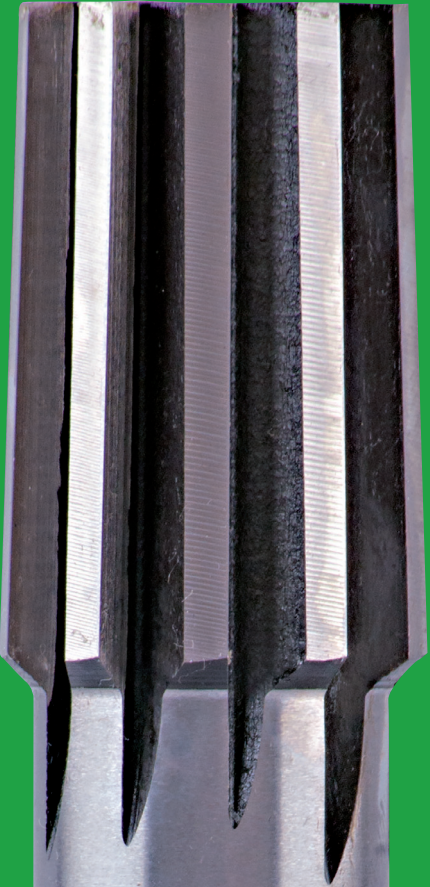
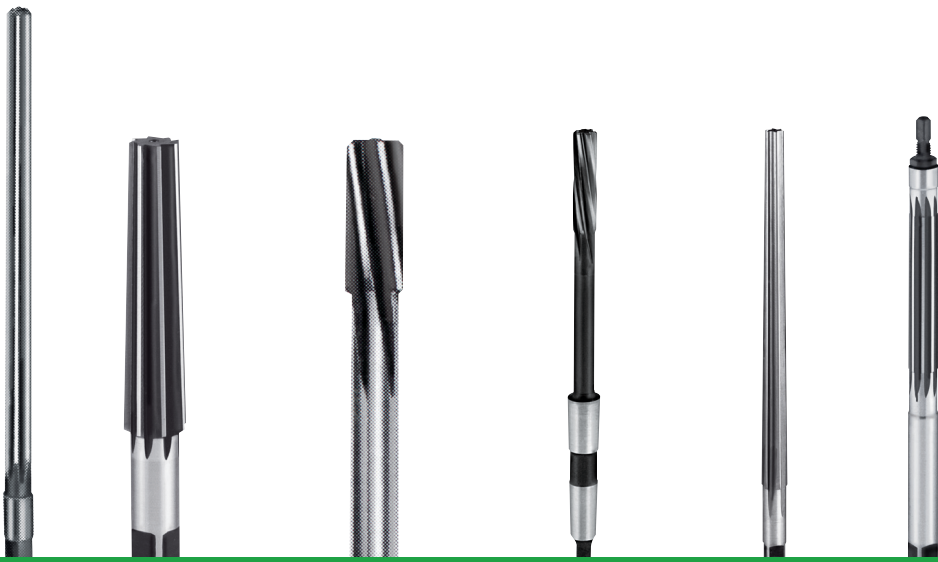


# Reibahlen

## Reamers







## Reamers

### ► Zeichenerklärung

Key to symbols

#### SCHNEIDSTOFF / TOOL MATERIAL



**HSS**



**HSS-CO**



**PKD**



**CERMET**



**K 10/20**

Metallo duro / Micrograna  
Solid carbide / Micro grain

#### BESCHICHTUNG / COATING



**TN**

TiN





► **Werkzeug-Auswahlhilfe**  
Tool selection guide







## HAND - REIBAHLEN / HAND REAMERS

KAT.-NR. ITEM	DIN	FORM FORM	Ø mm	TOLERANZ TOLERANCE	SCHAFT SHANK	KÜHLUNG INTERNAL COOLANT
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**REIBAHLEN** ■ Gerade genutet und 7-8° linksdrall - straight and 7-8° Helix

<b>6301</b> 	206	A	1,0 ÷ 50,0	H7		-
<b>6302</b> 	206	B	1,0 ÷ 50,0	H7		-


**REIBAHLEN** ■ Nachstellbar – Nachstellbereich max. 1 % über dem Nenndurchmesser

<b>6306</b> 	859	A	4,0 ÷ 30,0	-		-
<b>6309</b> 	859	B	8,0 ÷ 30,0	-		-

**REIBAHLEN** ■ Hand-Kegelreibahlen – Kegel 1 : 50 - Hand taper pin reamers, taper 1 : 50

<b>6315</b> 	9	A	0,8 ÷ 30,0	-		-
<b>6304</b> 	9	B	1,5 ÷ 50,0	-		-

**REIBAHLEN** ■ Hand-Kegelreibahlen für Morsekegel nach DIN 228 - taper socket

<b>6317</b> 	204	C	MK/MT 0 ÷ MK/MT 6	-		-
<b>6312</b> 	204	-	MK/MT 0 ÷ MK/MT 6	-		-



## HAND - REIBAHLEN / HAND REAMERS

BESCHICHTUNG COATING	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
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-		HSS	●	●	●	●	-	-	670
-		HSS	●	●	●	●	-	-	670

- Adjustable range of expansion max. 1 % Over nominal size

-		HSS	●	●	●	●	-	-	673
-		HSS	●	●	●	●	-	-	673
-		HSS	●	●	●	●	-	-	695
-		HSS	●	●	●	●	-	-	695

reamer – finishing for taper sleeves acc. To Din 228



-		HSS	●	●	●	●	-	-	702
-		HSS	●	●	●	●	-	-	702





MASCHINEN - REIBAHLEN / MACHINE CHUCKING REAMERS



KAT.-NR. ITEM	DIN	FORM FORM	Ø mm	TOLERANZ TOLERANCE	SCHAFT SHANK	KÜHLUNG INTERNAL COOLANT
------------------	-----	--------------	---------	-----------------------	-----------------	-----------------------------


**REIBAHLEN** ■ Kurz für automaten – 7-8° linksdrall - short for automatic machines

<b>6324</b> 	8089	B/D	1,5 ÷ 20,0	H7		-
--	------	-----	------------------	----	---	---



**REIBAHLEN** ■ Gerade genutet - straight flutes



<b>6321</b> 	212	A/C	1,5 ÷ 20,0	H7		-
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
<b>6333</b> 	208	A	5,0 ÷ 32,0	H7		-
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<b>6361</b> 	219	A	25,0 ÷ 100,0	H7	-	-
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**REIBAHLEN** ■ 7 – 8° Linksdrall (1/100 Abstufung ) - Helix 7-8° (progression of 0,01 mm)

<b>6326</b> 	212	B/D	1,0 ÷ 20,0	H7		-
--	-----	-----	------------------	----	---	---

<b>6326C</b> 	212	B/D	0,95 ÷ 16,10	-		-
---	-----	-----	--------------------	---	---	---

<b>6337</b> 	208	B	5,0 ÷ 40,0	H7		-
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<b>6360</b> 	219	B	25,0 ÷ 100,0	H7	-	-
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## MASCHINEN - REIBAHLEN / MACHINE CHUCKING REAMERS

BESCHICHTUNG  
COATING

SCHNEIDRICHTUNG  
CUTTING DIRECT.

SCHNEIDSTOFF  
TOOL MATERIAL

P

M

K

N

S

H






Seite  
Page

- 7-8° Helix



BESCHICHTUNG COATING	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
-		HSS-CO	●	●	●	●	●	-	674
-		HSS-CO	●	●	●	●	●	-	675
-		HSS-CO	●	●	●	●	●	-	688
-		HSS	●	●	●	●	●	-	693
TN		HSS-CO	●	●	●	●	●	-	675
-		HSS-CO	●	●	●	●	●	-	683
-		HSS-CO	●	●	●	●	●	-	688
-		HSS	●	●	●	●	●	-	693







MASCHINEN - REIBAHLEN / MACHINE CHUCKING REAMERS

KAT.-NR. ITEM	DIN	FORM FORM	Ø mm	TOLERANZ TOLERANCE	SCHAFT SHANK	KÜHLUNG INTERNAL COOLANT
<b>6325</b> 	212	E	1,0 ÷ 20,0	H7		-
<b>6335</b> 	208	C	5,0 ÷ 32,0	H7		-
<b>6362</b> 	219	C	25,0 ÷ 100,0	H7	-	-

**REIBAHLEN** ■ Spreizreibahlen für Fertigungs und Reparaturarbeiten zum Erreichen  
applications to obtain narrower tolerances)

<b>6307</b> 	ILIX NORM	-	8,0 ÷ 20,0	-		-
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**REIBAHLEN** ■ Kegel-schälreibahlen - kegel 1 : 50 - Taper pin reamers - taper 1:50

