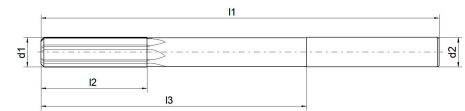


VHM-NC/HRC-Maschinenreibahlen

Solid carbide NC/HRC machine reamers



Artikelnummer Article-No.	d1 h7	l1	l2	l3	d2	flutes
E.5631NC.1.0097	0.97	60	6	20	3,0	3
E.5631NC.1.0100	1	60	6	20	3,0	3
E.5631NC.1.0197	1.97	60	15	30	3,0	4
E.5631NC.1.0198	1.98	60	15	30	3,0	4
E.5631NC.1.0199	1.99	60	15	30	3,0	4
E.5631NC.1.0200	2	60	15	30	3,0	4
E.5631NC.1.0201	2.01	60	15	30	3,0	4
E.5631NC.1.0202	2.02	60	15	30	3,0	4
E.5631NC.1.0203	2.03	60	15	30	3,0	4
E.5631NC.1.0296	2.96	60	15	30	3,0	4
E.5631NC.1.0297	2.97	60	15	30	3,0	4
E.5631NC.1.0298	2.98	60	15	30	3,0	4
E.5631NC.1.0299	2.99	60	15	30	3,0	4
E.5631NC.1.0300	3	60	15	30	3,0	4
E.5631NC.1.0301	3.01	60	15	30	3,0	4
E.5631NC.1.0302	3.02	60	15	30	3,0	4
E.5631NC.1.0303	3.03	60	15	30	3,0	4
E.5631NC.1.0304	3.04	60	15	30	3,0	4
E.5631NC.1.0305	3.05	60	15	30	3,0	4
E.5631NC.1.0396	3.96	80	18	40	6,0	4
E.5631NC.1.0397	3.97	80	18	40	6,0	4
E.5631NC.1.0398	3.98	80	18	40	6,0	4
E.5631NC.1.0399	3.99	80	18	40	6,0	4
E.5631NC.1.0400	4	80	18	40	6,0	4
E.5631NC.1.0401	4.01	80	18	40	6,0	4
E.5631NC.1.0402	4.02	80	18	40	6,0	4
E.5631NC.1.0403	4.03	80	18	40	6,0	4
E.5631NC.1.0404	4.04	80	18	40	6,0	4
E.5631NC.1.0405	4.05	80	18	40	6,0	4
E.5631NC.1.0495	4.95	100	26	60	6,0	6
E.5631NC.1.0497	4.97	100	26	60	6,0	6
E.5631NC.1.0498	4.98	100	26	60	6,0	6
E.5631NC.1.0499	4.99	100	26	60	6,0	6
E.5631NC.1.0500	5	100	26	60	6,0	6
E.5631NC.1.0501	5.01	100	26	60	6,0	6

