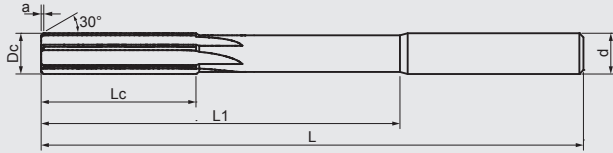


NC Machine Reamers

Designed with straight flute and right cutting flute. 直刃右切刃設計。
 Applicable to blind hole reaming. 可適用盲孔鉸孔加工。
 Application for reaming different steels below 48HRC, stainless steel, cast iron, aluminium, copper...and etc. 適用切削於48HRC以下各種鋼鐵，不銹鋼及鑄鐵、鋁合金、銅...等材料鉸孔應用。
 Accuracy tolerance: H7 (m5) 刃徑精度公差：H7 (m5)
 0/+0.004mm 0/+0.004mm



VHM Carbide **Uncoated Bright** **0°** **Z** **Steel Cast Iron Stainless Steel AL, Copper** **Through Hole** **Blind Hole**



孔徑配合尺寸容許範圍與鉸刀直徑公差範圍規範

尺寸區分(mm)	鉸刀直徑公差(mm)		孔的公差(mm)		研磨鉸刀直徑公差(mm)				
	以上	以下	m5(JIS)	H7(DIN 1420)	H7	H8	下限	中間值	上限
-	3		+0.002/+0.006	+0.004/+0.008	0/+0.010	0/+0.014	+0.004	+0.005	+0.006
3	6		+0.004/+0.009	+0.005/+0.010	0/+0.012	0/+0.018	+0.005	+0.007	+0.009
6	10		+0.006/+0.012	+0.006/+0.012	0/+0.015	0/+0.022	+0.007	+0.009	+0.011
10	18		+0.007/+0.015	+0.008/+0.015	0/+0.018	0/+0.027	+0.009	+0.011	+0.013
18	30		+0.008/+0.017	+0.009/+0.017	0/+0.021	0/+0.033	+0.011	+0.013	+0.015

- P
- H
- M
- K
- N

Standard Length (Dc=d) Code No. R307-Dc

Dc mm	Tolerance mm	Lc mm	L1 mm	L mm	a mm	Z teeth	R307 Bright
0.98	0/+0.004	6	15	34	0.2	4	•
0.99	0/+0.004	6	15	34	0.2	4	•
1	H7	6	15	34	0.2	4	•
1.01	0/+0.004	6	15	34	0.2	4	•
1.02	0/+0.004	6	15	34	0.2	4	•
1.03	0/+0.004	6	15	34	0.2	4	•
1.1	H7	7	16	36	0.2	4	•
1.2	H7	7	16	36	0.2	4	•
1.3	H7	7	16	36	0.2	4	•
1.4	H7	8	18	40	0.2	4	•
1.48	0/+0.004	8	18	40	0.2	4	•
1.49	0/+0.004	8	18	40	0.2	4	•
1.5	H7	8	18	40	0.2	4	•
1.51	0/+0.004	8	18	40	0.2	4	•
1.52	0/+0.004	8	18	40	0.2	4	•
1.53	0/+0.004	8	18	40	0.2	4	•
1.6	H7	9	20	43	0.3	4	•
1.7	H7	9	20	43	0.3	4	•
1.8	H7	10	22	46	0.3	4	•
1.9	H7	10	22	46	0.3	4	•
1.98	0/+0.004	11	24	49	0.3	4	•
1.99	0/+0.004	11	24	49	0.3	4	•
2	H7	11	24	49	0.3	4	•
2.01	0/+0.004	11	24	49	0.3	4	•
2.02	0/+0.004	11	24	49	0.3	4	•
2.03	0/+0.004	11	24	49	0.3	4	•
2.1	H7	11	24	49	0.3	4	•
2.2	H7	12	25	53	0.3	4	•
2.3	H7	12	25	53	0.3	4	•
2.4	H7	14	29	57	0.3	4	•
2.48	0/+0.004	14	29	57	0.3	4	•
2.49	0/+0.004	14	29	57	0.3	4	•
2.5	H7	14	29	57	0.3	4	•
2.51	0/+0.004	14	29	57	0.3	4	•
2.52	0/+0.004	14	29	57	0.3	4	•
2.53	0/+0.004	14	29	57	0.3	4	•