<b>6313</b> 	2179		1,0 ÷ 12,0	-		-
<b>6314</b> 	2180		5,0 ÷ 20,0	-		-

**HSS**

MASCHINEN KEGEL REIBAHLEN / MACHINE TAPER REAMERS

**REIBAHLEN**

<b>6308</b> 	ILIX NORM	-	3,0 ÷ 45,0	-		-
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MASCHINEN - REIBAHLEN / MACHINE CHUCKING REAMERS

BESCHICHTUNG COATING	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
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-		HSS-CO	●	●	●	●	●	-	675
-		HSS-CO	●	●	●	●	●	-	688
-		HSS	●	●	●	●	●	-	693

von engeren Toleranzen - Taper shank expansion reamers for maintenance and rework

-		HSS-CO	●	●	●	●	-	-	692
-		HSS	●	●	●	●	-	-	697
-		HSS	●	●	●	●	-	-	698

**HSS**

MASCHINEN KEGEL REIBAHLEN / MACHINE TAPER REAMERS





-		HSS	●	●	●	●	-	-	701
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## MASCHINEN KEGEL REIBAHLEN / MACHINE TAPER REAMERS

KAT.-NR. ITEM	DIN	FORM FORM	Ø mm	TOLERANZ TOLERANCE	SCHAFT SHANK	KÜHLUNG INTERNAL COOLANT
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**REIBAHLEN** ■ Kegeltreibahle für NPT/NPTF Gewinde - Taper pin reamer for

<b>6310</b> 	ILIX NORM	-	1/16" ÷ 2"	-		-
<b>6311</b> 	ILIX NORM	-	1/16" ÷ 2"	-		-





**REIBAHLEN** ■ Kegel-Schälreibahlen (nf: französische norm) – Kegel 1 : 50 -

<b>6319</b> 	E 60-011	NF	1,00 ÷ 4,5	-		-
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**REIBAHLEN** ■ Nietloch-Reibahlen mit Morsekegel - Bridge reamers with morse taper

<b>6355</b> 	331	-	6,4 ÷ 32,0	-		-
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**REIBAHLEN** ■ Kegel-Reibahlen, Kegel 1 : 100 (Kleinstreibahlen mit 3 Schneiden Kat.

<b>6318</b> 	ILIX NORM	-	1,2 ÷ 1,9	-		-
<b>6303</b> 	ILIX NORM	-	1,5 ÷ 20,0	-		-

**VHM / SOLID CARBIDE**  
MASCHINEN - REIBAHLEN / MACHINE TAPER**REIBAHLEN** ■ Vollhartmetall-Reibahlen Hartmetall K 10 / 20 - solid carbide machine

<b>6369</b> 	ILIX NORM	-	5,0 ÷ 20,0	H7		-
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\* Bis zu 20 mm Durchmesser aus Vollhartmetall, über Hartmetall bestückt / up to Ø 20 mm made of solid carbide, above carbide tipped



## MASCHINEN KEGEL REIBAHLEN / MACHINE TAPER REAMERS

BESCHICHTUNG  
COATING

SCHNEIDRICHTUNG  
CUTTING DIRECT.

SCHNEIDSTOFF  
TOOL MATERIAL

P

M

K

N

S

H

Seite  
Page

NPT/NPTF thread

-		HSS	●	●	●	●	-	-	699
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-		HSS	●	●	●	●	-	-	700
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Taper pin reamers (inf: french standard) – taper 1 : 50

-		HSS	●	●	●	●	-	-	696
---	--	-----	---	---	---	---	---	---	-----

-		HSS	●	●	●	●	-	-	703
---	--	-----	---	---	---	---	---	---	-----

**-Nr.6318)** - Taper pin reamers, taper 1 : 100 (3 fluted micro reamers, cat.-No.6318)

-		HSS	●	●	●	●	-	-	694
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-		HSS	●	●	●	●	-	-	694
---	--	-----	---	---	---	---	---	---	-----

## VHM / SOLID CARBIDE

### MASCHINEN - REIBAHLEN / MACHINE TAPER

reamers\* - carbide grade k 10/20

-		VHM	●	●	●	●	●	-	690
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## MASCHINEN - REIBAHLEN / MACHINE TAPER

KAT.-NR. ITEM	DIN	FORM FORM	Ø mm	TOLERANZ TOLERANCE	SCHAFT SHANK	KÜHLUNG INTERNAL COOLANT
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### REIBAHLEN ■ VHM\*\*- solid carbide machine reamers\*\*

<b>6372</b> 	ILIX NORM	-	1,0 ÷ 20,0	H7		-
<b>6372C</b> 	ILIX NORM	-	0,98 ÷ 12,05	-		-
<b>6370</b> 	ILIX NORM	-	4,0 ÷ 20,0	H7		
<b>6371</b> 	ILIX NORM	-	4,0 ÷ 20,0	H7		
<b>6376</b> 	ILIX NORM	-	5,0 ÷ 20,0	H7		-

### REIBAHLEN ■ in Cermet - Cermet

<b>6323</b> 	ILIX NORM	-	3,5 ÷ 20,00	H7		-
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### REIBAHLEN ■ in PKD - PKD

<b>6373</b> 	ILIX NORM	-	6,0 ÷ 20,00	H7		
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\*\* Bis zu 12.20 mm Durchmesser aus Vollhartmetall, über Hartmetall bestück / up to Ø 12,20 mm made of solid carbide, above carbide tipped



## MASCHINEN - REIBAHLEN / MACHINE TAPER

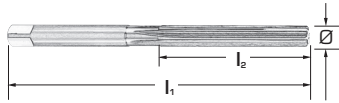
BESCHICHTUNG COATING	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
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TN		VHM	●	●	●	●	-	-	679
-		VHM	●	●	●	●	-	-	684
-		VHM	●	●	●	●	-	-	681
-		VHM	●	●	●	●	-	-	682
-		VHM	●	●	●	●	-	-	691
-		CERMET	●	●	●	●	-	-	686
-		PKD	-	-	-	●	-	-	687



## Hand-Reibahlen aus HSS für Bohrungen mit Passung H7

Hand reamers made of HSS  
to produce holes with H7 tolerances



Form / Form			A	B
Typ / Type			Schneiden gerade straight	Schneiden 7/8° LH
Schneidrichtung Cutting direction				
Schneidstoff Material			HSS	HSS
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	6301	6302
1,0**	37	12	●	●
1,1**	40	15	●	●
1,2**	40	15	●	●
1,3**	40	15	●	●
1,4	41	20	●	●
1,5	41	20	●	●
1,6	44	21	●	●
1,7	44	21	●	●
1,8	47	23	●	●
1,9	47	23	●	●
2,0	50	25	●	●
2,1	50	25	●	●
2,2	54	27	●	●
2,3	54	27	●	●
2,4	58	29	●	●
2,5	58	29	●	●
2,6	58	29	●	●
2,7	62	31	●	●
2,8	62	31	●	●
2,9	62	31	●	●
3,0	62	31	●	●
3,1	66	33	●	●
3,2	66	33	●	●
3,3	66	33	●	●
3,4	71	35	●	●
3,5	71	35	●	●
3,6	71	35	●	●
3,7	71	35	●	●
3,8	76	38	●	●
3,9	76	38	●	●
4,0	76	38	●	●
4,1	76	38	●	●
4,2	76	38	●	●
4,3	81	41	●	●
4,4	81	41	●	●
4,5	81	41	●	●
4,6	81	41	●	●
4,7	81	41	●	●

Form / Form			A	B
Typ / Type			Schneiden gerade straight	Schneiden 7/8° LH
Schneidrichtung Cutting direction				
Schneidstoff Material			HSS	HSS
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	6301	6302
4,8	87	44	●	●
4,9	87	44	●	●
5,0	87	44	●	●
5,1	87	44	●	●
5,2	87	44	●	●
5,3	87	44	●	●
5,4	93	47	●	●
5,5	93	47	●	●
5,6	93	47	●	●
5,7	93	47	●	●
5,8	93	47	●	●
5,9	93	47	●	●
6,0	93	47	●	●
6,1	100	50	●	●
6,2	100	50	●	●
6,3	100	50	●	●
6,4	100	50	●	●
6,5	100	50	●	●
6,6	100	50	●	●
6,7	100	50	●	●
6,8	107	54	●	●
6,9	107	54	●	●
7,0	107	54	●	●
7,1	107	54	●	●
7,2	107	54	●	●
7,3	107	54	●	●
7,4	107	54	●	●
7,5	107	54	●	●
7,6	115	58	●	●
7,7	115	58	●	●
7,8	115	58	●	●
7,9	115	58	●	●
8,0	115	58	●	●
8,1	115	58	●	●
8,2	115	58	●	●
8,3	115	58	●	●
8,4	115	58	●	●
8,5	115	58	●	●

