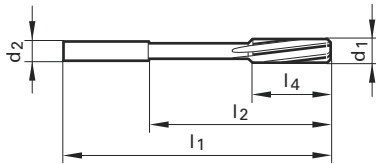
○ bright

NC machine reamers



Ø > 3.75 mm with extremely unequal flute spacing
 Tolerance for Order no. 88350:
 ≤ Ø 5.50 mm: 0.000/+0.004
 > Ø 5.50 mm: 0.000/+0.005

NC machine reamers similar to DIN 8093 with straight shank (h6) for standardised tool clamping in hydraulic or shrink fit chucks offer highest concentricity and process reliability for the production of holes to required tolerances.



Solid carbide	
	+0,004 +0,005
	H7

Order no.	88350	88351
P (N/mm ²)	●	●
M	○	○
K	●	●
N	●	●
S	○	○
H (HRC)	52	52
Surface finish	○	○
Discount group	120	120



Code no.	d1 mm	d2 h6 mm	l1 mm	l2 mm	l4 mm	Z	Availability
10.000	10.000	10.000	133.00	87.00	38.00	6	●
10.010	10.010	10.000	133.00	87.00	38.00	6	●
10.020	10.020	10.000	133.00	87.00	38.00	6	●
10.030	10.030	10.000	133.00	87.00	38.00	6	●
10.040	10.040	10.000	133.00	87.00	38.00	6	●
10.050	10.050	10.000	133.00	87.00	38.00	6	●
10.100	10.100	10.000	133.00	87.00	38.00	6	●
10.200	10.200	10.000	133.00	87.00	38.00	6	●
10.300	10.300	10.000	133.00	87.00	38.00	6	●
10.400	10.400	10.000	133.00	87.00	38.00	6	●
10.500	10.500	10.000	133.00	87.00	38.00	6	●
10.600	10.600	10.000	133.00	87.00	38.00	6	●
11.000	11.000	10.000	142.00	96.00	41.00	6	●
11.100	11.100	10.000	142.00	96.00	41.00	6	●
11.200	11.200	10.000	142.00	96.00	41.00	6	●
11.300	11.300	10.000	142.00	96.00	41.00	6	●
11.500	11.500	10.000	142.00	96.00	41.00	6	●
11.600	11.600	10.000	142.00	96.00	41.00	6	●
11.800	11.800	10.000	142.00	96.00	41.00	6	●
11.900	11.900	12.000	151.00	105.00	44.00	6	●
11.970	11.970	12.000	151.00	105.00	44.00	6	●
11.980	11.980	12.000	151.00	105.00	44.00	6	●
11.990	11.990	12.000	151.00	105.00	44.00	6	●
12.000	12.000	12.000	151.00	105.00	44.00	6	●
12.010	12.010	12.000	151.00	105.00	44.00	6	●
12.020	12.020	12.000	151.00	105.00	44.00	6	●
12.030	12.030	12.000	151.00	105.00	44.00	6	●
12.040	12.040	12.000	151.00	105.00	44.00	6	●
12.050	12.050	12.000	151.00	105.00	44.00	6	●

○ bright

Machine reamers

H7

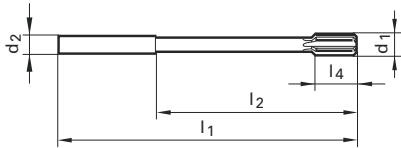
~DIN
8050

Cyl

EU

R

- ≤ Ø 9.50 mm: solid carbide
- > Ø 9.50 mm: carbide head
- Allocation to hartner standard
- ≤ Ø 9.50 mm with ext. centres on both ends
- > Ø 9.50 mm with int. centres on both ends



Code no.	d1 mm	d2 h6 mm	l1 mm	l2 mm	l4 mm	Z
5.000	5.000	5.000	86.00	52.00	12.00	6
6.000	6.000	5.600	93.00	57.00	12.00	6
7.000	7.000	7.100	109.00	69.00	16.00	6
8.000	8.000	8.000	117.00	75.00	16.00	6
9.000	9.000	9.000	125.00	81.00	19.00	6
10.000	10.000	10.000	133.00	87.00	12.00	6
11.000	11.000	10.000	142.00	96.00	12.00	6
12.000	12.000	10.000	151.00	105.00	12.00	6
13.000	13.000	10.000	151.00	105.00	12.00	6
14.000	14.000	12.000	160.00	110.00	16.00	6
15.000	15.000	12.000	162.00	112.00	16.00	6
16.000	16.000	12.000	170.00	120.00	19.00	6
18.000	18.000	14.000	182.00	130.00	19.00	6
20.000	20.000	16.000	195.00	137.00	19.00	6

Carbide



A



B

Order no.	88352	88353
P (N/mm ²)	1400	1400
M	○	○
K	●	●
N	●	●
S	○	○
H (HRC)	48	48
Surface finish	○	○
Discount group	120	120



Availability

●	●
●	●
●	●
●	●
●	●
●	●
●	●
●	●
●	●
●	●
●	●
●	●
●	●
●	●
●	●
●	●
●	●

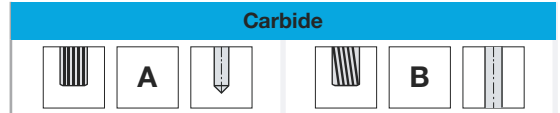
Machine reamers

○ bright

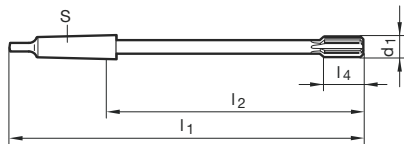
Machine reamers



≤ Ø 9.50 mm: solid carbide
 > Ø 9.50 mm: carbide head
 Allocation to hartner standard
 ≤ Ø 9.50 mm with external centre on cutting end
 internal centre on shank end
 > Ø 9.50 mm with internal centres on both ends



Order no.	88354	88355
P (N/mm ²)	1400	1400
M	○	○
K	●	●
N	●	●
S	○	○
H (HRC)	48	48
Surface finish	○	○
Discount group	120	120









Code no.	d1 mm	S	l1 mm	l2 mm	l4 mm	Z	Availability
5.000	5.000	1	133.00	71.00	12.00	6	●
6.000	6.000	1	138.00	76.00	12.00	6	● ●
7.000	7.000	1	150.00	88.00	16.00	6	●
8.000	8.000	1	156.00	94.00	16.00	6	● ●
10.000	10.000	1	168.00	106.00	12.00	6	● ●
11.000	11.000	1	175.00	113.00	12.00	6	● ●
12.000	12.000	1	182.00	120.00	12.00	6	● ●
13.000	13.000	1	182.00	120.00	12.00	6	● ●
14.000	14.000	1	189.00	127.00	16.00	6	● ●
15.000	15.000	2	204.00	129.00	16.00	6	● ●
16.000	16.000	2	210.00	135.00	19.00	6	● ●
17.000	17.000	2	214.00	139.00	19.00	6	● ●
18.000	18.000	2	219.00	144.00	19.00	6	● ●
20.000	20.000	2	228.00	153.00	19.00	6	● ●
21.000	21.000	2	232.00	157.00	22.00	6	● ●
22.000	22.000	2	237.00	162.00	22.00	6	● ●
23.000	23.000	2	241.00	166.00	22.00	6	● ●
24.000	24.000	3	268.00	174.00	22.00	8	● ●
25.000	25.000	3	268.00	174.00	22.00	8	● ●
26.000	26.000	3	273.00	179.00	22.00	8	● ●
28.000	28.000	3	277.00	183.00	25.00	8	● ●
30.000	30.000	3	281.00	187.00	25.00	8	● ●
32.000	32.000	4	317.00	199.50	25.00	8	● ●
40.000	40.000	4	329.00	211.50	25.00	8	● ●

○ bright













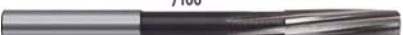








High speed steel reamers

Standard	Form	Shank form	Diameter tolerance	Tool material	Surface finish	Hole type	d1	Order no.	Discount group	Standard range page
----------	------	------------	--------------------	---------------	----------------	-----------	----	-----------	----------------	---------------------

NC machine reamers

	DIN 212-3	B	HA	+0,004 +0,005	HSS-E			1.000 - 12.020	88300	105	20
	DIN 212-3	B	HA	H7	HSS-E			1.500 - 20.000	88301	105	20

Machine reamers

	DIN 212	A	cyl.	H7	HSS-E			1.000 - 5.500	88302	105	25
	DIN 212	B	cyl.	H7	HSS-E			1.000 - 3.700	88304	105	25
	DIN 212-2	A	cyl.	H7	HSS-E			4.000 - 20.000	88305	105	26
	DIN 212-2	B	cyl.	H7	HSS-E			3.800 - 20.000	88306	105	26
	DIN 212	B	cyl.	+0,004 +0,005	HSS-E			0.950 - 12.050	88311	105	28
	DIN 208	A	MK	H7	HSS-E			3.000 - 40.000	88307	105	30
	DIN 208	B	MK	H7	HSS-E			3.000 - 50.000	88308	105	30

 bright

NC machine reamers

HSS-E

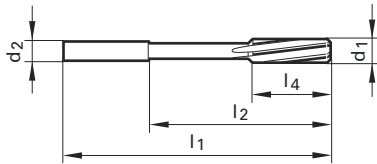


≤ Ø 3.75 mm with external centres on both ends
 > Ø 3.75 mm with internal centres on both ends
 Tolerance for Order no. 88300:
 ≤ Ø 5.50 mm: 0.000/+0.004
 > Ø 5.50 mm: 0.000/+0.005

The combination of NC machine reamer and hydraulic, high precision clamping or shrink fit chuck respectively offers highest concentricity and process reliability for the production of holes to required tolerances.

NC machine reamers are similar to DIN 212 with straight shank (h6) for standardised tool clamping in hydraulic or shrink fit chucks. Short delivery for intermediate sizes.

Order no.	88300	88301
P (N/mm ²)	1000	1000
M	○	○
K	●	●
N	●	●
S	○	○
H (HRC)		
Surface finish	○	○
Discount group	105	105



Availability

Code no.	d1 mm	d2 h6 mm	l1 mm	l2 mm	l4 mm	Z	Availability
10.010	10.010	10.000	133.00	93.00	38.00	6	●
10.020	10.020	10.000	133.00	93.00	38.00	6	●
10.030	10.030	10.000	133.00	93.00	38.00	6	●
11.000	11.000	10.000	142.00	102.00	41.00	6	●
11.980	11.980	10.000	151.00	111.00	44.00	6	●
11.990	11.990	10.000	151.00	111.00	44.00	6	●
12.000	12.000	10.000	151.00	111.00	44.00	6	●
12.010	12.010	10.000	151.00	111.00	44.00	6	●
12.020	12.020	10.000	151.00	111.00	44.00	6	●
13.000	13.000	10.000	151.00	111.00	44.00	6	●
14.000	14.000	14.000	160.00	115.00	47.00	8	●
15.000	15.000	14.000	162.00	117.00	50.00	8	●
16.000	16.000	14.000	170.00	125.00	52.00	8	●
17.000	17.000	14.000	175.00	130.00	54.00	8	●
18.000	18.000	14.000	182.00	137.00	56.00	8	●
19.000	19.000	16.000	189.00	141.00	58.00	8	●
20.000	20.000	16.000	195.00	147.00	60.00	8	●

○ bright

Machine reamers

HSS-E

H7

DIN 212

Cyl



A

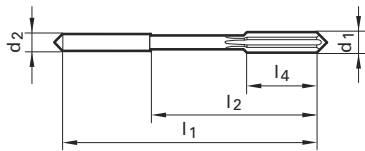


B



≤ Ø 3.75 mm with external centres on both ends
 > Ø 3.75 mm with internal centres on both ends

Order no.	88302	88304
P (N/mm ²)	1000	1000
M	○	○
K	●	●
N	●	●
S	○	○
H (HRC)		
Surface finish	○	○
Discount group	105	105



Availability

Code no.	d1 mm	d2 h6 mm	l1 mm	l2 mm	l4 mm	Z	Availability
1.000	1.000	1.000	34.00	15.00	5.50	3	● ●
1.200	1.200	1.200	38.00	16.50	7.50	3	● ●
1.300	1.300	1.300	38.00	16.50	7.50	3	● ●
1.400	1.400	1.400	40.00	18.00	8.00	3	● ●
1.500	1.500	1.500	40.00	18.00	8.00	3	● ●
1.600	1.600	1.600	43.00	20.00	9.00	3	● ●
1.800	1.800	1.800	46.00	22.00	10.00	4	● ●
1.900	1.900	1.900	46.00	22.00	10.00	4	● ●
2.000	2.000	2.000	49.00	24.00	11.00	4	● ●
2.200	2.200	2.200	53.00	25.00	12.00	4	● ●
2.300	2.300	2.300	53.00	25.00	12.00	4	● ●
2.500	2.500	2.500	57.00	29.00	14.00	4	● ●
2.700	2.700	2.800	61.00	33.00	15.00	6	● ●
2.800	2.800	2.800	61.00	33.00	15.00	6	● ●
2.900	2.900	3.000	61.00	33.00	15.00	6	● ●
3.000	3.000	3.000	61.00	33.00	15.00	6	● ●
3.200	3.200	3.200	65.00	37.00	16.00	6	● ●
3.500	3.500	3.500	70.00	42.00	18.00	6	● ●
3.700	3.700	3.500	70.00	42.00	18.00	6	● ●
5.500	5.500	5.600	93.00	57.00	26.00	6	● ●

High speed steel reamers

○ bright

Machine reamers

H7

DIN 212-2

Cyl



≤ Ø 3.75 mm with external centres on both ends
 > Ø 3.75 mm with internal centres on both ends

HSS-E



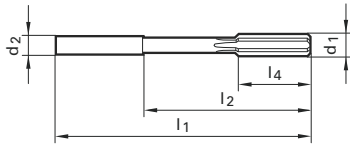
A



B



Order no.	88305	88306
P (N/mm ²)	1000	1000
M	○	○
K	●	●
N	●	●
S	○	○
H (HRC)		
Surface finish	○	○
Discount group	105	105



