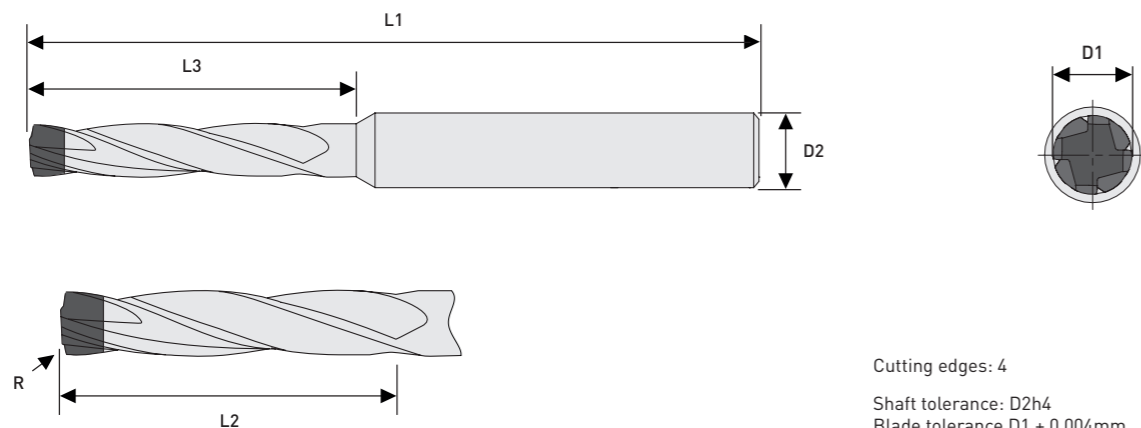


Solid CBN Reamers with helix angle

for hard reaming up to 72 HRC



Cutting edges: 4
 Shaft tolerance: D2h4
 Blade tolerance D1 + 0,004mm
 Helix angle right

D1	L3	L2	L1	D2	R	Item No.
1,50	10,00	8,00	48,00	3,00	0,20	RA5940-0002
1,60	10,00	8,00	48,00	3,00	0,20	RA5940-0004
1,70	10,00	8,00	48,00	3,00	0,20	RA5940-0006
1,80	10,00	8,00	48,00	3,00	0,20	RA5940-0008
1,90	10,00	8,00	48,00	3,00	0,20	RA5940-0010
1,98	15,00	13,00	48,00	3,00	0,20	RA5940-0012
1,99	15,00	13,00	48,00	3,00	0,20	RA5940-0014
2,00	15,00	13,00	48,00	3,00	0,20	RA5940-0016
2,01	15,00	13,00	48,00	3,00	0,20	RA5940-0018
2,02	15,00	13,00	48,00	3,00	0,20	RA5940-0020
2,03	15,00	13,00	48,00	3,00	0,20	RA5940-0022
2,10	15,00	13,00	48,00	3,00	0,30	RA5940-0024
2,20	15,00	13,00	48,00	3,00	0,30	RA5940-0026
2,30	15,00	13,00	48,00	3,00	0,30	RA5940-0028
2,40	15,00	13,00	48,00	3,00	0,30	RA5940-0030

D1	L3	L2	L1	D2	R	Item No.
2,50	15,00	13,00	48,00	3,00	0,30	RA5940-0032
2,60	15,00	13,00	48,00	3,00	0,30	RA5940-0034
2,70	15,00	13,00	48,00	3,00	0,30	RA5940-0036
2,80	15,00	13,00	48,00	3,00	0,30	RA5940-0038
2,90	15,00	13,00	48,00	3,00	0,30	RA5940-0040
2,98	20,00	18,00	58,00	3,00	0,30	RA5940-0042
2,99	20,00	18,00	58,00	3,00	0,30	RA5940-0044
3,00	20,00	18,00	58,00	3,00	0,30	RA5940-0046
3,01	20,00	18,00	58,00	3,00	0,30	RA5940-0048
3,02	20,00	18,00	58,00	3,00	0,30	RA5940-0050
3,03	20,00	18,00	58,00	3,00	0,30	RA5940-0052
3,10	20,00	18,00	58,00	4,00	0,30	RA5940-0054
3,20	20,00	18,00	58,00	4,00	0,30	RA5940-0056
3,30	20,00	18,00	58,00	4,00	0,30	RA5940-0058
3,40	20,00	18,00	58,00	4,00	0,30	RA5940-0060
3,50	20,00	18,00	58,00	4,00	0,30	RA5940-0062
3,60	20,00	18,00	58,00	4,00	0,30	RA5940-0064
3,70	20,00	18,00	58,00	4,00	0,30	RA5940-0066
3,80	20,00	18,00	58,00	4,00	0,30	RA5940-0068
3,90	20,00	18,00	58,00	4,00	0,30	RA5940-0070
3,98	25,00	23,00	58,00	4,00	0,30	RA5940-0072
3,99	25,00	23,00	58,00	4,00	0,30	RA5940-0074
4,00	25,00	23,00	58,00	4,00	0,40	RA5940-0076