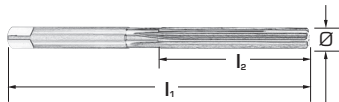
\*\*ILIX Norm

● Standardartikel / Items available ex stock



## Hand-Reibahlen aus HSS für Bohrungen mit Passung H7

Hand reamers made of HSS  
to produce holes with H7 tolerances



Form / Form			A	B
Typ / Type			Schneiden gerade straight	Schneiden 7/8° LH
Schneidrichtung Cutting direction				
Schneidstoff Material			HSS	HSS
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	6301	6302
8,6	124	62	●	●
8,7	124	62	●	●
8,8	124	62	●	●
8,9	124	62	●	●
9,0	124	62	●	●
9,1	124	62	●	●
9,2	124	62	●	●
9,3	124	62	●	●
9,4	124	62	●	●
9,5	124	62	●	●
9,6	133	66	●	●
9,7	133	66	●	●
9,8	133	66	●	●
9,9	133	66	●	●
10,0	133	66	●	●
10,1	133	66	●	-
10,2	133	66	●	-
10,3	133	66	●	-
10,4	133	66	●	-
10,5	133	66	●	●
10,6	133	66	●	-
10,7	142	71	●	-
10,8	142	71	●	-
10,9	142	71	●	-
11,0	142	71	●	●
11,1	142	71	●	-
11,2	142	71	●	-
11,3	142	71	●	-
11,4	142	71	●	-
11,5	142	71	●	●
11,6	142	71	●	-
11,7	142	71	●	-
11,8	142	71	●	-
11,9	152	76	●	-
12,0	152	76	●	●
12,5	152	76	●	-
13,0	152	76	●	-
13,5	163	81	●	-

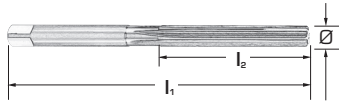
Form / Form			A	B
Typ / Type			Schneiden gerade straight	Schneiden 7/8° LH
Schneidrichtung Cutting direction				
Schneidstoff Material			HSS	HSS
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	6301	6302
14,0	163	81	●	●
14,5	163	81	●	●
15,0	163	81	●	●
15,5	175	87	●	●
16,0	175	87	●	●
16,5	175	87	●	●
17,0	175	87	●	●
17,5	188	93	●	●
18,0	188	93	●	●
18,5	188	93	●	●
19,0	188	93	●	●
19,5	201	100	●	●
20,0	201	100	●	●
20,5	201	100	●	●
21,0	201	100	●	●
21,5	201	100	●	●
22,0	215	107	●	●
22,5	215	107	●	●
23,0	215	107	●	●
23,5	215	107	●	●
24,0	231	115	●	●
24,5	231	115	-	●
25,0	231	115	●	●
25,5	231	115	●	●
26,0	231	115	●	●
26,5	231	115	●	●
27,0	247	124	●	●
27,5	247	124	-	●
28,0	247	124	●	●
28,5	247	124	●	●
29,0	247	124	●	●
29,5	247	124	●	●
30,0	247	124	●	■
31,0	265	133	●	●
32,0	265	133	●	●
33,0	265	133	●	●
34,0	284	142	●	●
35,0	284	142	●	●

● Standardartikel / Items available ex stock ■ Auslaufender Artikel / discontinued items



## Hand-Reibahlen aus HSS für Bohrungen mit Passung H7

Hand reamers made of HSS  
to produce holes with H7 tolerances



Form / Form			A	B
Typ / Type			Schneiden gerade straight	Schneiden 7/8° LH
Schneidrichtung Cutting direction				
Schneidstoff Material			HSS	HSS
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	6301	6302
36,0	284	142	●	●
37,0	284	142	●	●
38,0	305	152	●	●
39,0	305	152	●	●
40,0	305	152	●	●
41,0	305	152	●	●
42,0	305	152	●	●
43,0	326	163	●	●
44,0	326	163	●	●
45,0	326	163	●	●
46,0	326	163	●	●
47,0	326	163	●	●
48,0	347	174	●	●
49,0	347	174	●	●
50,0	347	174	●	●

Form / Form			A	B
Typ / Type			Schneiden gerade straight	Schneiden 7/8° LH
Schneidrichtung Cutting direction				
Schneidstoff Material			HSS	HSS
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	6301	6302

Durchmesser Diameter range	6301 Anzahl der Schneiden No. of cutting lips	6302 Anzahl der Schneiden No. of cutting lips
2,40 mm	3	3
2,50 mm - 3,90 mm	5	5
4,00 mm - 12,90 mm	6	6
13,00 mm - 23,50 mm	8	8
24,00 mm - 33,00 mm	10	10
34,00 mm - 45,00 mm	12	12
>46,00 mm	14	14

\*\*ILIX Norm

● Standardartikel / Items available ex stock

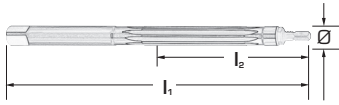


# DIN 859 A/B



## Nachstellbare Hand-Reibahlen aus HSS Nachstellbereich max. 1 % über dem Nenndurchmesser

Adjustable hand reamers made of HSS  
range of expansion max. 1 % over nominal size



Form / Form			A	B
Typ / Type			Schneiden gerade straight	Schneiden 7/8° LH
Schneidrichtung Cutting direction				
Schneidstoff Material			HSS	HSS
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	6306	6309
4	76	38	●	-
5	87	44	●	-
6	93	47	●	-
7	107	54	●	-
8	115	58	●	●
9	124	62	●	●
10	133	66	●	●
11	142	71	●	●
12	152	76	●	●
13	152	76	●	●
14	163	81	●	●
15	163	81	●	●
16	175	87	●	●
17	175	87	●	●
18	188	93	●	●
19	188	93	●	●
20	201	100	●	●
21	201	100	●	●
22	215	107	●	●
23	215	107	●	●
24	231	115	●	●
25	231	115	●	●
26	231	115	●	●
28	247	124	●	●
30	247	124	●	●

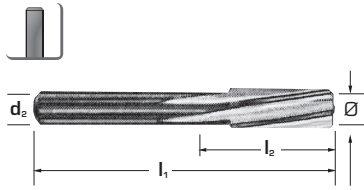
Form / Form			A	B
Typ / Type			Schneiden gerade straight	Schneiden 7/8° LH
Schneidrichtung Cutting direction				
Schneidstoff Material			HSS	HSS
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	6306	6309

Vierkant nach DIN 10 / square acc. to DIN 10  
 Alle nicht aufgeführten Durchmesser sind Zwischenmaße. Preise auf Anfrage  
 All items not listed herein are intermediate sizes. Prices upon request.  
 ● Standardartikel / Items available ex stock



## Kurze Maschinen-Reibahlen mit Zylinderschaft aus HSS-Co für Bohrungen mit Passung H7, für Automaten

Short machine chucking reamers with straight shank, made of HSS-Co to produce holes with H7 tolerance, for automatic machines



Form / Form				B/D
Typ / Type				Schneiden 7/8° LH
Schneidrichtung Cutting direction				
Schneidstoff Material				HSS-Co
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> h9	6324
1,5	45	12	2,00	●
2,0	50	16	2,00	●
2,5	56	18	3,00	●
3,0	56	18	3,00	●
3,5	63	22	4,00	●
4,0	56	20	3,55	●
4,5	63	22	4,00	●
5,0	63	22	4,00	●
5,5	63	22	5,00	●
6,0	63	22	5,00	●
6,5	63	22	5,00	●
7,0	71	25	6,30	●
7,5	71	25	6,30	●
8,0	71	25	6,30	●
8,5	71	25	6,30	●
9,0	71	25	8,00	●
9,5	71	25	8,00	●
10,0	71	25	8,00	●
11,0	80	28	10,00	●
12,0	80	28	10,00	●
13,0	80	28	10,00	●
14,0	90	32	12,50	●
15,0	90	32	12,50	●
16,0	90	32	12,50	●
17,0	90	32	12,50	●
18,0	100	36	16,00	●
19,0	100	36	16,00	●
20,0	100	36	16,00	●

Form / Form				B/D
Typ / Type				Schneiden 7/8° LH
Schneidrichtung Cutting direction				
Schneidstoff Material				HSS-Co
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> h9	6324

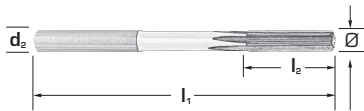
● Standardartikel / Items available ex stock

# DIN 212 A/C-B/D-E



## Maschinen-Reibahlen mit Zylinderschaft aus HSS-Co für Bohrungen mit Passung H7

Machine chucking reamers with straight shank, made of HSS-Co to produce holes with H7 tolerance