High speed steel reamers

Code no.	d1 mm	d2 h6 mm	l1 mm	l2 mm	l4 mm	Z	Availability	
3.800	3.800	4.000	75.00	47.00	19.00	6		●
4.000	4.000	4.000	75.00	47.00	19.00	6	●	●
4.400	4.400	4.500	80.00	52.00	21.00	6		●
4.500	4.500	4.500	80.00	52.00	21.00	6	●	●
4.700	4.700	4.500	80.00	52.00	21.00	6		●
4.900	4.900	5.000	86.00	58.00	23.00	6		●
5.000	5.000	5.000	86.00	58.00	23.00	6	●	●
5.100	5.100	5.000	86.00	58.00	23.00	6		●
5.500	5.500	5.600	93.00	57.00	26.00	6	●	●
6.000	6.000	5.600	93.00	57.00	26.00	6	●	●
6.100	6.100	6.300	101.00	65.00	28.00	6		●
6.200	6.200	6.300	101.00	65.00	28.00	6		●
6.500	6.500	6.300	101.00	65.00	28.00	6		●
6.900	6.900	7.100	109.00	73.00	31.00	6		●
7.000	7.000	7.100	109.00	73.00	31.00	6	●	●
7.100	7.100	7.100	109.00	73.00	31.00	6		●
7.200	7.200	7.100	109.00	73.00	31.00	6		●
7.400	7.400	7.100	109.00	73.00	31.00	6		●
7.500	7.500	7.100	109.00	73.00	31.00	6		●
8.000	8.000	8.000	117.00	81.00	33.00	6	●	●
8.100	8.100	8.000	117.00	81.00	33.00	6		●
8.300	8.300	8.000	117.00	81.00	33.00	6		●
8.500	8.500	8.000	117.00	81.00	33.00	6	●	●
9.000	9.000	9.000	125.00	85.00	36.00	6	●	●
9.200	9.200	9.000	125.00	85.00	36.00	6		●
9.400	9.400	9.000	125.00	85.00	36.00	6		●
9.500	9.500	9.000	125.00	85.00	36.00	6	●	●
9.800	9.800	10.000	133.00	93.00	38.00	6		●
9.900	9.900	10.000	133.00	93.00	38.00	6		●
10.000	10.000	10.000	133.00	93.00	38.00	6	●	●

○ bright

Machine reamers

HSS-E

H7

DIN
212-2

Cyl



A

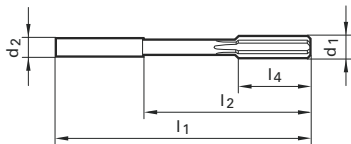


B



≤ Ø 3.75 mm with external centres on both ends
> Ø 3.75 mm with internal centres on both ends

Order no.	88305	88306
P (N/mm ²)	1000	1000
M	○	○
K	●	●
N	●	●
S	○	○
H (HRC)		
Surface finish	○	○
Discount group	105	105



Code no.	d1 mm	d2 h6 mm	l1 mm	l2 mm	l4 mm	Z	Availability	
10.100	10.100	10.000	133.00	93.00	38.00	6		●
10.500	10.500	10.000	133.00	93.00	38.00	6	●	
10.700	10.700	10.000	142.00	102.00	41.00	6		●
11.000	11.000	10.000	142.00	102.00	41.00	6	●	●
11.500	11.500	10.000	142.00	102.00	41.00	6	●	●
12.000	12.000	10.000	151.00	111.00	44.00	6	●	●
13.000	13.000	10.000	151.00	111.00	44.00	6	●	●
14.000	14.000	12.500	160.00	115.00	47.00	8	●	●
15.000	15.000	12.500	162.00	117.00	50.00	8	●	●
16.000	16.000	12.500	170.00	125.00	52.00	8	●	●
17.000	17.000	14.000	175.00	130.00	54.00	8	●	●
18.000	18.000	14.000	182.00	137.00	56.00	8	●	●
19.000	19.000	16.000	189.00	141.00	58.00	8	●	●
20.000	20.000	16.000	195.00	147.00	60.00	8	●	●

○ bright

Machine reamers

H7

DIN 208



Ø 3.00 mm with external centre on cutting end, with internal centre on shank end
 > Ø 3.00 mm with internal centres on both ends
 ≤ Ø 4.00 mm to hartner standard

HSS-E



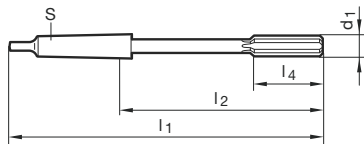
A



B



Order no.	88307	88308
P (N/mm ²)	1000	1000
M	○	○
K	●	●
N	●	●
S	○	○
H (HRC)		
Surface finish	○	○
Discount group	105	105



Code no.	d1 mm	S	l1 mm	l2 mm	l4 mm	Z	Availability	
3.000	3.000	1	115.00	53.00	15.00	6	●	●
4.000	4.000	1	125.00	63.00	19.00	6	●	●
5.000	5.000	1	133.00	71.00	23.00	6	●	●
5.100	5.100	1	133.00	71.00	23.00	6	●	
5.500	5.500	1	138.00	76.00	26.00	6	●	
6.000	6.000	1	138.00	76.00	26.00	6	●	●
6.100	6.100	1	144.00	82.00	28.00	6	●	
6.200	6.200	1	144.00	82.00	28.00	6	●	
6.500	6.500	1	144.00	82.00	28.00	6	●	
7.000	7.000	1	150.00	88.00	31.00	6		●
7.500	7.500	1	150.00	88.00	31.00	6	●	
8.000	8.000	1	156.00	94.00	33.00	6	●	●
8.500	8.500	1	156.00	94.00	33.00	6	●	
9.000	9.000	1	162.00	100.00	36.00	6	●	●
9.500	9.500	1	162.00	100.00	36.00	6	●	
9.800	9.800	1	168.00	106.00	38.00	6	●	
10.000	10.000	1	168.00	106.00	38.00	6	●	●
10.100	10.100	1	168.00	106.00	38.00	6	●	
11.000	11.000	1	175.00	113.00	41.00	6	●	●
12.000	12.000	1	182.00	120.00	44.00	6	●	●
13.000	13.000	1	182.00	120.00	44.00	6	●	●
14.000	14.000	1	189.00	127.00	47.00	8	●	●
15.000	15.000	2	204.00	129.00	50.00	8	●	●
15.700	15.700	2	210.00	135.00	52.00	8	●	
16.000	16.000	2	210.00	135.00	52.00	8	●	●
17.000	17.000	2	214.00	139.00	54.00	8	●	●
18.000	18.000	2	219.00	144.00	56.00	8	●	●
19.000	19.000	2	223.00	148.00	58.00	8	●	●
19.500	19.500	2	228.00	153.00	60.00	8	●	
20.000	20.000	2	228.00	153.00	60.00	8	●	●

○ bright

High speed steel reamers

Hand reamers

Standard	Form	Shank form	Diameter tolerance	Tool material	Surface finish	Hole type	d1	Order no.	Discount group	Standard range page
----------	------	------------	--------------------	---------------	----------------	-----------	----	-----------	----------------	---------------------

Hand reamers



DIN 206	A	cyl.	H7	HSS			2.000 - 49.000	88309	105	33
---------	---	------	----	-----	---	---	----------------	--------------	-----	----



DIN 206	B	cyl.	H7	HSS			1.400 - 43.000	88310	105	33
---------	---	------	----	-----	---	---	----------------	--------------	-----	----

Maximum performance for all materials


Our comprehensive TR 300 HP range includes reamers for the machining of most materials. The perfect combination of special geometries, tool material and coatings provides optimal machining results for all reaming operations.



Application recommendation for solid carbide reamers

Tools with bold feed column no. are preferred choice.

For blind holes with close diameter tolerances choose straight-fluted reamers.

Order no. 

Standard/DIN

Tool material

Surface finish

Form


Cooling

Counter-sink Ø mm	Feed column no.						
	71	72	73	74	75	76	77
	f (mm/U)						
< 4.00	0.080	0.100	0.125	0.300	0.500	0.800	1.000
4.00	0.100	0.125	0.160	0.300	0.500	1.000	1.200
5.00	0.100	0.125	0.160	0.400	0.600	1.000	1.400
6.30	0.125	0.160	0.200	0.400	0.700	1.200	1.600
8.00	0.160	0.200	0.250	0.600	1.000	1.800	2.400
10.00	0.200	0.250	0.315	0.600	1.200	1.800	2.400
12.50	0.200	0.250	0.315	0.800	1.200	2.000	2.500
16.00	0.250	0.315	0.400	0.800	1.400	2.200	2.600
20.00	0.315	0.400	0.500	0.800	1.400	2.200	2.600
25.00	0.400	0.500	0.630	1.000	1.600	2.500	3.000
31.50	0.400	0.500	0.630	1.000	2.000	3.000	3.600
40.00	0.500	0.630	0.800	1.200	2.000	3.000	3.600
50.00	0.630	0.800	1.000	1.400	2.200	3.200	3.600
> 50.00	0.800	1.000	1.250	1.600	2.200	3.200	3.600

Coolant:

- Air
- Neat oil
- Soluble oil

Cutting direction:

-  right-hand cutting

Material group	Material examples, new description (old description in brackets) Figures in bold = material no. to DIN EN	Tensile str. MPa (N/mm ²)	Hard- ness	Coolant
Common structural steels	1.0035 S185(St33), 1.0486 P275N(StE285), 1.0345 P235GH(H1), 1.0425 P265GH(H2) 1.0050 E295 (St50-2), 1.0070 E360 (St70-2), 1.8937 P500NH (WStE500)	≤500 ≤1000		<input type="radio"/> <input type="radio"/>
Free-cutting steels	1.0718 11SMnPb30 (9SMnPb28), 1.0736 11SMn37 (9SMn36) 1.0727 46S20 (45S20), 1.0728 (60S20), 1.0757 46SPb20 (45SPb20)	≤850 ≤1000		<input type="radio"/> <input type="radio"/>
Unalloyed heat-treatable steels	1.0402 C22, 1.1178 C30E (Ck30) 1.0503 C45, 1.1191 C45E (Ck45) 1.0601 C60, 1.1221 C60E (Ck60)	≤700 ≤850 ≤1000		<input type="radio"/> <input type="radio"/> <input type="radio"/>
Alloyed heat-treatable steels	1.5131 50MnSi4, 1.7003 38Cr2, 1.7030 28Cr4 1.5710 36NiCr6, 1.7035 41Cr4, 1.7225 42CrMo4	≤1000 ≤1400		<input type="radio"/> <input type="radio"/>
Unalloyed case hard. steels	1.0301 (C10), 1.1121 C10E (Ck10)	≤850		<input type="radio"/>
Alloyed case hardened steels	1.7276 10CrMo11, 1.5125 11MnSi6 1.5752 15NiCr13, 1.7131 16MnCr5, 1.7264 20CrMo5	≤1000 ≤1400		<input checked="" type="radio"/> <input checked="" type="radio"/>
Nitriding steels	1.8504 34CrAl6 1.8519 31CrMoV9, 1.8550 34CrAlNi7	≤1000 ≤1400		<input type="radio"/> <input checked="" type="radio"/>
Tool steels	1.1750 C75W, 1.2067 102Cr6, 1.2307 29CrMoV9 1.2080 X210Cr12, 1.2083 X42Cr13, 1.2419 105WCr6, 1.2767 X45NiCrMo4	≤850 ≤1400		<input type="radio"/> <input checked="" type="radio"/>
High speed steels	1.3243 S 6-5-2-5, 1.3343 S 6-5-2, 1.3344 S 6-5-3	≤1400		<input checked="" type="radio"/>
Spring steels	1.5026 55Si7, 1.7176 55Cr3, 1.8159 51CrV4 (51CrV4)		≤350 HB	<input checked="" type="radio"/>
Stainless steels, sulphured	1.4005 X12CrS13, 1.4104 X14CrMoS17, 1.4105 X6CrMoS17, 1.4305 X8CrNiS18-9	≤900		<input checked="" type="radio"/>
austenitic	1.4301 X5CrNi18-10 (V2A), 1.4541 X6CrNiTi18-10, 1.4571 X6CrNiMoTi 17-12-2 (V4A)	≤1100		<input checked="" type="radio"/>
martensitic	1.4057 X20CrNi172 (X17CrNi16-2), 1.4122 X39CrMo17-1, 1.4521 X2CrMoTi18-2	≤1500		<input checked="" type="radio"/>
Hardened steels	-		≤48 HRC ≤63 HRC	<input checked="" type="radio"/> <input checked="" type="radio"/>
Special alloys	Nimonic, Inconel, Monel, Hastelloy	≤2000		<input checked="" type="radio"/>
Cast iron	0.6010 EN-GJL-100 (GG10), 0.6020 EN-GJL-200 (GG20) 0.6025 EN-GJL-250 (GG25), 0.6035 EN-GJL-350 (GG35)	≤240 HB ≤350 HB		<input type="radio"/> <input type="radio"/>
Spheroidal graphite iron and malleable cast iron	0.7050 EN-GJS-500-7 (GGG50), 0.8035 EN-GJMW-350-4 (GTW35) 0.7070 EN-GJS-700-2 (GGG70), 0.8170 EN-GJMB-700-2 (GTS70)	≤240 HB ≤350 HB		<input type="radio"/> <input type="radio"/>
Chilled cast iron	-		≤350 HB	<input type="radio"/>
Ti and Ti-alloys	3.7024 Ti99.5, 3.7114 TiAl5Sn2.5, 3.7124 TiCu2 3.7154 TiAl6Zr5, 3.7165 TiAl6V4, 3.7184 TiAl4Mo4Sn2.5, - TiAl8Mo1V1	≤850 ≤1400		<input checked="" type="radio"/> <input checked="" type="radio"/>
Aluminium and Al-alloys	3.0255 Al99.5, 3.2315 AlMgSi1, 3.3515 AlMg1 3.0615 AlMgSiPb, 3.1325 AlCuMg1, 3.3245 AlMg3Si, 3.4365 AlZnMgCu1.5	≤400 ≤650		<input type="radio"/> <input type="radio"/>
Al wrought alloys	3.2131 G-AlSi5Cu1, 3.2153 G-AlSi7Cu3, 3.2573 G-AlSi9 3.2581 G-AlSi12, 3.2583 G-AlSi12Cu, - G-AlSi12CuNiMg	≤600 ≤600		<input type="radio"/> <input type="radio"/>
Al cast alloys ≤ 10 % Si	3.5200 MgMn2, 3.5812.05 G-MgAl8Zn1, 3.5612.05 G-MgAl6Zn1	≤400		<input type="radio"/>
≤ 24 % Si	2.0070 SE-Cu, 2.1020 CuSn6, 2.1096 G-CuSn5ZnPb 2.0380 CuZn39Pb2, 2.0401 CuZn39Pb3, 2.0410 CuZn43Pb2 2.0250 CuZn20, 2.0280 CuZn33, 2.0332 CuZn37Pb0.5	≤500 ≤600 ≤600		<input type="radio"/> <input type="radio"/> <input type="radio"/>
Magnesium alloys	2.0070 SE-Cu, 2.1020 CuSn6, 2.1096 G-CuSn5ZnPb 2.0380 CuZn39Pb2, 2.0401 CuZn39Pb3, 2.0410 CuZn43Pb2 2.0250 CuZn20, 2.0280 CuZn33, 2.0332 CuZn37Pb0.5	≤500 ≤600 ≤600		<input type="radio"/> <input type="radio"/> <input type="radio"/>
Copper, low-alloyed	2.1090 CuSn7ZnPb, 2.1170 CuPb5Sn5, 2.1176 CuPb10Sn 2.0790 CuNi18Zn19Pb	≤600 ≤850		<input type="radio"/> <input checked="" type="radio"/>
Brass, short-chipping	2.0916 CuAl5, 2.0960 CuAl9Mn, 2.1050 CuSn10 2.0980 CuAl11Ni, 2.1247 CuBe2	≤850 ≤1000		<input type="radio"/> <input checked="" type="radio"/>
long-chipping	2.0916 CuAl5, 2.0960 CuAl9Mn, 2.1050 CuSn10 2.0980 CuAl11Ni, 2.1247 CuBe2	≤850 ≤1000		<input type="radio"/> <input checked="" type="radio"/>
Bronze, short-chipping	2.0916 CuAl5, 2.0960 CuAl9Mn, 2.1050 CuSn10 2.0980 CuAl11Ni, 2.1247 CuBe2	≤850 ≤1000		<input type="radio"/> <input checked="" type="radio"/>
Bronze, long-chipping	2.0916 CuAl5, 2.0960 CuAl9Mn, 2.1050 CuSn10 2.0980 CuAl11Ni, 2.1247 CuBe2	≤850 ≤1000		<input type="radio"/> <input checked="" type="radio"/>
Duroplastics	Epoxidharz, Resopal, Pertinax, Moltopren	≤150		<input type="radio"/>
Thermoplastics	Plexiglas, Hostalen, Novodur, Makralon	≤100		<input type="radio"/>
New cast materials CGI	EN-GJV250 (GGV25), EN-GJV350 (GGV35) EN-GJV400 (GGV40), EN-GJV500 (GGV50), SiMo 6	≤220 HB ≤300 HB		<input type="radio"/> <input type="radio"/>
New cast materials ADI	EN-GJS-800-8 (ADI800), EN-GJS-1000-5 (ADI1000) EN-GJS-1200-2 (ADI1200), EN-GJS-1400-1 (ADI1400)	≤1000 ≤1400		<input type="radio"/> <input type="radio"/>
Kevlar	Kevlar	≤1000		<input type="radio"/>
Glass, carbon conc. plastics	GFK/CFK	≤1000		<input type="radio"/>