Application range:

- CBN Steel hardened and Tool Steel up to 72 HRC, powder metallurgical Steel, Sintered steel hardened, Grey Cast Iron hardened, Carbide ...

You will find further application ranges in the detailed overview on page 8.



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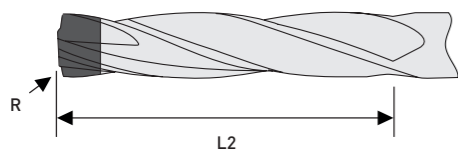
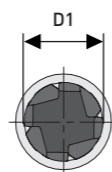
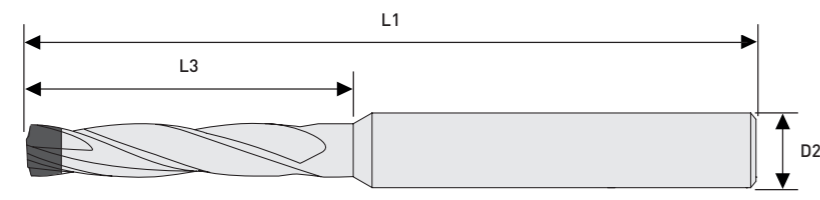


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Subject to technical changes.

Solid CBN Reamers with helix angle

for hard reaming up to 72 HRC



Cutting edges: 4
 Shaft tolerance: D2h4
 Blade tolerance D1 + 0,004mm
 Helix angle right

D1	L3	L2	L1	D2	R	Item No.
4,01	25,00	23,00	58,00	4,00	0,40	RA5940-0078
4,02	25,00	23,00	58,00	4,00	0,40	RA5940-0080
4,03	25,00	23,00	58,00	4,00	0,40	RA5940-0082
4,10	25,00	23,00	58,00	6,00	0,40	RA5940-0084
4,20	25,00	23,00	58,00	6,00	0,40	RA5940-0086
4,30	25,00	23,00	58,00	6,00	0,40	RA5940-0088
4,40	25,00	23,00	58,00	6,00	0,40	RA5940-0090
4,50	25,00	23,00	58,00	6,00	0,40	RA5940-0092
4,60	25,00	23,00	58,00	6,00	0,40	RA5940-0094
4,70	25,00	23,00	58,00	6,00	0,40	RA5940-0096
4,80	25,00	23,00	58,00	6,00	0,40	RA5940-0098
4,90	25,00	23,00	58,00	6,00	0,40	RA5940-0100
4,98	30,00	28,00	68,00	6,00	0,40	RA5940-0102
4,99	30,00	28,00	68,00	6,00	0,40	RA5940-0104
5,00	30,00	28,00	68,00	6,00	0,50	RA5940-0106