Form / Form				A/C	E	B/D	B/D
Typ / Type				Schneiden gerade straight	Schneiden 45° LH	Schneiden 7/8° LH	Schneiden 7/8° LH
Schneidrichtung Cutting direction							
Schneidstoff Material				HSS-Co	HSS-Co	HSS-Co	HSS-Co
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> h9	6321	6325	6326	6326 TN
1,0	37	5	1,0	●	●	●	●
1,1	40	7	1,1	●	●	●	●
1,2	40	7	1,2	●	●	●	●
1,3	40	7	1,3	●	●	●	●
1,4	40	8	1,4	●	●	●	●
1,5	40	8	1,5	●	●	●	●
1/16"	43	9	1,588	-	-	●	●
1,6	43	9	1,6	●	●	●	●
1,7	43	9	1,7	●	●	●	●
1,8	46	10	1,8	●	●	●	●
1,9	46	10	1,9	●	●	●	●
2,0	49	11	2,0	●	●	●	●
2,1	49	11	2,1	●	●	●	●
2,2	53	12	2,2	●	●	●	●
2,3	53	12	2,3	●	●	●	●
3/32"	57	14	2,382	-	-	●	●
2,4	57	14	2,4	●	●	●	●
2,5	57	14	2,5	●	●	●	●
2,6	57	14	2,6	●	●	●	●
2,7	61	15	2,7	●	●	●	●
7/64"	61	15	2,779	-	-	●	●
2,8	61	15	2,8	●	●	●	●
2,9	61	15	2,9	●	●	●	●
3,0	61	15	3,0	●	●	●	●
3,1	65	16	3,1	●	●	●	●
1/8"	65	16	3,175	-	-	●	●
3,2	65	16	3,2	●	●	●	●
3,3	65	18	3,3	●	●	●	●
3,4	70	18	3,4	●	●	●	●
3,5	70	18	3,5	●	●	●	●
3,6	70	18	3,6	●	●	●	●
3,7	70	18	3,7	●	●	●	●
3,8	75	19	4,0	●	●	●	●
3,9	75	19	4,0	●	●	●	●
4,0	75	19	4,0	●	●	●	●
4,1	75	19	4,0	●	●	●	●
4,2	75	19	4,0	●	●	●	●
4,3	80	21	4,5	●	●	●	●

\*ILIX Standard

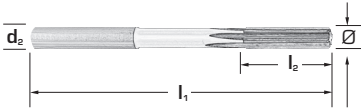
● Standardartikel / Items available ex stock

# DIN 212 A/C-B/D-E



## Maschinen-Reibahlen mit Zylinderschaft aus HSS-Co für Bohrungen mit Passung H7

Machine chucking reamers with straight shank, made of HSS-Co to produce holes with H7 tolerance



Form / Form

Typ / Type

Schneidrichtung  
Cutting direction

Schneidstoff  
Material

Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> h9	A/C	E	B/D	B/D
				Schneiden gerade straight 	Schneiden 45° LH 	Schneiden 7/8° LH 	Schneiden 7/8° LH 
				6321	6325	6326	6326 TN
4,4	80	21	4,5	●	●	●	●
4,5	80	21	4,5	●	●	●	●
4,6	80	21	4,5	●	●	●	●
4,7	80	21	4,5	●	●	●	●
3/16"	86	23	5,0	-	-	●	●
4,8	86	23	5,0	●	●	●	●
4,9	86	23	5,0	●	●	●	●
5,0	86	23	5,0	●	●	●	●
5,1	86	23	5,0	●	●	●	●
5,2	86	23	5,0	●	●	●	●
5,3	86	23	5,0	●	●	●	●
5,4	93	26	5,6	●	●	●	●
5,5	93	26	5,6	●	●	●	●
5,6	93	26	5,6	●	●	●	●
5,7	93	26	5,6	●	●	●	●
5,8	93	26	5,6	●	●	●	●
5,9	93	26	5,6	●	●	●	●
6,0	93	26	5,6	●	●	●	●
6,1	101	28	6,3	●	●	●	●
6,2	101	28	6,3	●	●	●	●
6,3	101	28	6,3	●	●	●	●
1/4"	101	28	6,3	-	-	●	●
6,4	101	28	6,3	●	●	●	●
6,5	101	28	6,300	●	●	●	●
6,6	101	28	6,300	●	●	●	●
6,7	101	28	6,300	●	●	●	●
6,8	109	31	7,1	●	●	●	●
6,9	109	31	7,1	●	●	●	●
7,0	109	31	7,1	●	●	●	●
7,1	109	31	7,1	●	●	●	●
7,2	109	31	7,1	●	●	●	●
7,3	109	31	7,1	●	●	●	●
7,4	109	31	7,1	●	●	●	●
7,5	109	31	7,1	●	●	●	●
7,6	117	33	8,0	●	●	●	●
7,7	117	33	8,0	●	●	●	●
7,8	117	33	8,0	●	●	●	●
7,9	117	33	8,0	●	●	●	●

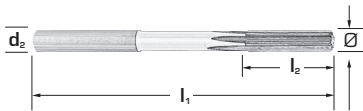
● Standardartikel / Items available ex stock

# DIN 212 A/C-B/D-E



## Maschinen-Reibahlen mit Zylinderschaft aus HSS-Co für Bohrungen mit Passung H7

Machine chucking reamers with straight shank, made of HSS-Co to produce holes with H7 tolerance



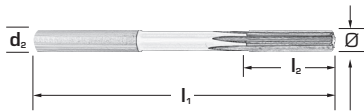
Form / Form				A/C	E	B/D	B/D
Typ / Type				Schneiden gerade straight	Schneiden 45° LH	Schneiden 7/8° LH	Schneiden 7/8° LH
Schneidrichtung Cutting direction							
Schneidstoff Material				HSS-Co	HSS-Co	HSS-Co	HSS-Co
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> h9	6321	6325	6326	6326 TN
5/16"	117	33	8,0	-	-	●	●
8,0	117	33	8,0	●	●	●	●
8,1	117	33	8,0	●	●	●	●
8,2	117	33	8,0	●	●	●	●
8,3	117	33	8,0	●	●	●	●
8,4	117	33	8,0	●	●	●	●
8,5	117	33	8,0	●	●	●	●
8,6	125	36	9,0	●	●	●	●
8,7	125	36	9,0	●	●	●	●
8,8	125	36	9,0	●	●	●	●
8,9	125	36	9,0	●	●	●	●
9,0	125	36	9,0	●	●	●	●
9,1	125	36	9,0	●	●	●	●
9,2	125	36	9,0	●	●	●	●
9,3	125	36	9,0	●	●	●	●
9,4	125	36	9,0	●	●	●	●
9,5	125	36	9,0	●	●	●	●
3/8"	133	38	10,0	-	-	●	●
9,6	133	38	10,0	●	●	●	●
9,7	133	38	10,0	●	●	●	●
9,8	133	38	10,0	●	●	●	●
9,9	133	38	10,0	●	●	●	●
10,0	133	38	10,0	●	●	●	●
10,1	133	38	10,0	●	●	●	●
10,2	133	38	10,0	●	●	●	●
10,3	133	38	10,0	●	●	●	●
10,4	133	38	10,0	●	●	●	●
10,5	133	38	10,0	●	●	●	●
10,6	133	38	10,0	●	●	●	●
10,7	142	41	10,0	●	●	●	●
10,8	142	41	10,0	●	●	●	●
10,9	142	41	10,0	●	●	●	●
11,0	142	41	10,0	●	●	●	●
11,5	142	41	10,0	●	●	●	●
12,0	151	44	10,0	●	●	●	●
12,5	151	44	10,0	●	●	●	●
1/2"	151	44	10,0	-	-	●	●
13,0	151	44	10,0	●	●	●	●

● Standardartikel / Items available ex stock



## Maschinen-Reibahlen mit Zylinderschaft aus HSS-Co für Bohrungen mit Passung H7

Machine chucking reamers with straight shank, made of HSS-Co to produce holes with H7 tolerance



Form / Form				A/C	E	B/D	B/D
Typ / Type				Schneiden gerade straight	Schneiden 45° LH	Schneiden 7/8° LH	Schneiden 7/8° LH
Schneidrichtung Cutting direction							
Schneidstoff / Material				HSS-Co	HSS-Co	HSS-Co	HSS-Co
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> h9	6321	6325	6326	6326 TN
13,5	160	47	12,5	●	●	●	●
14,0	160	47	12,5	●	●	●	●
14,5	162	50	12,5	●	●	●	●
15,0	162	50	12,5	●	●	●	●
15,5	170	52	12,5	●	●	●	●
5/8"	170	52	12,5	-	-	●	●
16,0	170	52	12,5	●	●	●	●
16,5	175	54	14,0	●	●	●	●
17,0	175	54	14,0	●	●	●	●
17,5	182	56	14,0	●	●	●	●
18,0	182	56	14,0	●	●	●	●
18,5	189	58	16,0	●	●	●	●
19,0	189	58	16,0	●	●	●	●
3/4"	195	60	16,0	-	-	●	●
19,5	195	60	16,0	●	●	●	●
20,0	195	60	16,0	●	●	●	●