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鑽頭

鉸刀

技術資料

Dc mm	Tolerance mm	Lc mm	L1 mm	L mm	a mm	Z teeth	R307 Bright		
2.6	H7	14	29	57	0.3	4	●		
2.7	H7	15	33	61	0.3	4	●		
2.8	H7	15	33	61	0.3	4	●		
2.9	H7	15	36	61	0.3	4	●		
2.95	0/+0.004	15	36	61	0.4	4	●		
2.96	0/+0.004	15	36	61	0.4	4	●		
2.97	0/+0.004	15	36	61	0.4	4	●		
2.98	0/+0.004	15	36	61	0.4	4	●		
2.99	0/+0.004	15	36	61	0.4	4	●		
3	H7	15	36	61	0.4	4	●		
3.01	0/+0.004	15	36	61	0.4	4	●		
3.02	0/+0.004	15	36	61	0.4	4	●		
3.03	0/+0.004	15	36	61	0.4	4	●		
3.04	0/+0.004	15	36	61	0.4	4	●		
3.05	0/+0.004	15	36	61	0.4	4	●		
3.1	H7	16	36	65	0.4	4	●		
3.2	H7	16	36	65	0.4	4	●		
3.3	H7	16	36	65	0.4	4	●		
3.4	H7	18	41	70	0.4	4	●		
3.5	H7	18	41	70	0.4	4	●		
3.6	H7	18	41	70	0.5	4	●		
3.7	H7	18	41	70	0.5	4	●		
3.8	H7	19	44	75	0.5	4	●		
3.9	H7	19	44	75	0.5	4	●		
3.95	0/+0.004	19	44	75	0.5	4	●		
3.96	0/+0.004	19	44	75	0.5	4	●		
3.97	0/+0.004	19	44	75	0.5	4	●		
3.98	0/+0.004	19	44	75	0.5	4	●		
3.99	0/+0.004	19	44	75	0.5	4	●		
4	H7	19	44	75	0.5	4	●		
4.01	0/+0.004	19	44	75	0.5	4	●		
4.02	0/+0.004	19	44	75	0.5	4	●		
4.03	0/+0.004	19	44	75	0.5	4	●		
4.04	0/+0.004	19	44	75	0.5	4	●		
4.05	0/+0.004	19	44	75	0.5	4	●		
4.1	H7	19	44	75	0.5	4	●		
4.2	H7	19	44	75	0.5	4	●		
4.3	H7	21	48	80	0.5	4	●		
4.4	H7	21	48	80	0.5	4	●		
4.5	H7	21	48	80	0.5	4	●		
4.6	H7	21	48	80	0.6	6	●		
4.7	H7	21	48	80	0.6	6	●		
4.8	H7	23	53	86	0.6	6	●		
4.9	H7	23	53	86	0.6	6	●		
4.95	0/+0.004	23	53	86	0.6	6	●		
4.96	0/+0.004	23	53	86	0.6	6	●		
4.97	0/+0.004	23	53	86	0.6	6	●		
4.98	0/+0.004	23	53	86	0.6	6	●		
4.99	0/+0.004	23	53	86	0.6	6	●		
5	H7	23	53	86	0.6	6	●		
5.01	0/+0.004	23	53	86	0.6	6	●		
5.02	0/+0.004	23	53	86	0.6	6	●		
5.03	0/+0.004	23	53	86	0.6	6	●		
5.04	0/+0.004	23	53	86	0.6	6	●		
5.05	0/+0.004	23	53	86	0.6	6	●		
5.1	H7	23	53	86	0.6	6	●		
5.2	H7	23	53	86	0.6	6	●		
5.3	H7	23	53	86	0.6	6	●		
5.4	H7	26	58	93	0.6	6	●		
5.5	H7	26	58	93	0.6	6	●		
5.6	H7	26	58	93	0.6	6	●		
5.7	H7	26	58	93	0.6	6	●		
5.8	H7	26	58	93	0.6	6	●		
5.9	H7	26	58	93	0.6	6	●		