bright

a AlTiN nano

88400/88401		88402/88403		88350		88350		88352		88353		88354		88355	
WN		WN		WN		WN		~ 8050		~ 8050		~ 8051		~ 8051	
Solid carbide				Solid carbide				Solid carbide							
a		a		○		○		○		○		○		○	
TR 300 HP S		TR 300 HP D		B		B		A		B		A		B	
axial		axial													




V _c m/min	Feed column no.		V _c m/min	Feed column no.		V _c m/min	Feed column no.			
120-250	75-76	75-76	18	72	72	18	72	72	72	72
120-250	75-76	75-76	16	72	72	16	72	72	72	72
120-250	75-76	75-76	18	72	72	18	72	72	72	72
120-250	75-76	75-76	16	72	72	16	72	72	72	72
120-250	75-76	75-76	18	71	71	18	71	71	71	71
120-250	75-76	75-76	16	72	72	16	72	72	72	72
120-250	75-76	75-76	14	71	71	14	71	71	71	71
120-250	75-76	75-76	14	71	71	14	71	71	71	71
120-250	75-76	75-76	12	71	71	12	71	71	71	71
120-250	75-76	75-76	18	71	71	18	71	71	71	71
120-250	75-76	75-76	14	71	71	14	71	71	71	71
120-250	75-76	75-76	12	71	71	12	71	71	71	71
120-250	75-76	75-76	10	71	71	10	71	71	71	71
120-250	75-76	75-76	10	71	71	10	71	71	71	71
60-120	75-76	75-76	10	71	71	10	71	71	71	71
30-60	73-74	73-74								
60-120	74-75	74-75	8	71	71	8	71	71	71	71
40-80	74-75	74-75	6	71	71	6	71	71	71	71
60-120	74-75	74-75	6	71	71	6	71	71	71	71
40-60	73-74	73-74	6	71	71					
30-60	73-74	73-74								
40-60	74-75	74-75	6	71	71	6	71	71	71	71
60-140	75-76	75-76	20	71	71	20	71	71	71	71
60-140	75-76	75-76	18	71	71	18	71	71	71	71
120-250	74-75	74-75	20	71	71	20	71	71	71	71
60-120	74-75	74-75	18	71	71	18	71	71	71	71
30-50	74-75	74-75								
40-60	74	74	10	71	71	10	71	71	71	71
40-60	74	74	10	71	71	10	71	71	71	71
			30	73	73	30	73	73	73	73
			30	73	73	30	73	73	73	73
			40	72	72	40	72	72	72	72
			30	72	72	30	72	72	72	72
80-160	75-76	75-76	25	72	72	25	72	72	72	72
			25	72	72	25	72	72	72	72
100-250	75-76	75-76	35	72	72	35	72	72	72	72
			30	72	72	30	72	72	72	72
100-250	75-76	75-76	35	72	72	35	72	72	72	72
100-250	75-76	75-76	30	72	72	30	72	72	72	72
			30	72	72	30	72	72	72	72
			25	72	72	25	72	72	72	72
80-200	75-76	75-76	20	73	73	20	73	73	73	73
80-200	75-76	75-76	20	73	73	20	73	73	73	73
			16	71	71	16	71	71	71	71
80	75-76	75-76	16	71	71	16	71	71	71	71
			12	71	71					
80	75-76	75-76	12	71	71					
80	71	71								
80	71	71								

Application recommendation for HSS-E reamers


Tools with bold feed column no. are preferred choice.

For blind holes with close diameter tolerances choose straight-fluted reamers.

Order no. 
Standard/DIN
Tool material
Surface finish
Form

Counter-sink Ø mm	Feed column no.						
	71	72	73	74	75	76	77
	f (mm/U)						
< 4.00	0.080	0.100	0.125	0.300	0.500	0.800	1.000
4.00	0.100	0.125	0.160	0.300	0.500	1.000	1.200
5.00	0.100	0.125	0.160	0.400	0.600	1.000	1.400
6.30	0.125	0.160	0.200	0.400	0.700	1.200	1.600
8.00	0.160	0.200	0.250	0.600	1.000	1.800	2.400
10.00	0.200	0.250	0.315	0.600	1.200	1.800	2.400
12.50	0.200	0.250	0.315	0.800	1.200	2.000	2.500
16.00	0.250	0.315	0.400	0.800	1.400	2.200	2.600
20.00	0.315	0.400	0.500	0.800	1.400	2.200	2.600
25.00	0.400	0.500	0.630	1.000	1.600	2.500	3.000
31.50	0.400	0.500	0.630	1.000	2.000	3.000	3.600
40.00	0.500	0.630	0.800	1.200	2.000	3.000	3.600
50.00	0.630	0.800	1.000	1.400	2.200	3.200	3.600
> 50.00	0.800	1.000	1.250	1.600	2.200	3.200	3.600

- Coolant:
- Air
 - Neat Oil
 - ⊙ Soluble oil

Cutting direction:
 right-hand cutting

Material group	Material examples, new description (old description in brackets) Figures in bold = material no. to DIN EN	Tensile str. MPa (N/mm ²)	Hard- ness	Coolant
Common structural steels	1.0035 S185(St33), 1.0486 P275N(StE285), 1.0345 P235GH(H1), 1.0425 P265GH(H2) 1.0050 E295 (St50-2), 1.0070 E360 (St70-2), 1.8937 P500NH (WStE500)	≤500 ≤1000		○
Free-cutting steels	1.0718 11SMnPb30 (9SMnPb28), 1.0736 11SMn37 (9SMn36) 1.0727 46S20 (45S20), 1.0728 (60S20), 1.0757 46SPb20 (45SPb20)	≤850 ≤1000		○
Unalloyed heat-treatable steels	1.0402 C22, 1.1178 C30E (Ck30) 1.0503 C45, 1.1191 C45E (Ck45) 1.0601 C60, 1.1221 C60E (Ck60)	≤700 ≤850 ≤1000		○
Alloyed heat-treatable steels	1.5131 50MnSi4, 1.7003 38Cr2, 1.7030 28Cr4 1.5710 36NiCr6, 1.7035 41Cr4, 1.7225 42CrMo4	≤1000 ≤1400		○
Unalloyed case hard. steels	1.0301 (C10), 1.1121 C10E (Ck10)	≤850		○
Alloyed case hardened steels	1.7276 10CrMo11, 1.5125 11MnSi6 1.5752 15NiCr13, 1.7131 16MnCr5, 1.7264 20CrMo5	≤1000 ≤1400		●
Nitriding steels	1.8504 34CrAl6 1.8519 31CrMoV9, 1.8550 34CrAlNi7	≤1000 ≤1400		○
Tool steels	1.1750 C75W, 1.2067 102Cr6, 1.2307 29CrMoV9 1.2080 X210Cr12, 1.2083 X42Cr13, 1.2419 105WCr6, 1.2767 X45NiCrMo4	≤850 ≤1400		○
High speed steels	1.3243 S 6-5-2-5, 1.3343 S 6-5-2, 1.3344 S 6-5-3	≤1400		○
Spring steels	1.5026 55Si7, 1.7176 55Cr3, 1.8159 51CrV4 (51CrV4)		≤350 HB	●
Stainless steels, sulphured	1.4005 X12CrS13, 1.4104 X14CrMoS17, 1.4105 X6CrMoS17, 1.4305 X8CrNiS18-9	≤900		●
austenitic	1.4301 X5CrNi18-10 (V2A), 1.4541 X6CrNiTi18-10, 1.4571 X6CrNiMoTi 17-12-2 (V4A)	≤1100		●
martensitic	1.4057 X20CrNi172 (X17CrNi16-2), 1.4122 X39CrMo17-1, 1.4521 X2CrMoTi18-2	≤1500		●
Hardened steels	-		≤48 HRC ≤63 HRC	●
Special alloys	Nimonic, Inconel, Monel, Hastelloy	≤2000		●
Cast iron	0.6010 EN-GJL-100 (GG10), 0.6020 EN-GJL-200 (GG20) 0.6025 EN-GJL-250 (GG25), 0.6035 EN-GJL-350 (GG35)	≤240 HB ≤350 HB		○
Spheroidal graphite iron and malleable cast iron	0.7050 EN-GJS-500-7 (GGG50), 0.8035 EN-GJMW-350-4 (GTW35) 0.7070 EN-GJS-700-2 (GGG70), 0.8170 EN-GJMB-700-2 (GTS70)	≤240 HB ≤350 HB		○
Chilled cast iron	-		≤350 HB	○
Ti and Ti-alloys	3.7024 Ti99.5, 3.7114 TiAl5Sn2.5, 3.7124 TiCu2 3.7154 TiAl6Zr5, 3.7165 TiAl6V4, 3.7184 TiAl4Mo4Sn2.5, - TiAl8Mo1V1	≤850 ≤1400		○
Aluminium and Al-alloys	3.0255 Al99.5, 3.2315 AlMgSi1, 3.3515 AlMg1 3.0615 AlMgSiPb, 3.1325 AlCuMg1, 3.3245 AlMg3Si, 3.4365 AlZnMgCu1.5	≤400 ≤650		○
Al wrought alloys	3.2131 G-AlSi5Cu1, 3.2153 G-AlSi7Cu3, 3.2573 G-AlSi9 3.2581 G-AlSi12, 3.2583 G-AlSi12Cu, - G-AlSi12CuNiMg	≤600 ≤600		○
Al cast alloys ≤ 10 % Si	3.5200 MgMn2, 3.5812.05 G-MgAl8Zn1, 3.5612.05 G-MgAl6Zn1	≤400		○
≤ 24 % Si	2.0070 SE-Cu, 2.1020 CuSn6, 2.1096 G-CuSn5ZnPb	≤500		○
Magnesium alloys	2.0380 CuZn39Pb2, 2.0401 CuZn39Pb3, 2.0410 CuZn43Pb2 2.0250 CuZn20, 2.0280 CuZn33, 2.0332 CuZn37Pb0.5	≤600 ≤600		○
Copper, low-alloyed	2.1090 CuSn7ZnPb, 2.1170 CuPb5Sn5, 2.1176 CuPb10Sn 2.0790 CuNi18Zn19Pb	≤600 ≤850		○
Brass, short-chipping	2.0916 CuAl5, 2.0960 CuAl9Mn, 2.1050 CuSn10 2.0980 CuAl11Ni, 2.1247 CuBe2	≤850 ≤1000		○
long-chipping	Epoxidharz, Resopal, Pertinax, Moltopren Plexiglas, Hostalen, Novodur, Makralon	≤150 ≤100		○
Bronze, short-chipping	EN-GJV250 (GGV25), EN-GJV350 (GGV35) EN-GJV400 (GGV40), EN-GJV500 (GGV50), SiMo 6	≤220 HB ≤300 HB		○
Bronze, long-chipping	EN-GJS-800-8 (ADI800), EN-GJS-1000-5 (ADI1000) EN-GJS-1200-2 (ADI1200), EN-GJS-1400-1 (ADI1400)	≤1000 ≤1400		○
Duroplastics	Kevlar	≤1000		○
Thermoplastics	GFK/CFK	≤1000		○
New cast materials CGI				○
New cast materials ADI				○
Kevlar				○
Glass, carbon conc. plastics				○