Durchmesser Diameter range	6321 Anzahl der Schneiden No. of cutting lips	6325 Anzahl der Schneiden No. of cutting lips	6326 Anzahl der Schneiden No. of cutting lips	6326TN Anzahl der Schneiden No. of cutting lips
0,6 mm - 2,4 mm	3	2	3	3
2,5 mm - 3,9 mm	5	3	5	5
4,0 mm - 13,5 mm	6	3	6	6
13,5 mm - 14,5 mm	8	3	8	8
15,0 mm - 20,0 mm	8	4	8	8

\*\*ILIX Standard

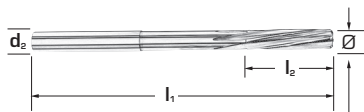
● Standardartikel / Items available ex stock



Ähnlich / similar DIN 8093

## Maschinen-Reibahlen mit Zylinderschaft aus VHM für Bohrungen mit Passung H7

Machine chucking reamers with straight shank, made of solid carbide to produce holes with H7 tolerance



Form / Form						B	B
Typ / Type						Schneiden 12° LH	Schneiden 12° LH
Schneidrichtung Cutting direction							
Schneidstoff / Material						K10/20	K10/20
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> h9	Anzahl der Schneiden Cutting lips	6372*	6372* TN	
1,0	34	6	1	3	●	●	
1,1	34	6	1	3	●	●	
1,2	34	6	1	3	●	●	
1,3	40	8	2	3	●	●	
1,4	40	8	2	3	●	●	
1,5	40	8	2	3	●	●	
1,6	43	9	2	3	●	●	
1,7	43	9	2	4	●	●	
1,8	46	10	2	4	●	●	
1,9	46	10	2	4	●	●	
2,0	49	11	2	4	●	●	
2,1	49	11	2	4	●	●	
2,2	53	12	3	4	●	●	
2,3	53	12	3	4	●	●	
2,4	57	14	3	4	●	●	
2,5	57	14	3	4	●	●	
2,6	57	14	3	4	●	●	
2,7	61	15	3	4	●	●	
2,8	61	15	3	6	●	●	
2,9	61	15	3	6	●	●	
3,0	61	15	3	6	●	●	
3,1	65	16	4	6	●	●	
3,2	65	16	4	6	●	●	
3,3	65	16	4	6	●	●	
3,4	70	18	4	6	●	●	
3,5	70	18	4	6	●	●	
3,6	70	18	4	6	●	●	
3,7	70	18	4	6	●	●	
3,8	75	19	4	6	●	●	
3,9	75	19	4	6	●	●	
4,0	75	19	4	6	●	●	
4,1	75	19	4	6	●	●	
4,2	80	21	4	6	●	●	
4,3	80	21	5	6	●	●	
4,4	80	21	5	6	●	●	
4,5	80	21	5	6	●	●	
4,6	80	21	5	6	●	●	
4,7	80	21	5	6	●	●	

Form / Form						B	B
Typ / Type						Schneiden 12° LH	Schneiden 12° LH
Schneidrichtung Cutting direction							
Schneidstoff / Material						K10/20	K10/20
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> h9	Anzahl der Schneiden Cutting lips	6372*	6372* TN	
4,8	86	23	5	6	●	●	
4,9	86	23	5	6	●	●	
5,0	86	23	5	6	●	●	
5,1	86	23	5	6	●	●	
5,2	86	23	5	6	●	●	
5,3	93	26	6	6	●	●	
5,4	93	26	6	6	●	●	
5,5	93	26	6	6	●	●	
5,6	93	26	6	6	●	●	
5,7	93	26	6	6	●	●	
5,8	93	26	6	6	●	●	
5,9	93	26	6	6	●	●	
6,0	93	26	6	6	●	●	
6,1	101	28	6	6	●	●	
6,2	101	28	6	6	●	●	
6,3	101	28	6	6	●	●	
6,4	101	28	6	6	●	●	
6,5	101	28	6	6	●	●	
6,6	101	28	6	6	●	●	
6,7	109	31	6	6	●	●	
6,8	109	31	8	6	●	●	
6,9	109	31	8	6	●	●	
7,0	109	31	8	6	●	●	
7,1	109	31	8	6	●	●	
7,2	117	33	8	6	●	●	
7,3	117	33	8	6	●	●	
7,4	117	33	8	6	●	●	
7,5	117	33	8	6	●	●	
7,6	117	33	8	6	●	●	
7,7	117	33	8	6	●	●	
7,8	117	33	8	6	●	●	
7,9	117	33	8	6	●	●	
8,0	117	33	8	6	●	●	
8,1	117	33	8	6	●	●	
8,2	117	33	8	6	●	●	
8,3	117	33	8	6	●	●	
8,4	117	33	8	6	●	●	
8,5	117	33	8	6	●	●	

Bis zu 12.20 mm Durchmesser aus Vollhartmetall, über Hartmetall bestück / up to Ø 12,20 mm made of solid carbide, above carbide tipped

\* ab 8,1 mm Ø mit Vollhartmetallkopf / from 8,1 mm Ø onwards with solid carbide head

● Standardartikel / Items available ex stock



Ähnlich / similar DIN 8093

## Maschinen-Reibahlen mit Zylinderschaft aus VHM für Bohrungen mit Passung H7

Machine chucking reamers with straight shank, made of solid carbide to produce holes with H7 tolerance



TIN



Form / Form						B	B
Typ / Type						Schneiden 12° LH	Schneiden 12° LH
Schneidrichtung Cutting direction							
Schneidstoff Material						K10/20	K10/20
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> h9	Anzahl der Schneiden Cutting lips	6372*	6372* TN	
8,6	125	36	10	6	●	●	
8,7	125	36	10	6	●	●	
8,8	125	36	10	6	●	●	
8,9	125	36	10	6	●	●	
9,0	125	36	10	6	●	●	
9,1	125	36	10	6	●	●	
9,2	125	36	10	6	●	●	
9,3	125	36	10	6	●	●	
9,4	125	36	10	6	●	●	
9,5	125	36	10	6	●	●	
9,6	133	38	10	6	●	●	
9,7	133	38	10	6	●	●	
9,8	133	38	10	6	●	●	
9,9	133	38	10	6	●	●	
10,0	133	38	10	6	●	●	
10,1	133	38	10	6	●	●	
10,2	133	38	10	6	●	●	
10,3	133	38	10	6	●	●	
10,4	133	38	10	6	●	●	
10,5	133	38	10	6	●	●	
10,6	133	38	10	6	●	●	
10,7	142	41	10	6	●	●	
10,8	142	41	10	6	●	●	
10,9	142	41	10	6	●	●	
11,0	142	41	10	6	●	●	
11,5	142	41	10	6	●	●	
12,0	151	44	10	6	●	●	
12,5	151	44	10	8	●	●	
13,0	151	44	10	8	●	●	
13,5	160	47	14	8	●	●	
14,0	160	47	14	8	●	●	
14,5	162	50	14	8	●	●	
15,0	162	50	14	8	●	●	
15,5	170	52	14	8	●	●	
16,0	170	52	14	8	●	●	
16,5	175	54	14	8	●	●	
17,0	175	54	14	8	●	●	
17,5	182	56	14	8	●	●	

Form / Form						B	B
Typ / Type						Schneiden 12° LH	Schneiden 12° LH
Schneidrichtung Cutting direction							
Schneidstoff Material						K10/20	K10/20
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> h9	Anzahl der Schneiden Cutting lips	6372*	6372* TN	
18,0	182	56	14	8	●	●	
18,5	189	58	16	8	●	●	
19,0	189	58	16	8	●	●	
19,5	195	60	16	8	●	●	
20,0	195	60	16	8	●	●	

\* ab 8,1 mm Ø mit Vollhartmetallkopf / from 8,1 mm Ø onwards with solid carbide head  
 ● Standardartikel / Items available ex stock

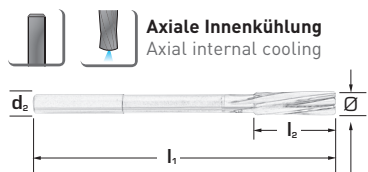




Ähnlich / similar **DIN 8093**

## Maschinen-Reibahlen mit Zylinderschaft aus VHM mit Innenkühlung für Sacklochbohrungen für Bohrungen mit Passung H7

Machine chucking reamers with straight shank, made of solid carbide to produce holes with H7 tolerance