NC Machine Reamers

Dc mm	Tolerance mm	Lc mm	L1 mm	L mm	a mm	Z teeth	R307 Bright		
5.95	0/+0.004	26	58	93	0.6	6	●		
5.96	0/+0.004	26	58	93	0.6	6	●		
5.97	0/+0.004	26	58	93	0.6	6	●		
5.98	0/+0.004	26	58	93	0.6	6	●		
5.99	0/+0.004	26	58	93	0.6	6	●		
6	H7	26	58	93	0.6	6	●		
6.01	0/+0.004	26	58	93	0.6	6	●		
6.02	0/+0.004	26	58	93	0.6	6	●		
6.03	0/+0.004	26	58	93	0.6	6	●		
6.04	0/+0.004	26	58	93	0.6	6	●		
6.05	0/+0.004	26	58	93	0.6	6	●		
6.1	H7	28	64	101	0.8	6	●		
6.2	H7	28	64	101	0.8	6	●		
6.3	H7	28	64	101	0.8	6	●		
6.4	H7	28	64	101	0.8	6	●		
6.5	H7	28	64	101	0.8	6	●		
6.6	H7	28	64	101	0.8	6	●		
6.7	H7	28	64	101	0.8	6	●		
6.8	H7	31	70	109	0.8	6	●		
6.9	H7	31	70	109	0.8	6	●		
6.95	0/+0.004	31	70	109	0.8	6	●		
6.96	0/+0.004	31	70	109	0.8	6	●		
6.97	0/+0.004	31	70	109	0.8	6	●		
6.98	0/+0.004	31	70	109	0.8	6	●		
6.99	0/+0.004	31	70	109	0.8	6	●		
7	H7	31	70	109	0.8	6	●		
7.01	0/+0.004	31	70	109	0.8	6	●		
7.02	0/+0.004	31	70	109	0.8	6	●		
7.03	0/+0.004	31	70	109	0.8	6	●		
7.04	0/+0.004	31	70	109	0.8	6	●		
7.05	0/+0.004	31	70	109	0.8	6	●		
7.1	H7	31	70	109	0.8	6	●		
7.2	H7	31	70	109	0.8	6	●		
7.3	H7	31	70	109	0.8	6	●		
7.4	H7	31	70	109	0.8	6	●		
7.5	H7	31	70	109	0.8	6	●		
7.6	H7	33	76	117	0.8	6	●		
7.7	H7	33	76	117	0.8	6	●		
7.8	H7	33	76	117	0.8	6	●		
7.9	H7	33	76	117	0.8	6	●		
7.95	0/+0.004	33	76	117	0.8	6	●		
7.96	0/+0.004	33	76	117	0.8	6	●		
7.97	0/+0.004	33	76	117	0.8	6	●		
7.98	0/+0.004	33	76	117	0.8	6	●		
7.99	0/+0.004	33	76	117	0.8	6	●		
8	H7	33	76	117	0.8	6	●		
8.01	0/+0.004	33	76	117	0.8	6	●		
8.02	0/+0.004	33	76	117	0.8	6	●		
8.03	0/+0.004	33	76	117	0.8	6	●		
8.04	0/+0.004	33	76	117	0.8	6	●		
8.05	0/+0.004	33	76	117	0.8	6	●		
8.1	H7	33	76	117	1.0	6	●		
8.2	H7	33	76	117	1.0	6	●		
8.3	H7	33	76	117	1.0	6	●		
8.4	H7	33	76	117	1.0	6	●		
8.5	H7	33	76	117	1.0	6	●		
8.6	H7	36	82	125	1.0	6	●		
8.7	H7	36	82	125	1.0	6	●		
8.8	H7	36	82	125	1.0	6	●		
8.9	H7	36	82	125	1.0	6	●		
8.95	0/+0.004	36	82	125	1.0	6	●		
8.96	0/+0.004	36	82	125	1.0	6	●		
8.97	0/+0.004	36	82	125	1.0	6	●		
8.98	0/+0.004	36	82	125	1.0	6	●		

