

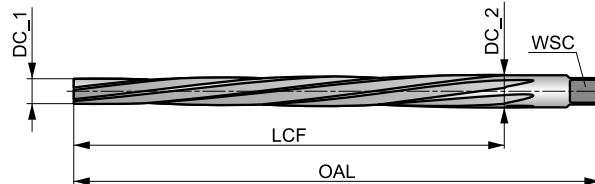


B952



HSS Straight Shank Taper Pin Hand Reamer 1:50 Taper, Bright Finish

With left-hand helix and right-hand cutting, gives smooth reaming for a more accurate hole size and better finish. The small end diameter has been reduced, making it easier to locate and center the reamer in the hole. Suitable for reaming in many materials.



HSS	Bright	DIN 9
R		B
1:50		

Workpiece material group suitability, starting values for cutting speed (m/min) and feed Alpha Code. Tables with feed per revolution can be found starting from page 251.

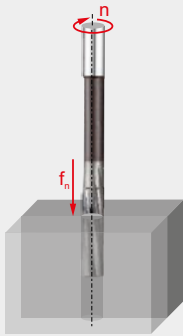
P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■	■	■	■	■	■	■	■	■	■	■	■	■	■
M2.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	N1.1	N1.2	N1.3	N2.1	N2.2
■	■	■	■	■	■	■	■	■	■	■	■	■	■
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2								
■	■	■	■	■	■								

DCON MS tolerance h11; DC <= 2.5mm Straight flute, form A.

Product	nom d	DC_1	DC_2	OAL	LCF	NOF	WSC	DCON MS
		[mm]	[mm]					
B9521.2	1.2	1.10	1.74	50.0	32.0	3	2.40	3.15
B9521.5	1.5	1.40	2.14	57.0	37.0	3	2.40	3.15
B9522.0	2.0	1.90	2.86	68.0	48.0	3	2.40	3.15
B9522.5	2.5	2.40	3.36	68.0	48.0	4	2.40	3.15
B9523.0	3.0	2.90	4.06	80.0	58.0	5	3.00	4.00
B9523.5	3.5	3.40	4.66	87.0	63.0	5	3.40	4.50
B9524.0	4.0	3.90	5.26	93.0	68.0	5	3.80	5.00
B9524.5	4.5	4.40	5.80	95.0	70.0	5	4.30	5.60
B9525.0	5.0	4.90	6.36	100.0	73.0	5	4.90	6.30
B9525.5	5.5	5.40	7.20	118.0	90.0	6	5.50	7.10
B9526.0	6.0	5.90	8.00	135.0	105.0	6	6.20	8.00
B9526.5	6.5	6.40	8.60	140.0	110.0	6	6.20	8.00
B9527.0	7.0	6.90	9.40	160.0	125.0	6	7.00	9.00
B9528.0	8.0	7.90	10.80	180.0	145.0	6	8.00	10.00
B9529.0	9.0	8.90	12.10	195.0	160.0	6	9.00	11.20
B95210.0	10.0	9.90	13.40	215.0	175.0	6	10.00	12.50
B95212.0	12.0	11.80	16.00	255.0	210.0	8	11.00	14.00
B95213.0	13.0	12.80	17.00	255.0	210.0	8	12.00	16.00
B95214.0	14.0	13.80	18.00	255.0	210.0	8	12.00	16.00
B95216.0	16.0	15.80	20.40	280.0	230.0	8	14.50	18.00
B95220.0	20.0	19.80	24.80	310.0	250.0	8	18.00	22.40
B95225.0	25.0	24.70	30.70	370.0	300.0	10	22.00	28.00
B95230.0	30.0	29.70	36.10	400.0	320.0	10	24.00	31.50
B95240.0	40.0	39.70	46.50	430.0	340.0	12	32.00	40.00
B95250.0	50.0	49.70	56.90	460.0	360.0	12	39.00	50.00



REAMERS FEED RATE CHART

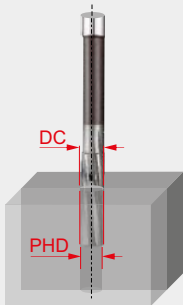


Feed per revolution (f_n in mm/rev)
Depending on the working conditions
it might be necessary to adjust these
values $\pm 15\%$.

How to use this table to find the feed per revolution (f_n):

1. Find your Alpha Code on the product page (example: 21C, "C" is the Alpha Code).
2. Find the closest diameter for your cutting application in the top row of the table.
3. Find your Alpha Code in the left column of the table.
4. The intersection (cell) of the Diameter and Alpha Code is the feed per revolution (f_n).