**Form / Form**

**Typ / Type**

**Schneidrichtung**  
Cutting direction

**Schneidstoff**  
Material



Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> h9	Anzahl der Schneiden Cutting lips	<b>6370</b>
4,0	75	19	4	6	●
4,5	80	21	5	6	●
5,0	86	23	5	6	●
5,5	93	26	6	6	●
6,0	93	26	6	6	●
6,5	101	28	6	6	●
7,0	109	31	8	6	●
7,5	117	33	8	6	●
8,0	117	33	8	6	●
8,5	125	36	10	6	●
9,0	125	36	10	6	●
9,5	133	38	10	6	●
10,0	133	38	10	6	●
11,0	142	41	10	6	●
12,0	151	41	10	6	●
13,0	151	44	10	8	●
14,0	160	47	14	8	●
15,0	162	50	14	8	●
16,0	170	52	14	8	●
17,0	175	54	14	8	●
18,0	182	56	14	8	●
19,0	189	58	16	8	●
20,0	195	60	16	8	●

**Form / Form**

**Typ / Type**

**Schneidrichtung**  
Cutting direction

**Schneidstoff**  
Material



Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> h9	Anzahl der Schneiden Cutting lips	<b>6370</b>

● Standardartikel / Items available ex stock



Ähnlich / similar DIN 8093

## Maschinen-Reibahlen mit Zylinderschaft aus VHM mit Innenkühlung für Durchgangsbohrungen für Bohrungen mit Passung H7

Machine chucking reamers with straight shank, made of solid carbide with radial cooling for through holes to produce holes with H7 tolerance



Kühlkanal axial  
radial internal cooling



Form / Form						B
Typ / Type						Schneiden 12° LH
Schneidrichtung Cutting direction						
Schneidstoff Material						K10/20
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> h9	Anzahl der Schneiden Cutting lips	6371	
4,0	75	19	4	6	●	
4,5	80	21	5	6	●	
5,0	86	23	5	6	●	
5,5	93	26	6	6	●	
6,0	93	26	6	6	●	
6,5	101	28	6	6	●	
7,0	109	31	8	6	●	
7,5	117	33	8	6	●	
8,0	117	33	8	6	●	
8,5	125	36	10	6	●	
9,0	125	36	10	6	●	
9,5	133	38	10	6	●	
10,0	133	38	10	6	●	
11,0	142	41	10	6	●	
12,0	151	41	10	6	●	
13,0	151	44	10	8	●	
14,0	160	47	14	8	●	
15,0	162	50	14	8	●	
16,0	170	52	14	8	●	
17,0	175	54	14	8	●	
18,0	182	56	14	8	●	
19,0	189	58	16	8	●	
20,0	195	60	16	8	●	

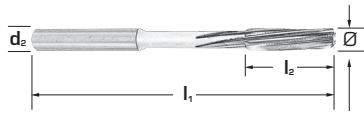
Form / Form						B
Typ / Type						Schneiden 12° LH
Schneidrichtung Cutting direction						
Schneidstoff Material						K10/20
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> h9	Anzahl der Schneiden Cutting lips	6371	

● Standardartikel / Items available ex stock



## Maschinen-Reibahlen mit Zylinderschaft aus HSS-Co in 1/100 Abstufung

Machine chucking reamers with straight shank, made of HSS-Co centesimal



### Herstellungstoleranzen

Reamer tolerances	
- 5,5 mm	+0,004
	0
> 5,5 mm	+0,005
	0



Form / Form		B/D			
Typ / Type		Schneiden 7-8° LH			
Schneidrichtung Cutting direction					
Schneidstoff Material		HSS-Co			
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> h9	Anzahl der Schneiden Cutting lips	6326 C
0,95 - 0,96	37	5	-	3	●
0,97 - 1,00	37	5	-	3	●
1,01 - 1,32	40	7	-	3	●
1,33 - 1,39	40	8	-	3	●
1,40 - 1,49	40	8	-	3	●
1,50	40	8	-	3	●
1,51 - 1,70	43	9	-	3	●
1,71 - 1,90	46	10	-	3	●
1,91 - 1,99	49	11	-	3	●
2,00 - 2,09	49	11	-	3	●
2,10 - 2,12	49	11	-	3	●
2,13 - 2,36	53	12	-	3	●
2,37 - 2,49	57	14	-	3	●
2,50 - 2,59	57	14	-	5	●
2,60 - 2,65	57	14	-	5	●
2,66 - 2,99	61	15	-	5	●
3,00	61	15	-	5	●
3,01 - 3,09	65	16	-	5	●
3,10 - 3,35	65	16	-	5	●
3,36 - 3,49	70	18	-	5	●
3,50 - 3,59	70	18	-	5	●
3,60 - 3,75	70	18	-	5	●
3,76 - 3,81	75	19	4,0	5	●
3,82 - 3,99	75	19	4,0	5	●
4,00 - 4,20	75	19	4,0	6	●
4,21 - 4,25	75	19	4,0	6	●
4,26 - 4,75	80	21	4,5	6	●
4,76 - 5,20	86	23	5,0	6	●
5,21 - 5,30	86	23	5,0	6	●
5,31 - 6,00	93	26	5,6	6	●
6,01 - 6,11	101	28	6,3	6	●
6,12 - 6,70	101	28	6,3	6	●
6,71 - 7,50	109	31	7,1	6	●
7,51 - 8,20	117	33	8,0	6	●
8,21 - 8,50	117	33	8,0	6	●
8,51 - 9,50	125	36	9,0	6	●
9,51 - 10,20	133	38	10,0	6	●
10,21 - 10,60	133	38	10,0	6	●

Form / Form		B/D			
Typ / Type		Schneiden 7-8° LH			
Schneidrichtung Cutting direction					
Schneidstoff Material		HSS-Co			
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> h9	Anzahl der Schneiden Cutting lips	6326 C
10,61 - 11,20	142	41	10,0	6	●
11,21 - 11,80	142	41	10,0	6	●
11,81 - 12,02	151	44	10,0	6	●
12,03 - 12,40	151	44	10,0	6	●
12,41 - 12,50	151	44	10,0	6	●
12,51 - 12,60	151	44	10,0	6	●
12,61 - 12,70	151	44	10,0	6	●
12,71 - 12,80	151	44	10,0	6	●
12,81 - 13,00	151	44	10,0	6	●
13,01 - 13,20	151	44	10,0	6	●
13,21 - 14,00	160	47	12,5	8	●
14,01 - 15,00	162	50	12,5	8	●
15,01 - 16,00	170	52	12,5	8	●
16,01 - 16,10	175	54	14,0	8	●

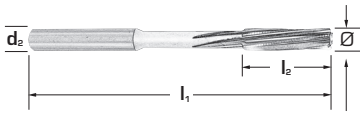
● Standardartikel / Items available ex stock



ÄhnlIch / similar DIN 8093

### Maschinen-Reibahle mit Zylinderschaft aus VHM in 1/100 Abgestuft

Machine chucking reamers with straight shank, made of solid carbide centesimal



Herstellungstoleranzen  
Reamer tolerances

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+0,004 mm  
0

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Form / Form						B
Typ / Type						Schneiden 12° LH
Schneidrichtung Cutting direction						
Schneidstoff Material						K10/20
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> h9	Anzahl der Schneiden Cutting lips	6372*	C
0,98 - 1,30	34	6	1	3		●
1,31 - 1,50	40	8	2	3		●
1,51 - 1,61	43	9	2	3		●
1,62 - 1,70	43	9	2	4		●
1,71 - 1,90	46	10	2	4		●
1,91 - 2,12	49	11	2	4		●
2,13 - 2,36	53	12	3	4		●
2,37 - 2,65	57	14	3	4		●
2,66 - 2,79	61	15	3	4		●
2,80 - 3,09	61	15	3	6		●
3,10 - 3,35	65	16	4	6		●
3,36 - 3,75	70	18	4	6		●
3,76 - 4,10	75	19	4	6		●
4,11 - 4,25	80	21	4	6		●
4,26 - 4,75	80	21	5	6		●
4,76 - 5,20	86	23	5	6		●
5,21 - 6,00	93	26	6	6		●
6,01 - 6,60	101	28	6	6		●
6,61 - 6,70	109	31	6	6		●
6,71 - 7,10	109	31	8	6		●
7,11 - 8,50	117	33	8	6		●
8,51 - 9,50	125	36	10	6		●
9,51 - 10,60	133	38	10	6		●
10,61 - 11,80	142	41	10	6		●
11,81 - 12,05	151	44	10	6		●

Form / Form						B
Typ / Type						Schneiden 12° LH
Schneidrichtung Cutting direction						
Schneidstoff Material						K10/20
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> h9	Anzahl der Schneiden Cutting lips	6372*	C

Bis Ø 12,20 mm aus Vollhartmetall, über Hartmetall bestückt / up to Ø 12,20 mm made of solid carbide, above carbide tipped