○ bright

 AITiN nano

88300	88301
201-2	212-3
HSS-E	
B	B

88302	88304	88305	88306	88307	88308
212	212	212-2	212-2	208	208
HSS-E					
A	B	A	B	A	B

88311
212
HSS-E
B

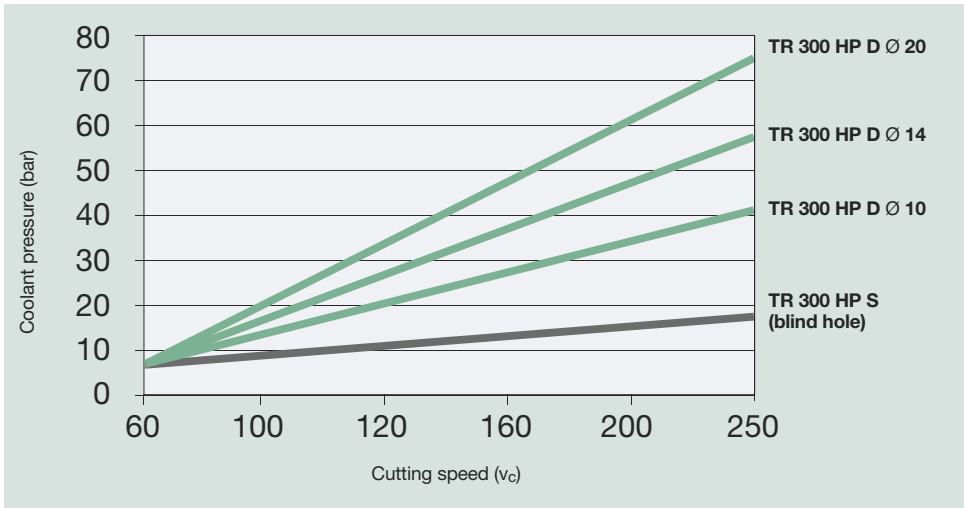


V _c m/min	Feed column no.		V _c m/min	Feed column no.						V _c m/min	Feed col. no.
16	72	72	16	72	72	72	72	72	72	16	72
12	72	72	12	72	72	72	72	72	72	12	72
12	72	72	12	72	72	72	72	72	72	12	72
10	71	71	10	71	71	71	71	71	71	10	71
14	72	72	14	72	72	72	72	72	72	14	72
12	71	71	12	71	71	71	71	71	71	12	71
10	71	71	10	71	71	71	71	71	71	10	71
10	71	71	10	71	71	71	71	71	71	10	71
8	71	71	8	71	71	71	71	71	71	8	71
8	71	71	8	71	71	71	71	71	71	8	71
16	72	72	16	72	72	72	72	72	72	16	72
10	71	71	10	71	71	71	71	71	71	10	71
8	71	71	8	71	71	71	71	71	71	8	71
10	71	71	10	71	71	71	71	71	71	10	71
8	71	71	8	71	71	71	71	71	71	8	71
14	72	72	14	72	72	72	72	72	72	14	72
10	71	71	10	71	71	71	71	71	71	10	71
10	71	71	10	71	71	71	71	71	71	10	71
6	72	72	6	72	72	72	72	72	72	6	72
6	72	72	6	72	72	72	72	72	72	6	72
4	72	72	4	72	72	72	72	72	72	4	72
4	71	71	4	71	71	71	71	71	71	4	71
14	71	71	14	71	71	71	71	71	71	14	71
12	71	71	12	71	71	71	71	71	71	12	71
12	71	71	12	71	71	71	71	71	71	12	71
10	71	71	10	71	71	71	71	71	71	10	71
6	71	71	6	71	71	71	71	71	71	6	71
4	71	71	4	71	71	71	71	71	71	4	71
18	73	73	18	73	73	73	73	73	73	18	73
18	73	73	18	73	73	73	73	73	73	18	73
20	72	72	20	72	72	72	72	72	72	20	72
18	72	72	18	72	72	72	72	72	72	18	72
20	72	72	20	72	72	72	72	72	72	20	72
18	72	72	18	72	72	72	72	72	72	18	72
18	72	72	18	72	72	72	72	72	72	18	72
16	72	72	16	72	72	72	72	72	72	16	72
20	72	72	20	72	72	72	72	72	72	20	72
18	72	72	18	72	72	72	72	72	72	18	72
18	72	72	18	72	72	72	72	72	72	18	72
14	72	72	14	72	72	72	72	72	72	14	72
12	73	73	12	73	73	73	73	73	73	12	73
14	73	73	14	73	73	73	73	73	73	14	73
8	71	71	8	71	71	71	71	71	71	8	71
8	71	71	8	71	71	71	71	71	71	8	71



Recommendations for the application of high-performance reamers TR 300 HP

Coolant pressure



Coolant pressure - cutting speed
valid for standard dimensions.
Preconditions: sufficient capacity of coolant pump



Troubleshooting

Adapted cutting speed, an appropriate feed rate and good cooling and lubricating agents should always be a top priority for reaming operations. A further point to be considered is that the reamer always follows the direction of the pre-drilled hole. An exception is the machine bottoming reamer or a very small reamer. Consequently reamers do not correct alignment errors of predrilled holes. Errors between the spindle axis and the axis of a pre-drilled hole can be adjusted with the aid of floating holders. The following fault finding chart will be found useful in tracing the cause of some common reaming problems.

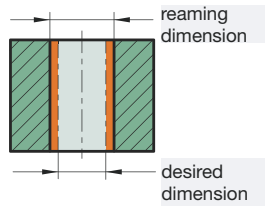
Wording:

Desired dim. Required finish dimension of bore hole, defined as max./min. dimension of tolerance zone

Reaming dim. the finish dimension reached in fact

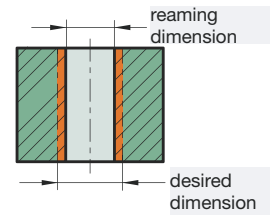
„Bore hole“ The reached bore hole after reaming

1 Holes too large



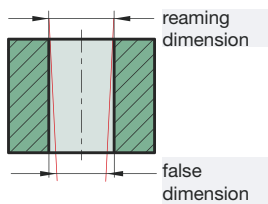
- Tool diameter too large
- Cutting speed too high
- Concentricity error of machine spindle
- Bevel lead of tool too short/uneven
- Cutting edge build up due to wrong cutting speeds or poor lubrication
- Lubricating agent unsuitable, holes too large due to lubrication

2 Holes too small



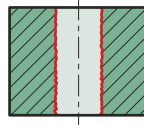
- Reamer blunt. Does not cut, scrapes
- Cutting speed too low
- Component is thin-walled, springs back
- Insufficient stock removal allowance, tool seizes in hole
- Hole is not round due to distortion

3 Conical hole malformation



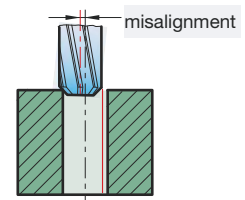
- Tool knocks in spindle
- Bevel lead incorrect
- Axis shifting between tool and predrilled hole. Application of floating holders
- Pre-machining inaccurate

4 Unsatisfactory surface finish



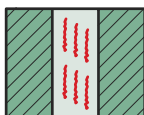
- Cutting speed too low
- No/insufficient lubrication. Cutting edge build-up.
- Tool damaged, i. e. broken cutting edge
- Material has a tendency to cause build up on cutting edges.
- Concentricity bevel lead incorrect

5 Misalignment of hole



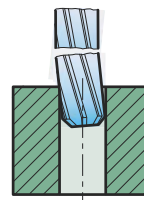
- Pre-drilled hole misaligned
- Concentricity bevel lead incorrect
- Apply floating holder if necessary
- If necessary pilot drill to correct predrilled position

6 Hole has chatter marks



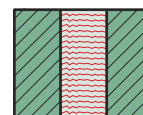
- Feed too low
- Cutting edge build-up
- Grease content in coolant too low
- Circular lands too small
- Stock removal allowance insufficient
- Tool incorrectly clamped in tool holder
- Machine spindle not concentric

7 Reamer seizes and breaks



- Position to pilot hole incorrect
- Back taper incorrect
- Circular lands too wide
- Pre-drilled hole is too small
- Bevel lead blunt/ground unevenly
- Feed rate too high
- Chip congestion – increase feed rate to produce shorter chips

8 Feed scoring marks in hole



- Cutting speed too low
- Worn cutting edges
- Crumbling on cutting edges
- Build up on cutting edges
- Position to pilot hole incorrect
- Insufficient lubrication

The most common tolerance zones in μm

Nominal diameter in mm		A		B				C			
over	to	9	11	8	9	10	11	8	9	10	11
0	3	+295	+330	+154	+165	+180	+200	+74	+85	+100	+120
		+270	+270	+140	+140	+140	+140	+60	+60	+60	+60
3	6	+300	+345	+158	+170	+188	+215	+88	+100	+118	+145
		+270	+270	+140	+140	+140	+140	+70	+70	+70	+70
6	10	+316	+370	+172	+186	+208	+240	+102	+116	+138	+170
		+280	+280	+150	+150	+150	+150	+80	+80	+80	+80
10	18	+333	+400	+177	+193	+220	+260	+122	+138	+165	+205
		+290	+290	+150	+150	+150	+150	+95	+95	+95	+95
18	30	+352	+430	+193	+212	+244	+290	+143	+162	+194	+240
		+300	+300	+160	+160	+160	+160	+110	+110	+110	+110
30	40	+372	+470	+209	+232	+270	+330	+159	+182	+220	+280
		+310	+310	+170	+170	+170	+170	+120	+120	+120	+120
40	50	+382	+480	+219	+242	+280	+340	+169	+192	+230	+290
		+320	+320	+180	+180	+180	+180	+130	+130	+130	+130
50	65	+414	+530	+236	+264	+310	+380	+186	+214	+260	+330
		+340	+340	+190	+190	+190	+190	+140	+140	+140	+140
65	80	+434	+550	+246	+274	+320	+390	+196	+224	+270	+340
		+360	+360	+200	+200	+200	+200	+150	+150	+150	+150
80	100	+467	+600	+274	+307	+360	+440	+224	+257	+310	+390
		+380	+380	+220	+220	+220	+220	+170	+170	+170	+170
100	120	+497	+630	+294	+327	+380	+460	+234	+267	+320	+400
		+410	+410	+240	+240	+240	+240	+180	+180	+180	+180

Nominal diameter in mm		D					E			F			
over	to	8	9	10	11	12	7	8	9	6	7	8	9
0	3	+34	+45	+60	+80	+120	+24	+28	+39	+12	16	+20	+31
		+20	+20	+20	+20	+20	+14	+14	+14	+6	+6	+6	+6
3	6	+48	+60	+78	+105	+150	+32	+38	+50	+18	+22	+28	+40
		+30	+30	+30	+30	+30	+20	+20	+20	+10	+10	+10	+10
6	10	+62	+76	+98	+130	+190	+40	+47	+61	+22	+28	+35	+49
		+40	+40	+40	+40	+40	+25	+25	+25	+13	+13	+13	+13
10	18	+77	+93	+120	+160	+230	+50	+59	+75	+27	+34	+43	+59
		+50	+50	+50	+50	+50	+32	+32	+32	+16	+16	+16	+16
18	30	+98	+117	+149	+195	+275	+61	+73	+92	+33	+41	+53	+72
		+65	+65	+65	+65	+65	+40	+40	+40	+20	+20	+20	+20
30	50	+119	+142	+180	+240		+75	+89	+112	+41	+50	+64	+87
		+80	+80	+80	+80		+50	+50	+50	+25	+25	+25	+25
50	80	+146	+174	+220	+290		+90	+106	+134	+49	+60	+76	+104
		+100	+100	+100	+100		+60	+60	+60	+30	+30	+30	+30
80	120	+174	+207	+260	+340		+107	+126	+159	+58	+71	+90	+123
		+120	+120	+120	+120		+72	+72	+72	+36	+36	+36	+36
120	180							+148					
								+85					
180	250							+172					
								+100					