		\varnothing DC [mm]																		
		1.00	1.50	2.00	3.00	4.00	5.00	6.00	7.00	8.00	10.00	12.00	15.00	16.00	20.00	25.00	30.00	40.00	50.00	80.00
Feed rates	A	0.030	0.045	0.055	0.078	0.090	0.100	0.125	0.137	0.150	0.170	0.185	0.210	0.220	0.250	0.280	0.320	0.390	0.440	0.500
	B	0.035	0.055	0.072	0.110	0.130	0.150	0.165	0.172	0.180	0.210	0.240	0.270	0.280	0.310	0.360	0.400	0.500	0.550	0.600
	C	0.040	0.065	0.085	0.135	0.160	0.185	0.200	0.210	0.220	0.260	0.285	0.325	0.335	0.390	0.440	0.480	0.600	0.680	0.750
	D	0.050	0.080	0.110	0.160	0.180	0.200	0.235	0.253	0.270	0.320	0.360	0.400	0.410	0.470	0.540	0.600	0.730	0.850	0.950
	E	0.065	0.100	0.140	0.180	0.215	0.250	0.300	0.325	0.350	0.390	0.430	0.485	0.500	0.530	0.640	0.750	0.910	1.100	1.200
	F	0.090	0.140	0.180	0.260	0.305	0.350	0.395	0.417	0.440	0.500	0.550	0.610	0.630	0.700	0.800	0.930	1.200	1.500	1.650



Machining allowance when using
a **machine reamer** (MA in mm)
Premachined hole diameter
 $PHD = DC - MA$.

How to use this table to get to the right premachined hole diameter (PHD):

1. Find the diameter range for your cutting application in the top row of the table.
2. Find your ISO Group Code in the left column of the table (example: For Stainless Steel the ISO Group Code is "M")
3. The intersection (cell) of the Diameter Range and ISO Group Code is the Machining Allowance (MA)
4. Subtract the Machining Allowance from the reaming diameter to get to the premachined hole diameter (PHD).

(example: for a 6mm hole in steel (P) the PHD is 5.85mm)

		\varnothing DC [mm]															
		1.00	5.00	5.00	8.00	8.00	12.00	12.00	16.00	16.00	30.00	30.00	80.00				
ISO group	P	0.10			0.15			0.20			0.20			0.30			0.30
	M	0.08			0.10			0.10			0.20			0.20			0.30
	K	0.10			0.15			0.20			0.20			0.30			0.30
	N	0.10			0.15			0.20			0.20			0.30			0.30
	S	0.05			0.10			0.10			0.15			0.20			0.20
	H	0.05			0.05			0.10			0.10			0.15			0.20

Be cautious with the machining tolerances of drills, the tool diameter is not the same as the hole diameter produced!

Note: The recommended allowance when using a hand reamer is 0.05 to 0.10 mm.



WMG (WORK MATERIAL GROUP)