● Standardartikel / Items available ex stock

# MASCHINEN-REIBAHLEN IN 1/100 ABSTUFUNG

## CENTESIMAL MACHINE REAMERS



Durchmesserbestimmung auf Basis Nenndurchmesser und Toleranzfeld / Tool diameter based on nominal diameter and tolerance

BEISPIEL  
EXAMPLE

Anfrage / Required fit       $d = 4,25 \text{ mm F8}$

Lösung / Solution:

- aus Spalte Nenn- $\emptyset$  den Durchmesserbereich wählen 3 - 6  
choose from column nominal- $\emptyset$  the diameter range = 3 - 6
- Passung F8 suchen / search fit F8 Zuschlagswert / surcharge = + 0,02  
 $4,25 \text{ mm} + 0,02 \text{ mm} = d = 4,27 \text{ mm}$

Nenn/nominal $\emptyset$ (mm) oltre/above - fino a/up to	Zuschlagswerte in mm bezogen auf die Passung / Table values for required fit in mm															
	A9	A11	B8	B9	B10	B11	C8	C9	C10	C11	D7	D8	D9	D10	D11	
1 - 3	+0,28	+0,31	-	+0,15	+0,17	+0,18	-	+0,07	+0,09	+0,10	-	-	+0,03	+0,05	+0,06	
3 - 6	+0,29	+0,32	+0,15	+0,16	+0,17	+0,19	+0,08	+0,09	+0,10	+0,12	-	+0,04	+0,05	+0,06	+0,08	
6 - 10	+0,30	+0,35	+0,16	+0,17	+0,19	+0,22	+0,09	+0,10	+0,12	+0,15	-	+0,05	+0,06	+0,08	+0,11	
10 - 18	+0,32	+0,37	+0,16	+0,18	+0,20	+0,23	+0,11	+0,12	+0,14	+0,18	+0,06	+0,06	+0,08	+0,10	+0,13	
	E7	E8	E9	F7	F8	F9	F10	G6	G7	H6	H7	H8	H9	H10	H11	
1 - 3	-	+0,02	+0,03	+0,01	+0,01	+0,02	-	-	-	-	-	-	+0,01	+0,03	+0,04	
3 - 6	-	+0,03	+0,04	-	+0,02	+0,03	+0,04	-	+0,01	-	-	+0,01	+0,02	+0,03	+0,05	
6 - 10	+0,03	+0,03	+0,05	+0,02	+0,02	+0,03	+0,05	-	+0,01	-	-	+0,01	+0,02	+0,04	+0,07	
10 - 18	+0,04	+0,04	+0,06	+0,02	+0,03	+0,04	+0,07	+0,01	-	-	+0,01	+0,01	+0,03	+0,05	+0,08	
	H12	H13	J6	J7	J8	JS6	JS7	JS8	JS9	K7	K8	M6	M7	M8	N6	
1 - 3	+0,08	+0,11	-	-	-	-	-	+0,00	+0,00	-	-0,01	-	-	-	-	
3 - 6	+0,09	+0,14	-	+0,00	+0,00	-	+0,00	+0,00	+0,00	-	-	-	-	-0,01	-	
6 - 10	+0,12	+0,18	-	+0,00	+0,00	-	+0,00	+0,00	+0,00	-	-0,01	-0,01	-0,01	-0,01	-	
10 - 18	+0,14	+0,22	-	+0,00	+0,00	-	+0,00	+0,00	+0,00	-	-0,01	-0,01	-0,01	-0,01	-	
	N7	N8	N9	N10	N11	P6	P7	R6	R7	S6	S7	U6	U7	U10	Z10	
1 - 3	-0,01	-0,01	-0,02	-0,02	-0,02	-	-	-	-	-	-0,02	-	-	-	-0,04	
3 - 6	-0,01	-0,01	-0,01	-0,02	-0,02	-	-	-	-0,02	-	-	-	-0,03	-0,04	-0,05	
6 - 10	-	-0,02	-0,01	-0,02	-0,02	-	-0,02	-	-0,02	-	-0,03	-	-0,03	-0,05	-0,06	
10 - 18	-0,01	-0,02	-0,02	-0,02	-0,03	-	-0,02	-	-0,03	-	-0,03	-	-	-0,05	-0,07	

### Anwendungshinweis

- Die Tabelle wurde so aufgebaut, dass jeder Reibahleddurchmesser mit einem 1/100 mm Stufensprung bestimmt werden kann. In den Zuschlagswerten wurden die Herstellungstoleranzen berücksichtigt  
 $\emptyset 5,5 \text{ mm} + 0,004 / + 0,0$   
 $> \emptyset 5,5 \text{ mm} + 0,005 / + 0,0$

### Notes for use of above table

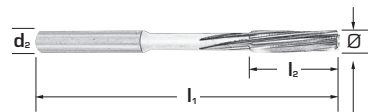
- This table allows the selection of chucking reamers with diameters within steps of 0,01mm. The given values take the basic manufacturing tolerances as standard into consideration.  
 $\emptyset 5,5 \text{ mm} + 0,004 / + 0,0$   
 $> \emptyset 5,5 \text{ mm} + 0,005 / + 0,0$



Ähnlich / similar DIN 212

## Maschinen-Reibahlen mit Zylinderschaft aus CERMET für Bohrungen mit Passung H7

Machine chucking reamers with straight shank, made of CERMET to produce holes with H7 tolerance



Form / Form

**B**

Typ / Type

Schneiden  
12°  
LH

Schneidrichtung  
Cutting direction



Schneidstoff  
Material

CERMET

Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub>	Anzahl der Schneiden Cutting lips	6323
3,5	60	18	4	6	■
4,0	75	19	4	6	■
4,5	75	21	5	6	■
6,0	93	26	6	6	■
6,5	101	28	6	6	■
7,0	109	31	8	6	■
7,5	109	33	8	6	■
9,5	125	38	10	6	■
11,0	142	41	10	6	■
12,0	151	44	10	6	■
13,0	151	44	10	8	■
16,0	170	53	14	8	■
20,0	195	60	16	8	■

Form / Form

**B**

Typ / Type

Schneiden  
12°  
LH

Schneidrichtung  
Cutting direction



Schneidstoff  
Material

CERMET

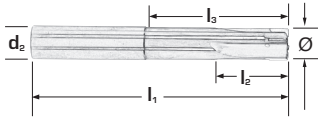
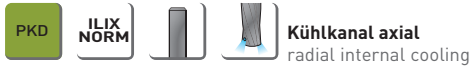
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub>	Anzahl der Schneiden Cutting lips	6323



PKD

## VHM maschinen Reibahlen mit Zylinderschaft und Diamant Beschichtung, Radialer Kühlmittelaustritt

Machine reamers with straight shank in solid carbide with polycrystalline diamond and internal cooling



ILIX NORM

Schneiden  
Dritte  
straight flutes



PKD

6373

Form / Form

Typ / Type

Schneidrichtung  
Cutting direction

Schneidstoff  
Material

Ø mm h7	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>3</sub> mm	d <sub>2</sub> h6	Anzahl der Schneiden Cutting lips	
6	89	12	52	6	4	●
8	103	19	60	8	4	●
10	103	19	60	10	4	●
12	105	19	60	12	4	●
14	105	19	60	14	4	●
16	130	22	82	16	4	●
18	130	22	82	18	4	●
20	150	25	100	20	4	●

# DIN 208 A/B/C



## Maschinen-Reibahlen mit Morsekegel, aus HSS-Co für Bohrungen mit Passung H7

Machine chucking reamers with Morse taper shank, made of HSS-Co to produce holes with H7 tolerance



Form / Form				A	B	C
Typ / Type				Schneiden gerade straight	Schneiden 7/8° LH	Schneiden 45° LH
Schneidrichtung Cutting direction						
Schneidstoff Material				HSS-Co	HSS-Co	HSS-Co
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	MK MT	6333	6337	6335
5,0	133	23	1	●	●	●
5,5	138	26	1	●	●	-
6,0	138	26	1	●	●	●
6,5	144	28	1	●	●	-
7,0	150	31	1	●	●	●
7,5	150	31	1	●	●	-
8,0	156	33	1	●	●	●
8,5	156	33	1	●	●	-
9,0	162	36	1	●	●	●
9,5	162	36	1	●	●	-
10,0	168	38	1	●	●	●
10,5	168	38	1	●	●	-
11,0	175	41	1	●	●	●
11,5	175	41	1	●	●	-
12,0	182	41	1	●	●	●
12,5	182	44	1	●	●	-
13,0	182	44	1	●	●	●
13,5	189	47	1	●	●	-
14,0	189	47	1	●	●	●
14,5	204	50	2	●	●	-