D1	L3	L2	L1	D2	R	Item No.
5,01	30,00	28,00	68,00	6,00	0,50	RA5940-0108
5,02	30,00	28,00	68,00	6,00	0,50	RA5940-0110
5,03	30,00	28,00	68,00	6,00	0,50	RA5940-0112
5,10	30,00	28,00	68,00	6,00	0,50	RA5940-0114
5,20	30,00	28,00	68,00	6,00	0,50	RA5940-0116
5,30	30,00	28,00	68,00	6,00	0,50	RA5940-0118
5,40	30,00	28,00	68,00	6,00	0,50	RA5940-0120
5,50	30,00	28,00	68,00	6,00	0,50	RA5940-0122
5,60	30,00	28,00	68,00	6,00	0,50	RA5940-0124
5,70	30,00	28,00	68,00	6,00	0,50	RA5940-0126
5,80	30,00	28,00	68,00	6,00	0,50	RA5940-0128
5,90	30,00	28,00	68,00	6,00	0,50	RA5940-0130
5,98	30,00	28,00	68,00	6,00	0,50	RA5940-0132
5,99	30,00	28,00	68,00	6,00	0,50	RA5940-0134
6,00	30,00	28,00	68,00	6,00	0,50	RA5940-0136
6,01	30,00	28,00	68,00	6,00	0,50	RA5940-0138
6,02	30,00	28,00	68,00	6,00	0,50	RA5940-0140
6,03	30,00	28,00	68,00	6,00	0,50	RA5940-0142

Application range:

- CBN Steel hardened and Tool Steel up to 72 HRC, powder metallurgical Steel, Sintered steel hardened, Grey Cast Iron hardened, Carbide ...

You will find further application ranges in the detailed overview on page 8.



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 Visit us at diamond-tools24.com

Subject to technical changes.

Cutting Parameters

for our CBNCoat Drills



		CBNCoat Drills								
			Ø 2	Ø 3	Ø 4	Ø 5	Ø 6	Ø 8	Ø 10	Ø 12
Material		V _c [m/min]	F [mm/rev]	F [mm/rev]	F [mm/rev]	F [mm/rev]	F [mm/rev]	F [mm/rev]	F [mm/rev]	F [mm/rev]
Steel, hardened 48-55 HRC	min.	20	0,010	0,030	0,050	0,060	0,070	0,070	0,080	0,090
	max.	35	0,050	0,060	0,080	0,090	0,100	0,100	0,110	0,120
Steel, hardened 55-60 HRC	min.	10	0,010	0,030	0,050	0,060	0,070	0,070	0,080	0,090
	max.	25	0,050	0,060	0,080	0,090	0,100	0,100	0,110	0,120
Steel, hardened 60-68 HRC	min.	10	0,010	0,030	0,050	0,060	0,070	0,070	0,080	0,090
	max.	20	0,050	0,060	0,080	0,090	0,100	0,100	0,110	0,120
Tool steel, up to 68 HRC	min.	10	0,020	0,030	0,050	0,060	0,070	0,070	0,080	0,080
	max.	30	0,050	0,060	0,080	0,100	0,100	0,100	0,110	0,120

Cooling Recommended

While machining with CBNCoat Drills, proper cooling is a key point.



1. Choice: Emulsion

2. Choice: Oil




If you have any further technical questions, please do not hesitate to contact us by phone or e-mail!

Phone: +49(0)6301 32011-0

Mail: info@diamond-toolingsystems.com

Cutting Parameters

for our Solid CBN Reamers



		Solid CBN Reamers						
			Ø 1,5	Ø 2	Ø 3	Ø 4	Ø 5	Ø 6
Material		V _c [m/min]	F [mm/rev]	F [mm/rev]	F [mm/rev]	F [mm/rev]	F [mm/rev]	F [mm/rev]
Steel, hardened 48-55 HRC	min.	10	0,010	0,010	0,020	0,030	0,030	0,030
	max.	30	0,030	0,040	0,070	0,070	0,090	0,090
Steel, hardened 55-60 HRC	min.	10	0,010	0,010	0,020	0,030	0,030	0,030
	max.	25	0,030	0,040	0,070	0,070	0,090	0,090
Steel, hardened 60-72 HRC	min.	10	0,010	0,010	0,030	0,030	0,030	0,030
	max.	25	0,030	0,030	0,070	0,070	0,090	0,090
Tool and PM Steel, up to 72HRC	min.	10	0,010	0,010	0,030	0,030	0,030	0,030
	max.	30	0,030	0,030	0,070	0,070	0,090	0,090
Casting	min.	25	0,010	0,010	0,030	0,030	0,030	0,030
	max.	55	0,020	0,020	0,070	0,070	0,090	0,090
Carbide	min.	on request						
	max.	on request						

Cooling Recommended

While machining with Solid CBN Reamers, proper cooling is a key point.



1. Choice: Emulsion or Oil



If you have any further technical questions, please do not hesitate to contact us by phone or e-mail!

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