The most common tolerance zones in μm

Nominal diameter in mm over to	G		H								J		
	6	7	6	7	8	9	10	11	12	6	7	8	
0 to 3	+8 +2	+12 +2	+6 0	+10 0	+14 0	+25 0	+40 0	+60 0	+100 0	+2 -4	+4 -6	+6 -8	
3 to 6	+12 +4	+16 +4	+8 0	+12 0	+18 0	+30 0	+48 0	+75 0	+120 0	+5 -3	+6 -6	+10 -8	
6 to 10	+14 +5	+20 +5	+9 0	+15 0	+22 0	+36 0	+58 0	+90 0	+150 0	+5 -4	+8 -7	+12 -10	
10 to 18	+17 +6	+24 +6	+11 0	+18 0	+27 0	+43 0	+70 0	+110 0	+180 0	+6 -5	+10 -8	+15 -12	
18 to 30	+20 +7	+28 +7	+13 0	+21 0	+33 0	+52 0	+84 0	+130 0	+210 0	+8 -5	+12 -9	+20 -13	
30 to 50	+25 +9	+34 +9	+16 0	+25 0	+39 0	+62 0	+100 0	+160 0	+250 0	+10 -6	+14 -11	+24 -15	
50 to 80	+29 +10	+40 +10	+19 0	+30 0	+46 0	+74 0	+120 0	+190 0	+300 0	+13 -6	+18 -12	+28 -18	
80 to 120	+34 +12	+47 +12	+22 0	+35 0	+54 0	+87 0	+140 0	+220 0	+350 0	+16 -6	+22 -13	+34 -20	
120 to 180		+54 +14	+25 0	+40 0	+63 0	+100 0	+160 0	+250 0		+18 -7	+26 -14	+41 -22	
180 to 250		+61 +15	+29 0	+46 0	+72 0	+115 0	+185 0	+290 0		+22 -7	+30 -16	+47 -25	

Nominal diameter in mm over to	JS				K			M		
	6	7	8	9	6	7	8	6	7	8
0 to 3	+3 -3	+5 -5	+7 -7	+12,5 -12,5	0 -6	0 -10	0 -14	-2 -8	-2 -12	-4 -18
3 to 6	+4 -4	+6 -6	+9 -9	+15 -15	+2 -6	+3 -9	+5 -13	-1 -9	0 -12	+2 -16
6 to 10	+4,5 -4,5	+7,5 -7,5	+11 -11	+18 -18	+2 -7	+5 -10	+6 -16	-3 -12	0 -215	+1 -21
10 to 18	+5,5 -5,5	+9 -9	+13,5 -13,5	+21,5 -21,5	+2 -9	+6 -12	+8 -19	-4 -15	0 -18	+2 -25
18 to 30	+6,5 -6,5	+10,5 -10,5	+16,5 -16,5	+26 -26	+2 -11	+6 -15	+10 -23	-4 -17	0 -21	+4 -29
30 to 50	+8 -8	+12,5 -12,5	+19,5 -19,5	+31 -31	+3 -13	+7 -18	+12 -27	-4 -20	0 -25	+5 -34
50 to 80	+9,5 -9,5	+15 -15	+23 -23	+37 -37	+4 -15	+9 -21	+14 -32	-5 -24	0 -30	+5 -41
80 to 120	+11 -11	+17,5 -17,5	+27 -27	+43,5 -43,5	+4 -18	+10 -25	+16 -38	-6 -28	0 -35	+6 -48
120 to 180					+4 -21	+12 -28				
180 to 250					+5 -24	+13 -33				



The most common tolerance zones in μm

Nominal diameter in mm		N						P			R	
over	to	6	7	8	9	10	11	6	7	9	6	7
0	3	-4	-4	-4	-4	-4	-4	-6	-6	-6	-10	-10
		-10	-14	-8	-29	-44	-64	-12	-16	-31	-16	-20
3	6	-5	-4	-2	0	0	0	-9	-8	-12	-12	-11
		-13	-16	-20	-30	-48	-75	-17	-20	-42	-20	-23
6	10	-7	-4	-3	0	0	0	-12	-9	-15	-16	-13
		-16	-19	-25	-36	-58	-90	-21	-24	-51	-25	-28
10	18	-9	-5	-3	0	0	0	-15	-11	-18	-20	-16
		-20	-23	-30	-43	-70	-110	-26	-29	-61	-31	-34
18	30	-11	-7	-3	0	0	0	-18	-14	-22	-24	-20
		-24	-28	-36	-52	-84	-130	-31	-35	-74	-37	-41
30	50	-12	-8	-3	0	0	0	-21	-17	-26	-29	-25
		-28	-33	-42	-62	-100	-160	-37	-42	-88	-45	-50
50	65	-14	-9	-4	0	0	0	-26	-21	-32	-35	-30
		-33	-39	-50	-74	-120	-190	-45	-51	-106	-54	-60
65	80	-14	-9	-4	0	0	0	-26	-21	-32	-37	-32
		-33	-39	-50	-74	-120	-190	-45	-51	-106	-56	-62
80	100	-16	-10	-4	0	0	0	-30	-24	-37	-44	-38
		-38	-45	-58	-87	-140	-220	-52	-59	-124	-66	-73
100	120	-16	-10	-4	0	0	0	-30	-24		-47	-41
		-38	-45	-58	-87	-140	-220	-52	-59		-69	-76

Nominal diameter in mm		S		T	U			X		Z	
over	to	6	7	6	6	7	10	10	11	10	11
0	3	-14	-14	-18	-18	-18	-18	-20	-20	-26	-26
		-20	-24	-24	-24	-28	-58	-60	-80	-66	-86
3	6	-16	-15	-20	-20	-19	-23	-28	-28	-35	-35
		-24	-27	-28	-28	-31	-71	-76	-103	-83	-110
6	10	-20	-17	-25	-25	-22	-28	-34	-34	-42	-42
		-29	-32	-34	-34	-37	-86	-92	-124	-100	-132
10	14	-25	-21	-30	-30	-26	-33	-40	-40	-50	-50
		-36	-39	-41	-41	-44	-103	-110	-150	-120	-160
14	18	-25	-21	-30	-30	-26	-33	-45	-45	-60	-60
		-36	-39	-41	-41	-44	-103	-115	-155	-130	-170
18	24	-31	-27	-37	-37	-33	-41	-54	-54	-73	-73
		-44	-48	-50	-50	-54	-125	-138	-184	-157	-203
24	30	-31	-27	-37	-44	-40	-48	-64	-64	-88	-88
		-44	-48	-50	-57	-61	-132	-148	-194	-172	-218
30	40	-38	-34	-43	-55	-51	-60	-80	-80	-112	-112
		-54	-59	-59	-71	-76	-160	-180	-240	-212	-272
40	50	-38	-34	-49	-65	-61	-70	-97	-97	-136	-136
		-54	-59	-65	-81	-86	-170	-197	-257	-236	-296
50	65	-47	-42	-60	-81	-76	-87	-122	-122	-172	-172
		-66	-72	-79	-100	-106	-207	-242	-312	-292	-362
65	80	-53	-48	-69	-96	-91	-102	-146	-146	-210	-210
		-72	-78	-88	-115	-121	-222	-266	-336	-330	-400
80	100	-64	-58	-84	-117	-111	-124	-178	-178	-258	-258
		-86	-93	-106	-139	-146	-264	-318	-398	-398	-478
100	120	-72	-66	-97	-137	-131	-144	-210	-210	-310	-310
		-94	-101	-119	-159	-166	-284	-350	-430	-450	-530

Manufacturing tolerances

(tolerance zones A ... G)

DIN 1420

Nominal diameter in mm		Permissible upper and lower tolerances on nominal reamer diameter d_1 in μm for hole tolerance zone									
		A9	A11	B8	B9	B10	B11	C8	C9	C10	C11
1	3	+ 291	+ 321	+ 151	+ 161	+ 174	+ 191	+ 71	+ 81	+ 94	+ 111
		+ 282	+ 300	+ 146	+ 152	+ 160	+ 170	+ 66	+ 72	+ 80	+ 90
3	6	+ 295	+ 333	+ 155	+ 165	+ 180	+ 203	+ 85	+ 95	+ 110	+ 133
		+ 284	+ 306	+ 148	+ 154	+ 163	+ 176	+ 78	+ 84	+ 93	+ 106
6	10	+ 310	+ 356	+ 168	+ 180	+ 199	+ 226	+ 98	+ 110	+ 129	+ 156
		+ 297	+ 324	+ 160	+ 167	+ 178	+ 194	+ 90	+ 97	+ 108	+ 124
10	18	+ 326	+ 383	+ 172	+ 186	+ 209	+ 243	+ 117	+ 131	+ 154	+ 188
		+ 310	+ 344	+ 162	+ 170	+ 184	+ 204	+ 107	+ 115	+ 129	+ 149
18	30	+ 344	+ 410	+ 188	+ 204	+ 231	+ 270	+ 138	+ 154	+ 181	+ 220
		+ 325	+ 364	+ 176	+ 185	+ 201	+ 224	+ 126	+ 135	+ 151	+ 174
30	40	+ 362	+ 446	+ 203	+ 222	+ 255	+ 306	+ 153	+ 172	+ 205	+ 256
		+ 340	+ 390	+ 189	+ 200	+ 220	+ 250	+ 139	+ 150	+ 170	+ 200
40	50	+ 372	+ 456	+ 213	+ 232	+ 265	+ 316	+ 163	+ 182	+ 215	+ 266
		+ 350	+ 400	+ 199	+ 210	+ 230	+ 260	+ 149	+ 160	+ 180	+ 210
50	65	+ 402	+ 501	+ 229	+ 252	+ 292	+ 351	+ 179	+ 202	+ 242	+ 301
		+ 376	+ 434	+ 212	+ 226	+ 250	+ 284	+ 162	+ 176	+ 200	+ 234
65	80	+ 422	+ 521	+ 239	+ 262	+ 302	+ 361	+ 189	+ 212	+ 252	+ 311
		+ 396	+ 454	+ 222	+ 236	+ 260	+ 294	+ 172	+ 186	+ 210	+ 244
80	100	+ 453	+ 567	+ 265	+ 293	+ 339	+ 407	+ 215	+ 243	+ 289	+ 357
		+ 422	+ 490	+ 246	+ 262	+ 290	+ 330	+ 196	+ 212	+ 240	+ 280
100	120	+ 483	+ 597	+ 285	+ 313	+ 359	+ 427	+ 225	+ 253	+ 299	+ 367
		+ 452	+ 520	+ 266	+ 282	+ 310	+ 350	+ 206	+ 222	+ 250	+ 290
120	140	+ 545	+ 672	+ 313	+ 345	+ 396	+ 472	+ 253	+ 285	+ 336	+ 412
		+ 510	+ 584	+ 290	+ 310	+ 340	+ 384	+ 230	+ 250	+ 280	+ 324
140	160	+ 605	+ 732	+ 333	+ 365	+ 416	+ 492	+ 263	+ 295	+ 346	+ 422
		+ 570	+ 644	+ 310	+ 330	+ 360	+ 404	+ 240	+ 260	+ 290	+ 334
160	180	+ 665	+ 792	+ 363	+ 395	+ 446	+ 522	+ 283	+ 315	+ 366	+ 442
		+ 630	+ 704	+ 340	+ 360	+ 390	+ 434	+ 260	+ 280	+ 310	+ 354

Nominal diameter in mm		Permissible upper and lower tolerances on nominal reamer diameter d_1 in μm for hole tolerance zone												
		D8	D9	D10	D11	E7	E8	E9	F6	F7	F8	F9	G6	G7
1	3	+ 31	+ 41	+ 54	+ 71	+ 22	+ 25	+ 35	+ 11	+ 14	+ 17	+ 27	+ 7	+ 10
		+ 26	+ 32	+ 40	+ 50	+ 18	+ 20	+ 26	+ 8	+ 10	+ 12	+ 18	+ 4	+ 6
3	6	+ 45	+ 55	+ 70	+ 93	+ 30	+ 35	+ 45	+ 16	+ 20	+ 25	+ 35	+ 10	+ 14
		+ 38	+ 44	+ 53	+ 66	+ 25	+ 28	+ 34	+ 13	+ 15	+ 18	+ 24	+ 7	+ 9
6	10	+ 58	+ 70	+ 89	+ 116	+ 37	+ 43	+ 55	+ 20	+ 25	+ 31	+ 43	+ 12	+ 17
		+ 50	+ 57	+ 68	+ 84	+ 31	+ 35	+ 42	+ 16	+ 19	+ 23	+ 30	+ 8	+ 11
10	18	+ 72	+ 86	+ 109	+ 143	+ 47	+ 54	+ 68	+ 25	+ 31	+ 38	+ 52	+ 15	+ 21
		+ 62	+ 70	+ 84	+ 104	+ 40	+ 44	+ 52	+ 21	+ 24	+ 28	+ 36	+ 11	+ 14
18	30	+ 93	+ 109	+ 136	+ 175	+ 57	+ 68	+ 84	+ 31	+ 37	+ 48	+ 64	+ 18	+ 24
		+ 81	+ 90	+ 106	+ 129	+ 49	+ 56	+ 65	+ 26	+ 29	+ 36	+ 45	+ 13	+ 16
30	50	+ 113	+ 132	+ 165	+ 216	+ 71	+ 83	+ 102	+ 38	+ 46	+ 58	+ 77	+ 22	+ 30
		+ 99	+ 110	+ 130	+ 160	+ 62	+ 69	+ 80	+ 32	+ 37	+ 44	+ 55	+ 16	+ 21
50	80	+ 139	+ 162	+ 202	+ 261	+ 85	+ 99	+ 122	+ 46	+ 55	+ 69	+ 92	+ 26	+ 35
		+ 122	+ 136	+ 160	+ 194	+ 74	+ 82	+ 96	+ 39	+ 44	+ 52	+ 66	+ 19	+ 24
80	120	+ 165	+ 193	+ 239	+ 307	+ 101	+ 117	+ 145	+ 54	+ 65	+ 81	+ 109	+ 30	+ 41
		+ 146	+ 162	+ 190	+ 230	+ 88	+ 98	+ 114	+ 46	+ 52	+ 62	+ 78	+ 22	+ 28
120	180	+ 198	+ 230	+ 281	+ 357	+ 119	+ 138	+ 170	+ 64	+ 77	+ 96	+ 128	+ 35	+ 48
		+ 175	+ 195	+ 225	+ 269	+ 105	+ 115	+ 135	+ 55	+ 63	+ 73	+ 93	+ 26	+ 34