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NC Machine Reamers

Dc mm	Tolerance mm	Lc mm	L1 mm	L mm	a mm	Z teeth	R307 Bright		
8.99	0/+0.004	36	82	125	1.0	6	●		
9	H7	36	82	125	1.0	6	●		
9.01	0/+0.004	36	82	125	1.0	6	●		
9.02	0/+0.004	36	82	125	1.0	6	●		
9.03	0/+0.004	36	82	125	1.0	6	●		
9.04	0/+0.004	36	82	125	1.0	6	●		
9.05	0/+0.004	36	82	125	1.0	6	●		
9.1	H7	36	82	125	1.0	6	●		
9.2	H7	36	82	125	1.0	6	●		
9.3	H7	36	82	125	1.0	6	●		
9.4	H7	36	82	125	1.0	6	●		
9.5	H7	36	82	125	1.0	6	●		
9.6	H7	38	88	133	1.0	6	●		
9.7	H7	38	88	133	1.0	6	●		
9.8	H7	38	88	133	1.0	6	●		
9.9	H7	38	88	133	1.0	6	●		
9.95	0/+0.004	38	88	133	1.0	6	●		
9.96	0/+0.004	38	88	133	1.0	6	●		
9.97	0/+0.004	38	88	133	1.0	6	●		
9.98	0/+0.004	38	88	133	1.0	6	●		
9.99	0/+0.004	38	88	133	1.0	6	●		
10	H7	38	88	133	1.0	6	●		
10.01	0/+0.004	38	88	133	1.0	6	●		
10.02	0/+0.004	38	88	133	1.0	6	●		
10.03	0/+0.004	38	88	133	1.0	6	●		
10.04	0/+0.004	38	88	133	1.0	6	●		
10.05	0/+0.004	38	88	133	1.0	6	●		
10.1	H7	38	88	133	1.2	6	●		
10.2	H7	38	88	133	1.2	6	●		
10.3	H7	38	88	133	1.2	6	●		
10.4	H7	38	88	133	1.2	6	●		
10.5	H7	38	88	133	1.2	6	●		
10.6	H7	38	88	133	1.2	6	●		
10.7	H7	41	97	142	1.2	6	●		
10.8	H7	41	97	142	1.2	6	●		
10.9	H7	41	97	142	1.2	6	●		
11	H7	41	97	142	1.2	6	●		
11.1	H7	41	97	142	1.2	6	●		
11.2	H7	41	97	142	1.2	6	●		
11.3	H7	41	97	142	1.2	6	●		
11.4	H7	41	97	142	1.2	6	●		
11.5	H7	41	97	142	1.2	6	●		
11.6	H7	41	97	142	1.2	6	●		
11.7	H7	41	97	142	1.2	6	●		
11.8	H7	41	97	142	1.2	6	●		
11.9	H7	44	106	151	1.2	6	●		
11.95	0/+0.004	44	106	151	1.2	6	●		
11.96	0/+0.004	44	106	151	1.2	6	●		
11.97	0/+0.004	44	106	151	1.2	6	●		
11.98	0/+0.004	44	106	151	1.2	6	●		
11.99	0/+0.004	44	106	151	1.2	6	●		
12	H7	44	106	151	1.2	6	●		
12.01	0/+0.004	44	106	151	1.2	6	●		
12.02	0/+0.004	44	106	151	1.2	6	●		
12.03	0/+0.004	44	106	151	1.2	6	●		
12.04	0/+0.004	44	106	151	1.2	6	●		
12.05	0/+0.004	44	106	151	1.2	6	●		

切削條件參考表請參照P31頁

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