ISO group	WMG (Work Material Group)	Hardness (HB or HRC)	Ultimate Tensile Strength (MPa)			
P	P1	P1.1	Sulfurized	< 240 HB	≤ 830	
		P1.2	Free machining steel	Sulfurized and phosphorized	< 180 HB	≤ 620
		P1.3	(carbon steels with increased machinability)	Sulfurized/phosphorized and leaded	< 180 HB	≤ 620
	P2	P2.1	Plain carbon steel (steels comprised of mainly iron and carbon)	Containing <0.25 % C	< 180 HB	≤ 620
		P2.2		Containing <0.55 % C	< 240 HB	≤ 830
		P2.3		Containing >0.55 % C	< 300 HB	≤ 1030
	P3	P3.1	Alloy steel (carbon steels with an alloying content ≤ 10%)	Annealed	< 180 HB	≤ 620
		P3.2		Hardened and tempered	180 – 260 HB	> 620 ≤ 900
		P3.3			260 – 360 HB	> 900 ≤ 1240
	P4	P4.1	Tool steel (special alloy steel for tools, dies and molds)	Annealed	< 26 HRC	≤ 900
P4.2		Hardened and tempered		26 – 39 HRC	> 900 ≤ 1240	
P4.3				39 – 45 HRC	> 1240 ≤ 1450	
M	M1	M1.1	Ferritic stainless steel (straight chromium non-hardenable alloys)	< 160 HB	≤ 520	
		M1.2		160 – 220 HB	> 520 ≤ 700	
	M2	M2.1	Martensitic stainless steel (straight chromium hardenable alloys)	Annealed	< 200 HB	≤ 670
		M2.2		Quenched and tempered	200 – 280 HB	> 670 ≤ 950
		M2.3		Precipitation-hardened	280 – 380 HB	> 950 ≤ 1300
	M3	M3.1	Austenitic stainless steel (chromium-nickel and chromium-nickel-manganese alloys)	< 200 HB	≤ 750	
		M3.2		200 – 260 HB	> 750 ≤ 870	
		M3.3		260 – 300 HB	> 870 ≤ 1040	
	M4	M4.1	Austenitic-ferritic (DUPLEX) or super-austenitic stainless steel	< 300 HB	≤ 990	
		M4.2		Precipitation hardening austenitic stainless steel	300 – 380 HB	≤ 1320
K	K1	K1.1	Gray iron or Automotive Gray iron (GG) (iron-carbon castings with a lamellar graphite microstructure)	Ferritic or ferritic-pearlitic	< 180 HB	≤ 190
				Ferritic-pearlitic or pearlitic	180 – 240 HB	> 190 ≤ 310
				Pearlitic	240 – 280 HB	> 310 ≤ 390
	K2	K2.1	Malleable iron (GTS/GTW) (iron-carbon castings with a graphite-free microstructure)	Ferritic	< 160 HB	≤ 400
				Ferritic or pearlitic	160 – 200 HB	> 400 ≤ 550
				Pearlitic	200 – 240 HB	> 550 ≤ 660
	K3	K3.1	Ductile iron (GGG) (iron-carbon castings with a nodular graphite microstructure)	Ferritic	< 180 HB	≤ 560
				Ferritic or pearlitic	180 – 220 HB	> 560 ≤ 680
				Pearlitic	220 – 260 HB	> 680 ≤ 800
	K4	K4.1	Austenitic gray iron (ASTM A436) (iron-carbon alloy castings with an austenitic lamellar graphite microstructure)	< 180 HB	≤ 190	
				< 240 HB	≤ 740	
		K4.2	Austenitic ductile iron (ASTM A439 or ASTM A571) (iron-carbon alloy castings with an austenitic nodular graphite microstructure)	< 280 HB	> 840 ≤ 980	
				280 – 320 HB	> 980 ≤ 1130	
				320 – 360 HB	> 1130 ≤ 1280	
	K5	K4.3	Austempered ductile iron (ASTM A897) (iron-carbon alloy castings with an ausferrite microstructure)	< 180 HB	≤ 400	
180 – 220 HB				> 400 ≤ 450		
220 – 260 HB				> 450 ≤ 500		
K5.1	K5.2	Compacted graphite iron CGI (ASTM A842) (iron-carbon castings with a vermicular graphite structure)	Ferritic	< 180 HB	≤ 400	
			Ferritic-pearlitic	180 – 220 HB	> 400 ≤ 450	
			Pearlitic	220 – 260 HB	> 450 ≤ 500	
N	N1	N1.1	Commercially pure wrought aluminium	< 60 HB	≤ 240	
				60 – 100 HB	> 240 ≤ 400	
				100 – 150 HB	> 400 ≤ 590	
	N2	N1.2	Wrought aluminium alloys	Half hard tempered	< 75 HB	≤ 240
				Full hard tempered	75 – 90 HB	> 240 ≤ 270
				90 – 140 HB	> 270 ≤ 440	
	N3	N2.1	Cast aluminium alloys	–	–	
				–	–	
				–	–	
	N4	N3.1	Free-cutting copper-alloys materials with excellent machining properties	–	–	
				–	–	
				–	–	
	N5	N3.2	Short-chip copper-alloys with good to moderate machining properties	–	–	
				–	–	
				–	–	
N6	N3.3	Electrolytic copper and long-chip copper-alloys with moderate to poor machining properties	–	–		
			–	–		
			–	–		
N7	N4.1	Thermoplastic polymers	–	–		
			–	–		
			–	–		
N8	N4.2	Thermosetting polymers	–	–		
			–	–		
			–	–		
N9	N4.3	Reinforced polymers or composites	–	–		
			–	–		
			–	–		
S1	N5.1	Graphite	–	–		
			–	–		
			–	–		
S	S1	S1.1	Titanium or titanium alloys	< 200 HB	≤ 660	
				200 – 280 HB	> 660 ≤ 950	
				280 – 360 HB	> 950 ≤ 1200	
	S2	S1.2	Fe-based high-temperature alloys	< 200 HB	≤ 690	
				200 – 280 HB	> 690 ≤ 970	
	S3	S1.3	Ni-based high-temperature alloys	< 280 HB	≤ 940	
280 – 360 HB				> 940 ≤ 1200		
S4	S2.1	Co-based high-temperature alloys	< 240 HB	≤ 800		
			240 – 320 HB	> 800 ≤ 1070		
H	H1	H1.1	Chilled cast iron	< 440 HB	–	
				< 55 HRC	–	
	H2	H2.1	Hardened cast iron	> 55 HRC	–	
				< 51 HRC	–	
	H3	H3.1	Hardened steel <55 HRC	51 – 55 HRC	–	
				55 – 59 HRC	–	
	H4	H4.1	Hardened steel >55 HRC	> 59 HRC	–	
				–	–	