Manufacturing tolerances

(tolerance zones H ... P)
DIN 1420

Nominal diameter in mm		Permissible upper and lower tolerances on nominal reamer diameter d_1 in μm for hole tolerance zone													
over	to	H6	H7	H8	H9	H10	H11	H12	J6	J7	J8	JS6	JS7	JS8	JS9
>1.....3		+5	+8	+11	+21	+34	+51	+85	+1	+2	+3	+2	+3	+4	+8
		+2	+4	+6	+12	+20	+30	+50	-2	-2	-2	-1	-1	-1	-1
>3.....6		+6	+10	+15	+25	+40	+63	+102	+3	+4	+7	+2	+4	+6	+10
		+3	+5	+8	+14	+23	+36	+60	0	-1	0	-1	-1	-1	-1
>6.....10		+7	+12	+18	+30	+49	+76	+127	+3	+5	+8	+3	+5	+7	+12
		+3	+6	+10	+17	+28	+44	+74	-1	-1	0	-1	-1	-1	-1
>10.....18		+9	+15	+22	+36	+59	+93	+153	+4	+7	+10	+3	+6	+8	+15
		+5	+8	+12	+20	+34	+54	+90	0	0	0	-1	-1	-1	-1
>18.....30		+11	+17	+28	+44	+71	+110	+178	+6	+8	+15	+4	+7	+11	+18
		+6	+9	+16	+25	+41	+64	+104	+1	0	+3	-1	-1	-1	-1
>30.....50		+13	+21	+33	+52	+85	+136	+212	+7	+10	+18	+5	+8	+13	+21
		+7	+12	+19	+30	+50	+80	+124	+1	+1	+4	-1	-1	-1	-1
>50.....80		+16	+25	+39	+62	+102	+161	+255	+10	+13	+21	+6	+10	+16	+25
		+9	+14	+22	+36	+60	+94	+150	+3	+2	+4	-1	-1	-1	-1
>80...120		+18	+29	+45	+73	+119	+187	+297	+12	+16	+25	+7	+12	+18	+30
		+10	+16	+26	+42	+70	+110	+174	+4	+3	+6	-1	-1	-1	-1
>120...180		+21	+34	+53	+85	+136	+212	+340	+14	+20	+31	+8	+14	+22	+35
		+12	+20	+30	+50	+80	+124	+200	+5	+6	+8	-1	0	-1	0

↑
Our
standard
manufacturing accuracy

Nominal diameter in mm		Permissible upper and lower tolerances on nominal reamer diameter d_1 in μm for hole tolerance zone													
over	to	K6	K7	K8	M6	M7	M8	N6	N7	N8	N9	N10	N11	P6	P7
1	3	-1	-2	-3	-3	-4		-5	-6	-7	-8	-10	-13	-7	-8
		-4	-6	-8	-6	-8		-8	-10	-12	-17	-24	-34	-10	-12
3	6	0	+1	+2	-3	-2	-1	-7	-6	-5	-5	-8	-12	-11	-10
		-3	-4	-5	-6	-7	-8	-10	-11	-12	-16	-25	-39	-14	-15
6	10	0	+2	+2	-5	-3	-3	-9	-7	-7	-6	-9	-14	-14	-12
		-4	-4	-6	-9	-9	-11	-13	-13	-15	-19	-30	-46	-18	-18
10	18	0	+3	+3	-6	-3	-3	-11	-8	-8	-7	-11	-17	-17	-14
		-4	-4	-7	-10	-10	-13	-15	-15	-18	-23	-36	-56	-21	-21
18	30	0	+2	+5	-6	-4	-1	-13	-11	-8	-8	-13	-20	-20	-1
		-5	-6	-7	-11	-12	-13	-18	-19	-20	-27	-43	-66	-25	-26
30	50	0	+3	+6	-7	-4	-1	-15	-12	-9	-10	-15	-24	-24	-21
		-6	-6	-8	-13	-13	-15	-21	-21	-23	-32	-50	-80	-30	-30
50	80	+1	+4	+7	-8	-5	-2	-17	-14	-11	-12	-18	-29	-29	-26
		-6	-7	-10	-15	-16	-19	-24	-25	-28	-38	-60	-96	-36	-37
80	120	0	+4	+7	-10	-6	-3	-20	-16	-13	-14	-21	-33	-34	-30
		-8	-9	-12	-18	-19	-22	-28	-29	-32	-45	-70	-110	-42	-43
120	180	0	+6	+10	-12	-6	-2	-24	-18	-14	-15	-24	-38	-40	-43
		-9	-8	-13	-21	-20	-25	-33	-32	-37	-50	-80	-126	-49	-48

Manufacturing tolerances

(tolerance zones R ... Z)
DIN 1420

Nominal diameter in mm		Permissible upper and lower tolerances on nominal reamer diameter d_1 in μm for hole tolerance zone											
over	to	R6	R7	S6	S7	T6	U6	U7	U10	X10	X11	Z10	Z11
1	3	- 11	- 12	- 15	- 16		- 19	- 20				- 32	
		- 14	- 16	- 18	- 20		- 22	- 24				- 46	
3	6	- 14	- 13	- 18	- 17		- 22	- 21	- 31			- 43	
		- 17	- 18	- 21	- 22		- 25	- 26	- 48			- 60	
6	10	- 18	- 16	- 22	- 20		- 27	- 25	- 37			- 51	
		- 22	- 22	- 26	- 26		- 31	- 31	- 58			- 72	
10	14	- 22	- 19	- 27	- 24		- 32	- 29	- 44			- 61	
		- 26	- 26	- 31	- 31		- 36	- 36	- 69			- 86	
14	18	- 22	- 19	- 27	- 24		- 32	- 29	- 44	- 56		- 71	
		- 26	- 26	- 31	- 31		- 36	- 36	- 69	- 81		- 96	
18	24	- 26	- 24	- 33	- 31		- 39	- 37		- 67		- 86	
		- 31	- 32	- 38	- 39		- 44	- 45		- 97		-116	
24	30	- 26	- 24	- 33	- 31	- 39	- 46	- 44		- 77		-101	-108
		- 31	- 32	- 38	- 39	- 44	- 51	- 52		-107		-131	-154
30	40	- 32	- 29	- 41	- 38	- 46	- 58	- 55		- 95		-127	-136
		- 38	- 38	- 47	- 47	- 52	- 64	- 64		-130		-162	-192
40	50	- 32	- 29	- 41	- 38	- 52	- 68	- 65	- 85	-112		-151	-160
		- 38	- 38	- 47	- 47	- 58	- 74	- 74	-120	-147		-186	-216
50	65	- 38	- 35	- 50	- 47	- 63	- 84	- 81	-105	-140	-151	-190	-201
		- 45	- 46	- 57	- 58	- 70	- 91	- 92	-147	-182	-218	-232	-268
65	80	- 40	- 37	- 56	- 53	- 72	- 99	- 96	-120	-164	-175	-228	-239
		- 47	- 48	- 63	- 64	- 79	-106	-107	-162	-206	-242	-270	-306
80	100	- 48	- 44	- 68	- 64	- 88	-121	-117	-145	-199	-211	-279	-291
		- 56	- 57	- 76	- 77	- 96	-129	-130	-194	-248	-288	-328	-368
100	120	- 51	- 47	- 76	- 72	-101	-141	-137	-165	-231	-243	-331	-343
		- 59	- 60	- 84	- 85	-109	-149	-150	-214	-280	-320	-380	-420
120	140	- 60	- 54	- 89	- 83	-119	-167	-161	-194	-272	-286	-389	-403
		- 69	- 68	- 98	- 97	-128	-176	-175	-250	-328	-374	-445	-491
140	160	- 62	- 56	- 97	- 91	-131	-187	-181	-214	-304	-318	-439	-453
		- 71	- 70	-106	-105	-140	-196	-195	-270	-360	-406	-495	-541
160	180	- 65	- 59	-105	- 99	-143	-207	-201	-234	-334	-348	-489	-503
		- 74	- 73	-114	-113	-152	-216	-215	-290	-390	-436	-545	-591

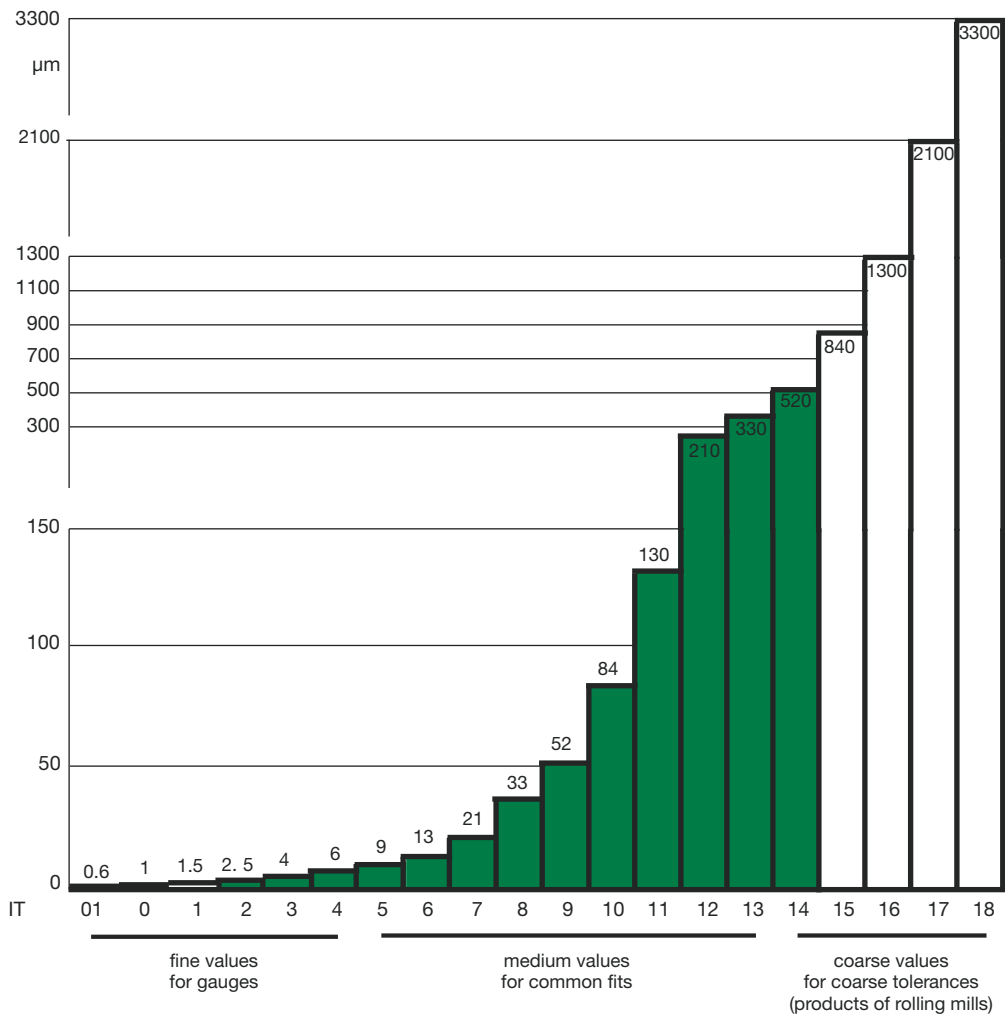


Basic ISO tolerances

DIN ISO 286-1

Range of nominal size mm		IT in μm											
		3	4	5	6	7	8	9	10	11	12	13	14
from	1	2	3	4	6	10	14	25	40	60	100	140	250
to	3												
over	3	2.5	4	5	8	12	18	30	48	75	120	180	300
to	6												
over	6	2.5	4	6	9	15	22	36	58	90	150	220	360
to	10												
over	10	3	5	8	11	18	27	43	70	110	180	270	430
to	18												
over	18	4	6	9	13	21	33	52	84	130	210	330	520
to	30												
over	30	4	7	11	16	25	39	62	100	160	250	390	620
to	50												
over	50	5	8	13	19	30	46	74	120	190	300	460	740
to	80												
over	80	6	10	15	22	35	54	87	140	220	350	540	870
to	120												

Example: Basic ISO tolerances for a range of nominal sizes over 18 to 30 mm



Manufacturing tolerances to DIN 1420

General remarks for the determination of manufacturing tolerances for reamers

The manufacturing tolerances to DIN 1420 are allocated to certain tolerance zones of the holes to be reamed. Generally they ensure the positioning of reamed holes within the relevant tolerance zone as well as the most economical use of the reamer.

It must, however, be taken into account that the size of the reamed hole depends, in addition to the manufacturing tolerance of the reamer, on various other factors, such as angles of cutting edges; bevel lead of reamer; clamping of the workpiece; the tool holder; condition of the machine; the coolant and on the material of the workpiece. Therefore, from time to time other manufacturing tolerances than IT7 (H7) might prove more advantageous.

However, in the interest of economic production and storage, it is recommended that non-standard manufacturing tolerances are used only in exceptional cases.

For determining the manufacturing tolerances the following well-proven basic rules were stipulated:

Determination of perm. max. and min. sizes of reamers

The largest permitted reamer diameter ranges at about 15% of the approximate hole tolerance (0.15 IT) below the permissible maximum diameter of the hole (see fig.), whereby the value 0.15 IT will be rounded of to the next higher integer or half μm -value, so that even μm values are derived for $d_{1\text{max}}$. The permissible smallest reamer diameter $d_{1\text{min}}$ ranges at about 35% of the approximate hole tolerance (0.35 IT) below the permissible maximum diameter $d_{1\text{max}}$ (ex. 1).

Simplified determination of permissible max. and min. reamer dimensions

In order to facilitate calculations, the table on page 47 indicates the upper and lower tolerance limits on the nominal diameter d_1 for the most common "H" tolerance zones. With the aid of these tolerance limits the permissible maximum and minimum reamer dimensions can be calculated.

