

OVERVIEW OF NC MACHINE REAMERS



			WN HSCO 0620 10 ...	
DIN/Type				
Cutting material				
Art. Pre-No.				
d1		h7		
d2		h6		
L1		Total length		
L2		Cutting edge length		
Z		Teeth	6	
Design			Left-hand spiral	
Material group		Material designations	Tensile strength/Hardness in MPa (N/mm²)	
Conventional steels		ST 33, StE285, P265GH, ST50-2, rod steels, boiler plates	500-850	●●
		C22, CK30	≤700	●●
		C45, CK45	700-850	●●
		C60, CK60	850 - 1,000	●●
		50MnSi4, 38Cr2, 28Cr4	850 ≤1,000	●●
		36NiCr6, 41Cr4, 42CrMo4	1,000-1,200	●●
		34CrAl6	≥850 ≥1,000	●●
Titanium		31CrMoV9, 34CrAlNi7	>1,000-1,200	●●
		C75W, 102Cr6, 29CrMoV9	≤850	●●
		X210CR12, X42Cr13, 105WCr6, X45NiCrMo4	> 850 - 1,000	●●
		S 6-5-2-5, S 6-5-2, S 6-5-3	≥ 650 - 1,000	●●
Special alloys		Ti99,5, TiAl5Sn2,5,TiCu2	≤850	●
		TiAl6Zr5, TiAl6V4, TiAl4Mo4Sn2,5, - TiAl8Mo1V1	< 850 - 1,200	●
Difficult-to-machine steels		Nimonic, Inconel, Monel, Hastelloy	≤ 1,200	●
		Hardox	Hardox 400-500, XAR 320, XAR 400	
		Spring steels	55Si7,55Cr3,51CrV4	≤330 HB (hardness)
Stainless steel		X12CrS13, X14CrMoS17, X8CrNiS18-9	≤ 850	●
		X5CrNi18-10, X6CrNiTi18-10, X6CrNiMoTi17-12-2 (V4A)	≤ 850	●
		X20CrNi 17 2 (X17CrNi16-2), X39CrMo17-1, X2CrMoTi18-2	≤ 850	●
Cast iron		EN-GJL-100 (GG10), EN-GJL-200(GG20)	≤ 240 HB	●●
		EN-GJL-250 (GG25), EN-GJL-350 (GG35)	< 300 HB	●●
		EN-GJS-500-7 (GGG50), EN-GJMW 350-4 (GTW35)	≤ 240 HB	●●
		EN-GJS-700-2 (GGG70), ENGJMB-700-2 (GTS70)	< 300 HB	●●
		White cast iron	≤350 HB	●●
Nonferrous metal		Al99.5, AlMgSi1, AlMg1,	≤ 400	●
		AlMgSiPb, AlCuMg1, AlMg3,Si, AlZnMgCu1,5	≤ 450	●
		G-AlSi5Cu1, G-AlSi7Cu3, G-AlSi9	≤600	●
		G-AlSi12, G-AlSi12Cu, G-AlSi12CuNiMg	≤ 600	●
		MgMn2, G-MgAl8Zn1, G-MgAl6Zn1	≤ 450	●
		Se-Cu, SuSn6,G-CuSn5ZnPb	≤400	●
		CuZn39Pb2, CuZn39Pb3, CuZn43Pb2	≤ 600	●
		Cu Zn20, CuZn33, CuZn37Pb0,5	≤600	●
		CuSn7ZnPb, CuPb5Sn5, CuPb10Sn	≤ 600	●
		CuNi18Zn19Pb	>600-850	●
Plastics		CuAl5, CuAl9Mn, CuSn10,	≤ 850	●
		CuAl11Ni, CuBe2	>850-1,000	●
		Plastics, duroplastic	Bakelite, Resopal, Pertinax, Moltopren	●
		Plastics, thermoplastic	Plexiglas, Hostalen, Novodur, Makrolon	●
Areas of use of application:		Plastics, aramide-fiber reinforced	Kevlar	
		Plastics, fiberglass-/carbon fiber-reinforced	GFRP/CFRP	

Not suitable

● Suitable

●● Highly suitable