PRODUCT DATA SHEET



Artikelnummer Article-No.	d1 h7	I1	I2	I3	d2	flutes
E.5631NC.1.0502	5.02	100	26	60	6,0	6
E.5631NC.1.0503	5.03	100	26	60	6,0	6
E.5631NC.1.0504	5.04	100	26	60	6,0	6
E.5631NC.1.0550	5.5	100	26	60	6,0	6
E.5631NC.1.0595	5.95	100	26	60	6,0	6
E.5631NC.1.0596	5.96	100	26	60	6,0	6
E.5631NC.1.0597	5.97	100	26	60	6,0	6
E.5631NC.1.0598	5.98	100	26	60	6,0	6
E.5631NC.1.0599	5.99	100	26	60	6,0	6
E.5631NC.1.0600	6	100	26	60	6,0	6
E.5631NC.1.0601	6.01	100	26	60	6,0	6
E.5631NC.1.0602	6.02	100	26	60	6,0	6
E.5631NC.1.0603	6.03	100	26	60	6,0	6
E.5631NC.1.0795	7.95	118	36	75	8,0	6
E.5631NC.1.0797	7.97	118	36	75	8,0	6
E.5631NC.1.0798	7.98	118	36	75	8,0	6
E.5631NC.1.0799	7.99	118	36	75	8,0	6
E.5631NC.1.0800	8	118	36	75	8,0	6
E.5631NC.1.0801	8.01	118	36	75	8,0	6
E.5631NC.1.0802	8.02	118	36	75	8,0	6
E.5631NC.1.0803	8.03	118	36	75	8,0	6
E.5631NC.1.0830	8.3	135	36	90	10,0	6
E.5631NC.1.0996	9.96	135	36	90	10,0	6
E.5631NC.1.0997	9.97	135	36	90	10,0	6
E.5631NC.1.0998	9.98	135	36	90	10,0	6
E.5631NC.1.0999	9.99	135	36	90	10,0	6
E.5631NC.1.1000	10	135	36	90	10,0	6
E.5631NC.1.1001	10.01	135	36	90	10,0	6
E.5631NC.1.1002	10.02	135	36	90	10,0	6
E.5631NC.1.1195	11.95	150	45	100	12,0	6
E.5631NC.1.1197	11.97	150	45	100	12,0	6
E.5631NC.1.1198	11.98	150	45	100	12,0	6
E.5631NC.1.1199	11.99	150	45	100	12,0	6
E.5631NC.1.1200	12	150	45	100	12,0	6
E.5631NC.1.1201	12.01	150	45	100	12,0	6
E.5631NC.1.1202	12.02	150	45	100	12,0	6
E.5631NC.1.1203	12.03	150	45	100	12,0	6
E.5631NC.1.1204	12.04	150	45	100	12,0	6



Individuelle Schnittdaten online im
Schnittdaten-Rechner berechnen lassen:
Calculate individual cutting
data online in the cutting data calculator
www.nachreiner-schnittdaten.eu

Materialbezeichnung material description	Bearbeitung Process	Vc m/min	fz							
			Ø 0.97-1.00	Ø 1.97-2.03	Ø 2.96-3.05	Ø 3.96-5.50	Ø 5.95-6.03	Ø 7.95-8.30	Ø 9.96-10.02	Ø 11.95-12.04
PA allg. Stähle General steels	Reibahlen und Senker VHM	12.00	0.030	0.040	0.050	0.075	0.120	0.135	0.155	0.170
PV Vergütungsstähle < 1400N/mm² Tempering steel < 1400N/mm²	Reibahlen und Senker VHM	12.00	0.025	0.030	0.035	0.060	0.090	0.100	0.120	0.140
Vergütungsstähle > 1400N/mm² Tempering steel > 1400N/mm²	Reibahlen und Senker VHM	10.00	0.025	0.030	0.035	0.060	0.090	0.100	0.120	0.140

PRODUCT DATA SHEET



Materialbezeichnung material description		Bearbeitung Process	Vc m/min	fz							
				∅ 0.97-1.00	∅ 1.97-2.03	∅ 2.96-3.05	∅ 3.96-5.50	∅ 5.95-6.03	∅ 7.95-8.30	∅ 9.96-10.02	∅ 11.95-12.04
K	Temperguss Malleable cast iron	Reibahlen und Senker VHM	17.00	0.060	0.075	0.090	0.140	0.180	0.230	0.260	0.280
	Gusseisen mit Kugelgraphit Nodular cast iron	Reibahlen und Senker VHM	0.00								
H	gehärtete Stähle 45-55 HRC Hardened steels 45-55 HRC	Reibahlen und Senker VHM	10.00	0.050	0.075	0.100	0.160	0.200	0.300		
	gehärtete Stähle 55-60 HRC Hardened steels 55-60 HRC	Reibahlen und Senker VHM	8.00	0.050	0.075	0.100	0.160	0.200	0.300		
	gehärtete Stähle 60-65 HRC Hardened steels 60-65 HRC	Reibahlen und Senker VHM	5.00	0.050	0.075	0.100	0.160	0.200	0.300		