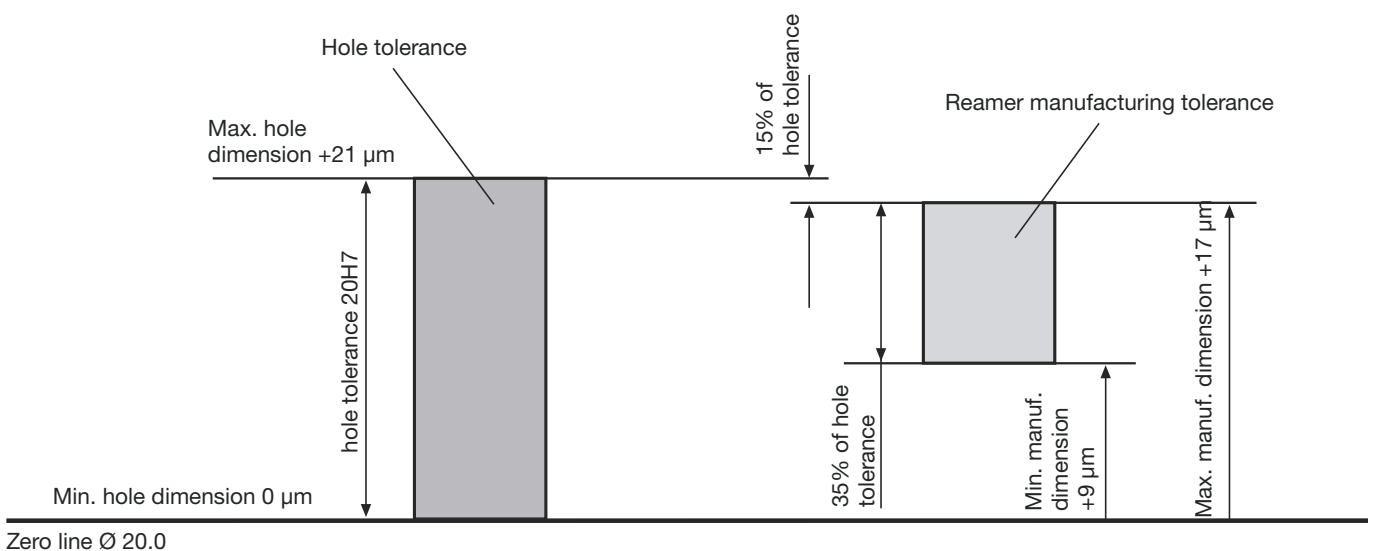
Example 1

nominal diameter d_1	$\approx 20.000 \text{ mm}$
maximum diameter of the hole	$\approx 20.021 \text{ mm}$
hole tolerance (IT 7)	$\approx 0.021 \text{ mm}$
15% of the hole tolerance (0.15 IT 7)	$\approx 0.0031 \text{ mm}$
maximum reamer diameter:	$\approx 0.004 \text{ mm}$
$d_{1\text{max}} = 20.021 - 0.004$	$= \underline{20.017 \text{ mm}}$
manufacturing tolerance of reamer:	
35% of the hole tolerance (0.35 IT 7)	$\approx 0.0073 \text{ mm}$
	$\approx 0.008 \text{ mm}$

minimum reamer diameter:
 $d_{1\text{min}} = d_{1\text{max}} - 0.35 \text{ IT } 7$
 $= 20.017 - 0.008$
 $= \underline{20.009 \text{ mm}}$

Simplified calculation of the permissible maximum and minimum dimensions for reamers

Example: Hole tolerance zone $\text{Ø } 20 \text{ H7/nom.}$ dimension d_1 of reamer 20 mm





Designation to DIN 1420

Designation

For the designation of reamers the ISO abbreviation for the tolerance zone of the hole is indicated after the nominal diameter. Designation of a reamer with nominal diameter $d_1 = 20$ mm, for hole tolerance H 7:

reamer 20 H 7 DIN ...
 (" ... ": for DIN no. indication
 of appropriate reamer)

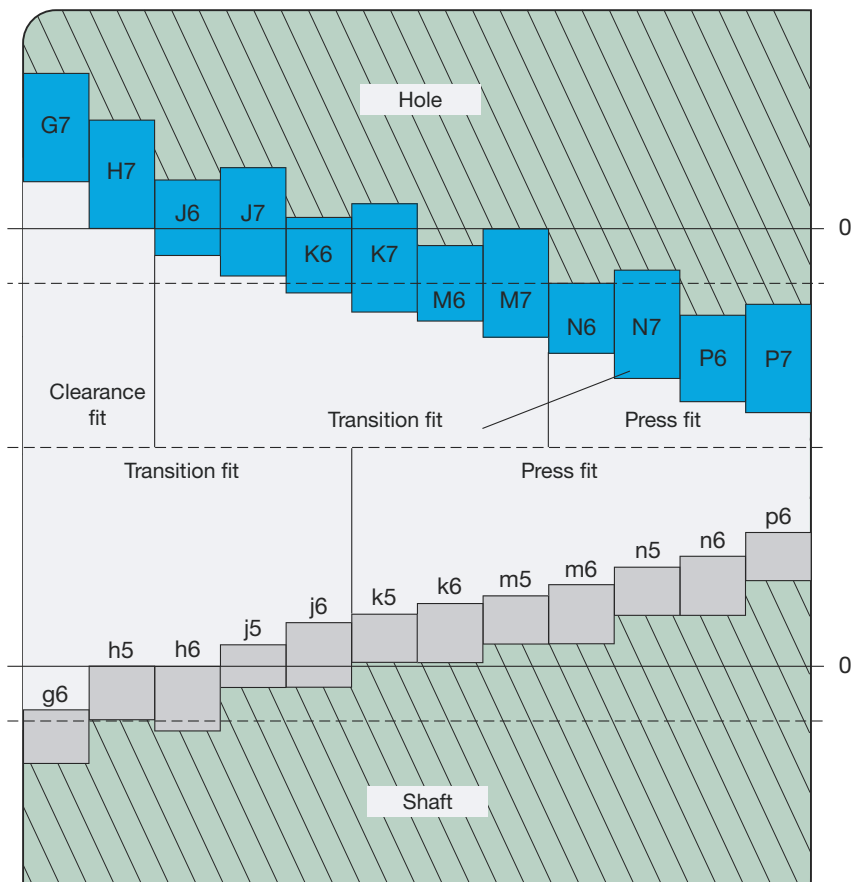
In special cases, reamers are ordered with maximum and minimum dimensions deviating from this standard, the ISO abbreviation for the hole tolerance zone must be replaced

by the upper and lower tolerance limit of the reamer in μm , e.g. for a reamer with a nominal diameter $d_1 = 20$ mm, upper tolerance limit = + (p) 25 μm and lower tolerance limit = + (p) 15 μm :

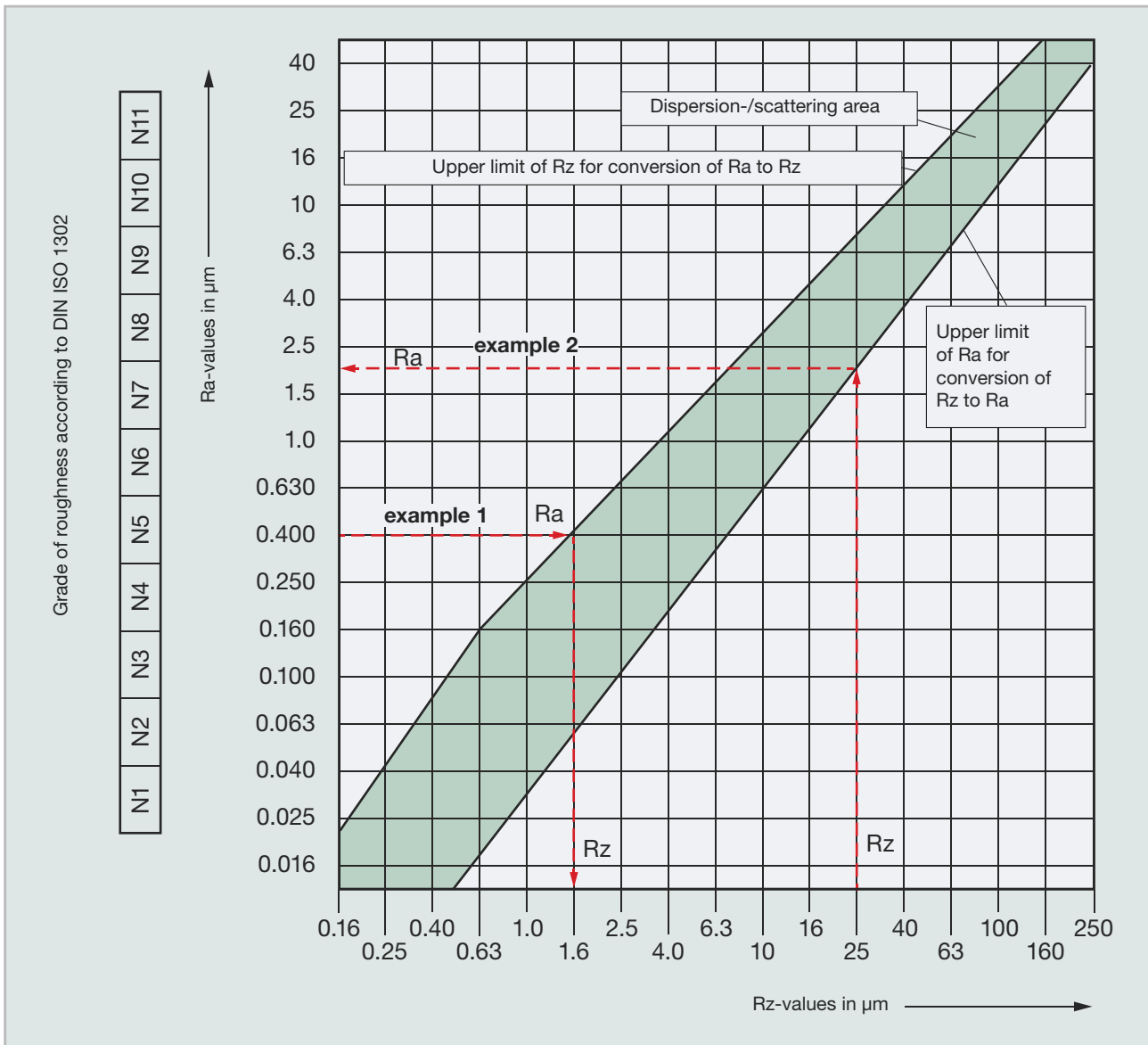
reamer 20 p 25 p 15 DIN ...

The designation shows a 'p' instead of the plus and an 'm' instead of the minus sign, because »+« and »-« cannot be written on all machines, particularly not on data processing machines.

Tolerance position



Conversion ratio to DIN 47



Reading example 1 R_a in R_z

When comparing the average roughness index $R_a = 0.4 \mu\text{m}$ to the average roughness R_z we achieve a value of $R_z = 1.6 \mu\text{m}$.

Reading example 2 R_z in R_a

When comparing the average roughness $R_z = 25 \mu\text{m}$ to the average roughness index R_a we achieve a value of $R_a = 2 \mu\text{m}$.



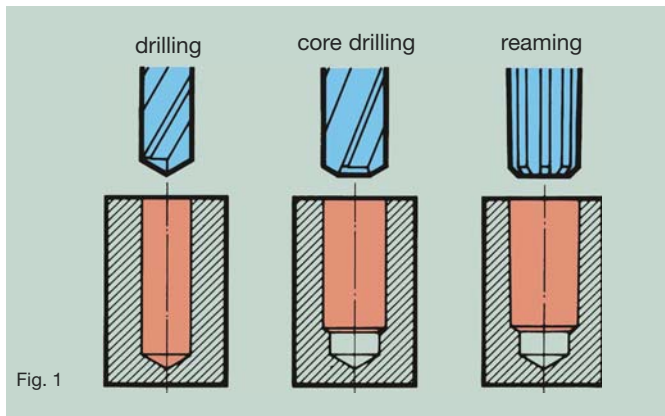
Achievable surface quality for reaming operations

Roughness classes		N11	N10	N9	N8		N7	N6		N5	N4	N3	N2	N1
Average roughness R_a		25	12.5	6.3	3.2		1.6	0.8		0.4	0.2	0.1	0.05	0.025
Average peak-to-valley height R_z		100	63	40	25	16	10	6.3	4	2.5	1.6	1	0.63	0.25
P	Struct. steel, low-alloyed steels: Case-hard. and heat-treat. steels													
M	Stainless steels Heat-resistant steels													
K	Grey cast iron, ferritic													
	Grey cast iron, pearlitic													
	Spheroidal graphite iron, ferritic													
	Spheroidal graphite iron, pearlitic													
N	Copper-alloy, brass													
	Aluminium wrought alloy													
	Aluminium cast alloy: Si-content < 10 %													
	Aluminium cast alloy: Si-content > 10 %													
S	Special alloy: Inconel													
	Titanium, titanium alloys													
H	Hardened steel < 45 HRC													
	Hardened steel > 45 HRC, <= 63 HRC													

achievable limited achievability

Selection and application

The reamer is the most commonly used tool for the production of holes true to form and tolerance with high surface quality. The latter meets the requirement of 'finishing' or 'fine finishing' i.e. from approximately Ra 0.2 to 6.5 μm according to the scales laid down in DIN 4766. However, finishes to Ra = 0.5 μm can be regarded as satisfactory. Generally, the achievable tolerance ranks at IT 7. In special cases IT 6 or even IT 5 are possible, provided that the reamer is appropriately ground and all other operating conditions meet the high specifications.



In preparation for the reaming process, holes have to be pre-drilled and normally core drilled (fig. 1). Pre-drilled holes produced with gun drills, are due to their highly compressed surface, not particularly suitable for reaming. Moreover, holes produced with gun drills show generally excellent tolerances on fit and surface qualities, so that additional fine finishing is usually not required. Should any further information on our gun drills be needed, please do not hesitate to contact us.

Which reamer for which purpose?

