
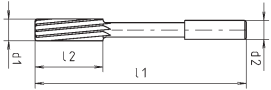


OVERVIEW OF NC MACHINE REAMERS



			
DIN/Type		WN	
Cutting material		HSCO	
Art. Pre-No.		0620 10 ...	
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)	
General structural steels	ST 33, StE285, P265GH, ST50-2, rod steels, boiler plates	500-850	●●
Non-alloyed tempering steels	C22, CK30	≤700	●●
	C45, CK45	700-850	●●
	C60, CK60	850 - 1,000	●●
Alloyed tempering steels	50MnSi4, 38Cr2, 28Cr4	850 ≤1,000	●●
	36NiCr6, 41Cr4, 42CrMo4	1,000-1,200	●●
Nitriding steels	34CrAl6	≥850 ≥1,000	●●
	31CrMoV9, 34CrAlNi7	>1,000-1,200	●●
Tool steels	C75W, 102Cr6, 29CrMoV9	≤850	●●
	X210CR12, X42Cr13, 105WCr6, X45NiCrMo4	> 850 - 1,000	●●
High-speed steels	S 6-5-2-5, S 6-5-2, S 6-5-3	≥ 650 - 1,000	●●
Titanium and titanium alloys	Ti99,5, TiAl5Sn2,5,TiCu2	≤850	●
	TiAl6Zr5, TiAl6V4, TiAl4Mo4Sn2.5, - TiAl8Mo1V1	< 850 - 1,200	●
Special alloys	Nimonic, Inconel, Monel, Hastelloy	≤ 1,200	●
Hardox	Hardox 400-500, XAR 320, XAR 400		
Spring steels	55Si7,55Cr3,51CrV4	≤330 HB (hardness)	
Stainless steels, sulfured	X12CrS13, X14CrMoS17, X8CrNiS18-9	≤ 850	●
Stainless steels, austenitic	X5CrNi18-10, X6CrNiTi18-10, X6CrNiMoTi17-12-2 (V4A)	≤ 850	●
Stainless steels, martensitic	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	●●
Spheroidal-graphite and malleable cast iron	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	●●
Aluminum and aluminum alloys	Al99.5, AlMgSi1, AlMg1,	≤ 400	●
Aluminum wrought alloys	AlMgSiPb, AlCuMg1, AlMg3,Si, AlZnMgCu1.5	≤ 450	●
Aluminum cast alloys ≤ 10% Si	G-AlSi5Cu1, G-AlSi7Cu3, G-AlSi9	≤600	●
Aluminum cast alloys >10% Si	G-AlSi12, G-AlSi12Cu, G-AlSi12CuNiMg	≤ 600	●
Magnesium alloys	MgMn2, G-MgAl8Zn1, G-MgAl6Zn1	≤ 450	●
Copper, low-alloyed	Se-Cu, SuSn6,G-CuSn5ZnPb	≤400	●
Brass, short-chipping	CuZn39Pb2, CuZn39Pb3, CuZn43Pb2	≤ 600	●
Brass, long-chipping	Cu Zn20, CuZn33, CuZn37Pb0,5	≤600	●
Bronze, short-chipping	CuSn7ZnPb, CuPb5Sn5, CuPb10Sn	≤ 600	●
	CuNi18Zn19Pb	>600-850	●
Bronze, long-chipping	CuAl5, CuAl9Mn, CuSn10,	≤ 850	●
	CuAl11Ni, CuBe2	>850-1,000	●
Plastics, duroplastic	Bakelite, Resopal, Pertinax, Moltopren		●
Plastics, thermoplastic	Plexiglas, Hostalen, Novodur, Makrolon		●
Plastics, aramide-fiber reinforced	Kevlar		
Plastics, fiberglass-/carbon fiber-reinforced	GFRP/CFRP		

Areas of use of application: Not suitable

● Suitable

●● Highly suitable