With regard to their application we differentiate between:

- hand reamers
- machine reamers

Hand reamers

Hand reamers are turned in the hole by means of a tap wrench which is mounted on the square. The feeding action is produced manually. Because of the low cutting rates these tools are made of HSS. To ensure a proper guidance in the hole the taper lead length of hand reamers is made considerably longer than that of machine reamers. Hand reamers are available for both cylindrical and tapered holes.

Hand reamers to DIN 859 may be adjusted within the elasticity tolerance range of hardened HSS. This corresponds in practice to 1% of the diameter, i.e. for example 0.1 mm on a reamer with 10 mm diameter. In the fully expanded condition these tools are not very resistant to breakage and must therefore be protected against impact. They should be stored with the tension released.

Expanding reamers can be adjusted over a much larger range, even up to a few millimeters! For accuracy reasons setting must be carried out with a ring gauge.

A basic rule for reaming by hand: turn the tool only in the cutting direction, i.e. never reverse the tool contrary to standard practice in thread cutting. Cutting edges will become immediately blunt if the reamer is turned back.



Fig. 2: taper hand reamer



Fig. 3: adjustable hand reamer



Fig. 4: expanding hand reamer with blades

Machine reamers

Machine reamers are - as the name implies - exclusively designed for use on machines and differ with regard to the type of tool material. Due to the possibility of higher cutting values, these tools are available in HSS-E, solid carbide or carbide-tipped (fig. 5). The tool material should be selected in accordance with the material to be machined.



Fig. 5: carbide-tipped machine reamer

Carbide reamers offer the following advantages:

- Higher cutting speeds and feed rates.
- Most economic machining of materials of over 1200 mm² tensile strength.
- The tool life is much higher than that of HSS-E reamers.



Selection and application

Reamers with special form

Reamers with special form and to special tolerances have recently become more and more common place. Their manufacture requires a great deal of know-how as well as the most modern and sophisticated tooling. We have all the machines and the knowledge to produce even the most complicated tools very economically. Leave the machining problems to us. To meet and overcome them is the daily task of our engineers. They are ready to assist you at all times, to find the best possible solution and, if necessary, to arrange for an obligation-free demonstration of our tools on your own machines.

A further distinctive feature of hand and machine reamers is the geometry of the cutting section, standardised under the following headings:

- straight-fluted reamers
- LH spiral reamers
- reamers with quick spiral (45°) left-hand flutes

Tools with right-hand spiral flutes are only applied in special cases. They produce, as do twist drills, a chip flow up the flutes, which often results in an unsatisfactory surface finish quality.

Reamers with straight flutes are suitable for the machining of blind holes. Here again the absence of chip space at the bottom of the hole means that swarf must be evacuated up the reamer flutes. For all other machining tasks, and particularly for interrupted holes (e.g. holes with keyways, intersecting holes and the like), reamers with left-hand spiral flutes are much more suitable. Chip removal is always in the direction of the feed and for this reason this flute geometry is used almost exclusively for through holes. Their application in blind holes is limited to tasks where reaming to the full depth is not required, so that sufficient space for the chip volume created is available.



Fig. 6: machine roughing reamer



Fig. 7: machine bottoming reamer

The 45° LH quick spiral reamer (fig. 6) has been well tried and tested in long-chipping materials. For absolutely straight and precisely located deep holes we recommend our machine bottoming reamers (fig. 7). Their bevel lead is face-cutting, i.e., they do not cut in conformity with the pre-drilled hole, but correct it truly to size. Machine bottoming reamers should always be applied with bushings.



Fig. 8: stepped carbide-tipped machine reamer

Accuracy in surface quality and form is tremendously improved by dividing the machining process into rough and finishing reaming. Stepped machine reamers (fig. 8) perform these two operations in one pass.

Badly worn taper pin reamers can be salvaged by resharpening of taper and reduction of circular land width.

Storage of reamers

Reamers are finishing tools and therefore very vulnerable. To avoid damage, individual storage and transport in our plastic sleeves is recommended. Tools reward careful treatment by producing excellent results and giving much higher operational life.

Special recommendations for reaming with machine reamers

Blind hole or through hole

Straight-fluted reamers are generally applied in blind holes as they, due to their cutting edge geometry, evacuate the chips from the hole against the direction of the feed. Spiral reamers are preferred for the application in through holes because the spiral evacuates the chips from the hole in direction of the feed.

Interrupted holes

Spiral reamers are preferred for the application in interrupted holes because the cutting edge geometry, in comparison to straight-fluted tools, possesses a lesser tendency of grabbing on the oblique hole. If the oblique hole is $> 0.25 \times D$, spiral reamers can also be applied in blind holes.

Stock removal allowance of the pre-drilled hole

In the event of the stock removal allowance of the pre-drilled hole exceeding the standard stock removal allowance (see table „Recommended stock allowance“ on page 47), a quick spiral reamer or a machine bridge reamer should be applied. It is possible to machine a considerably larger stock removal allowance with these tools, however, they should not be applied in blind holes due to the bevel lead length and the spiral angle.

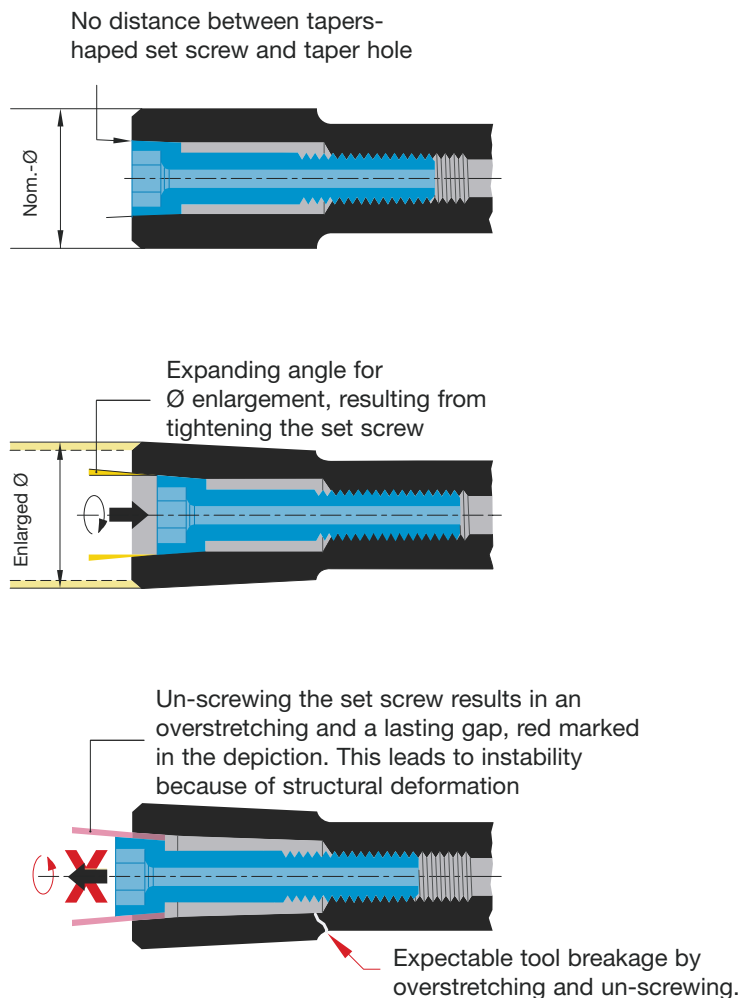
Expanding reamers

Expanding reamers can only be expanded. Subsequently, if the resulting measurement is too large it is not possible to turn the screw back as the pretension of the tool would be lost. In most cases this leads to tool breakage. If the pre-tension has been taken from the tool, it requires re-adjusting and re-grinding.

Positional accuracy of the hole

A machine bottoming reamer often provides the best solution when optimal positional accuracy is required, thanks to its special chamfer lead the 'wander' of the tool is minimal. In addition, machine bottoming reamers are often applied when the pre-drilled hole and the reamer are not on the same axis (slight misalignment).

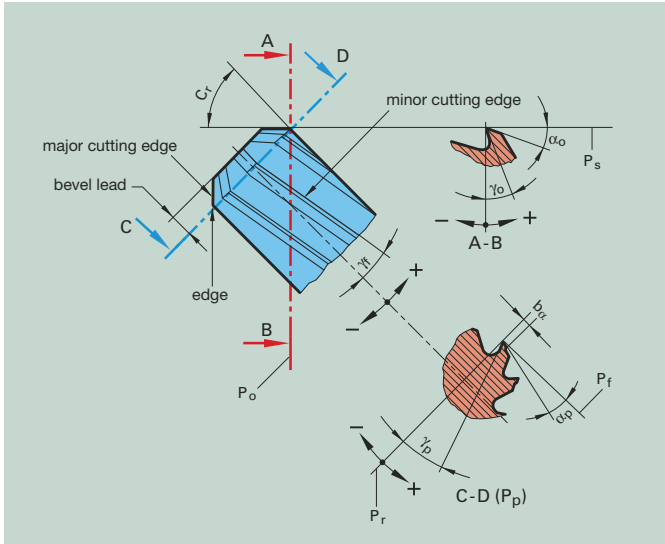
Schematic depiction of expanding and of risk of tool breakage when re-turning set screw (excessive depiction)



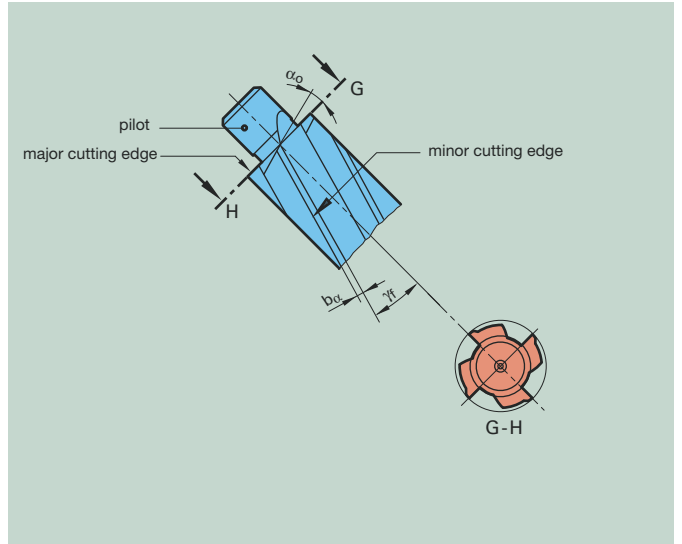


Definitions, dimensions and angles

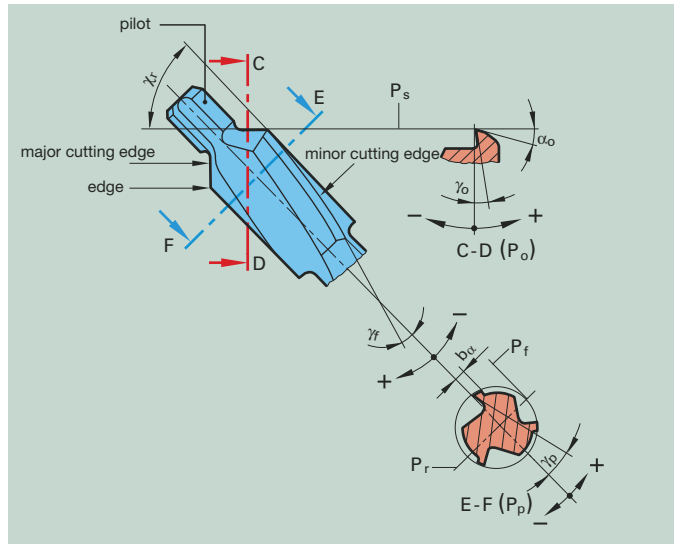
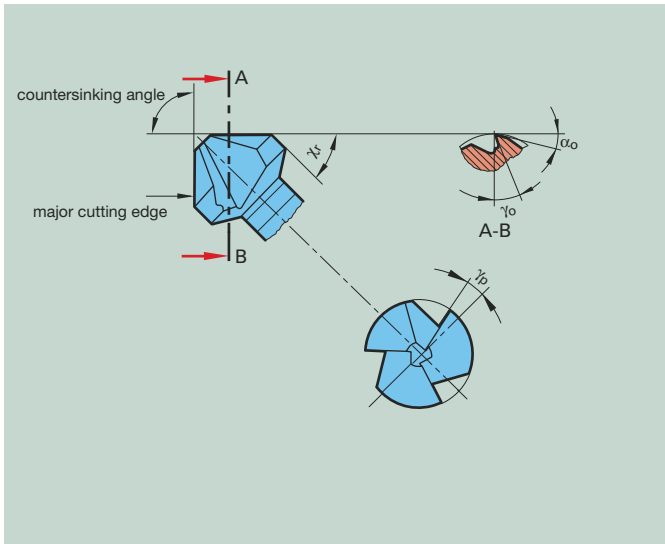
Reamers



Counterbores



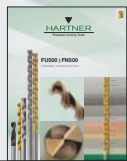
Countersinks



- α_o = clearance angle
- α_p = clearance angle of minor cutting edge
- b_α = circular land width
- γ_o = orthogonal rake angle
- γ_f = helix angle
- γ_p = back rake angle of minor cutting edge

- χ_r = face setting angle
- P_o = tool orthogonal plane
- P_f = assumed operating plane
- P_p = tool back plane
- P_r = tool reference plane
- P_s = tool cutting edge plane

Our programme:



FU 500/FN500



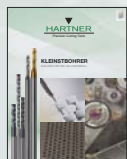
Gun Drills



INOX Drills



Multiplex



Micro Precision Drills



Multiplex HPC



TS-Drills



TM Vending Machines



Threading Tools



Solid Carbide
High Performance Milling Cutters



TF 100 Multi-Mill



Chamfering Milling Cutters

Hartner GmbH

P.O. Box 10 04 27, D-72425 Albstadt

Tel. +49 74 31/1 25-0, Fax +49 74 31/1 25-21 547

www.hartner.de