Form / Form				A	B	C
Typ / Type				Schneiden gerade straight	Schneiden 7/8° LH	Schneiden 45° LH
Schneidrichtung Cutting direction						
Schneidstoff Material				HSS-Co	HSS-Co	HSS-Co
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	MK MT	6333	6337	6335
15,0	204	50	2	●	●	●
15,5	210	52	2	●	●	-
16,0	210	52	2	●	●	●
16,5	214	54	2	●	●	-
17,0	214	54	2	●	●	●
17,5	219	56	2	●	●	-
18,0	219	56	2	●	●	●
18,5	223	58	2	●	●	-
19,0	223	58	2	●	●	●
19,5	228	60	2	●	●	-
20,0	228	60	2	●	●	●
20,5	232	62	2	●	●	-
21,0	232	62	2	●	●	●
21,5	237	64	2	●	●	-
22,0	237	64	2	●	●	●
22,5	241	66	2	●	●	-
23,0	241	66	2	●	●	●
23,5	241	66	2	●	●	-
24,0	268	68	3	●	●	●
24,5	268	68	3	●	●	-

Durchmesser Diameter range	6333 Anzahl der Schneiden No. of cutting lips	6337 Anzahl der Schneiden No. of cutting lips	6335 Anzahl der Schneiden No. of cutting lips
5,0 mm - 14,0 mm	6	6	3
14,5 mm - 15,0 mm	8	8	3
15,5 mm - 24,5 mm	8	8	4
25,0 mm - 35,0 mm	10	10	4
36,0 mm - 40,0 mm	-	12	-

Zwischenmaße Preise auf Anfrage / Deviating sizes prices upon request

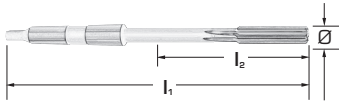
● Standardartikel / Items available ex stock











## Maschinen-Reibahlen mit Morsekegel, aus HSS-Co für Bohrungen mit Passung H7

Machine chucking reamers with Morse taper shank, made of HSS-Co to produce holes with H7 tolerance



Form / Form				A	B	C
Typ / Type				Schneiden gerade straight	Schneiden 7/8° LH	Schneiden 45° LH
Schneidrichtung Cutting direction						
Schneidstoff Material				HSS-Co	HSS-Co	HSS-Co
Ø	L <sub>1</sub>	L <sub>2</sub>	MK	6333	6337	6335
mm	mm	mm	MT			
25,0	268	68	3	●	●	●
25,5	273	70	3	●	●	-
26,0	273	70	3	●	●	●
26,5	273	70	3	●	●	-
27,0	277	71	3	●	●	●
27,5	277	71	3	●	●	-
28,0	277	71	3	●	●	●
28,5	281	73	3	●	●	-
29,0	281	73	3	●	●	●
29,5	281	73	3	●	●	-
30,0	281	73	3	●	●	●
30,5	285	75	3	●	●	-
31,0	285	75	3	●	●	●
31,5	285	75	3	●	●	-
32,0	317	77	4	●	●	●
33,0	317	77	4	-	●	-
34,0	321	78	4	-	●	-
35,0	321	78	4	-	●	-
36,0	325	79	4	-	●	-
37,0	325	79	4	-	●	-

Form / Form				A	B	C
Typ / Type				Schneiden gerade straight	Schneiden 7/8° LH	Schneiden 45° LH
Schneidrichtung Cutting direction						
Schneidstoff Material				HSS-Co	HSS-Co	HSS-Co
Ø	L <sub>1</sub>	L <sub>2</sub>	MK	6333	6337	6335
mm	mm	mm	MT			
38,0	329	81	4	-	●	-
39,0	329	81	4	-	●	-
40,0	329	81	4	-	●	-

Durchmesser Diameter range	6333 Anzahl der Schneiden No. of cutting lips	6337 Anzahl der Schneiden No. of cutting lips	6335 Anzahl der Schneiden No. of cutting lips
5,0 mm - 14,0 mm	6	6	3
14,5 mm - 15,0 mm	8	8	3
15,5 mm - 24,5 mm	8	8	4
25,0 mm - 35,0 mm	10	10	4
36,0 mm - 40,0 mm	-	12	-

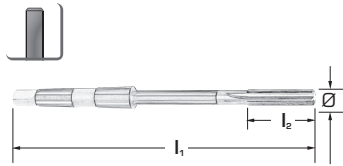
Zwischenmaße Preise auf Anfrage / Deviating sizes prices upon request

● Standardartikel / Items available ex stock



## Maschinen-Reibahlen mit Morsekegel, aus HSS-Co für Bohrungen mit Passung H7

Machine chucking reamers with Morse taper shank, made of solid carbide to produce holes with H7 tolerance



Form / Form						ILIX NORM
Typ / Type						Schneiden gerade straight
Schneidrichtung Cutting direction						
Schneidstoff Material						K10/20
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	MK MT	Anzahl der Schneiden Cutting lips		6369
5	133	23	1	6		●
6	138	26	1	6		●
7	150	31	1	6		●
8	156	33	1	6		●
9	162	36	1	6		●
10	168	38	1	6		●
11	175	41	1	6		●
12	182	44	1	6		●
13	182	44	1	6		●
14	189	47	1	6		●
15	204	50	2	6		●
16	210	52	2	6		●
17	214	54	2	6		●
18	219	56	2	6		●
19	223	58	2	6		●
20	228	60	2	6		●

Form / Form						ILIX NORM
Typ / Type						Schneiden gerade straight
Schneidrichtung Cutting direction						
Schneidstoff Material						K10/20
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	MK MT	Anzahl der Schneiden Cutting lips		6369

\* Bis Ø 20 mm VHM über Hartmetall bestückt / up to Ø 20 mm made of solid carbide, above carbide tipped

Zwischenmaße Preise auf Anfrage/ for intermediate sizes prices upon request

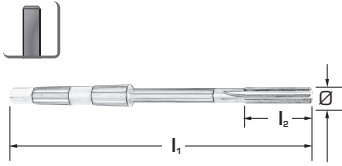
- bis 7,0 mm Ø Baumaße nach / up to 7,0 mm Ø dimensions acc. to DIN 208 FORM A / up to 7,0 mm Ø dimensions acc. to DIN 208 FORM A
- über 7,0 mm Ø Baumaße nach / above 7,0 mm Ø dimensions acc. to DIN 8094 FORM A / above 7,0 mm Ø dimensions acc. to DIN 8094 FORM A

● Standardartikel / Items available ex stock



## Maschinen-Reibahlen mit Morsekegel, aus HSS-Co für Bohrungen mit Passung H7

Machine chucking reamers with Morse taper shank, made of solid carbide to produce holes with H7 tolerance



Form / Form						ILIX NORM
Typ / Type						Schneiden 12° LH
Schneidrichtung Cutting direction						
Schneidstoff Material						K10/20
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	MK MT	Anzahl der Schneiden Cutting lips		6376
5	133	23	1	6		●
6	138	26	1	6		●
7	150	31	1	6		●
8	156	33	1	6		●
9	162	36	1	6		●
10	168	38	1	6		●
11	175	41	1	6		●
12	182	44	1	6		●
13	182	44	1	6		●
14	189	47	1	6		●
15	204	50	2	6		●
16	210	52	2	6		●
17	214	54	2	6		●
18	219	56	2	6		●
19	223	58	2	6		●
20	228	60	2	6		●

Form / Form						ILIX NORM
Typ / Type						Schneiden 12° LH
Schneidrichtung Cutting direction						
Schneidstoff Material						K10/20
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	MK MT	Anzahl der Schneiden Cutting lips		6376

Zwischenmaße Preise auf Anfrage/ for intermediate sizes prices upon request

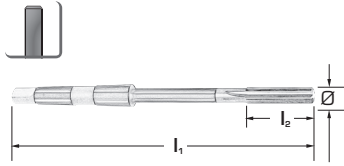
- bis 7,0 mm Ø Baumaße nach / up to 7,0 mm Ø dimensions acc. to DIN 208 FORM A / up to 7,0 mm Ø dimensions acc. to DIN 208 FORM A
- über 7,0 mm Ø Baumaße nach / above 7,0 mm Ø dimensions acc. to DIN 8094 FORM A / above 7,0 mm Ø dimensions acc. to DIN 8094 FORM A

● Standardartikel / Items available ex stock



**Spreiz-Reibahlen mit Morsekegel, aus HSS-Co**  
**Nachstellbarkeit max. 0,01 mm des Ø**

Expansion reamers with Morse taper shank  
 expandable up to max. 0,01 mm Ø



Form / Form					ILIX NORM
Typ / Type					Schneiden gerade straight
Schneidrichtung Cutting direction					
Schneidstoff Material					HSS-Co
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	MK MT		<b>6307</b>
8	156	33	1	■	
11	175	41	1	■	
12	182	44	1	■	
14	189	44	1	■	
15	204	50	2	■	
16	210	52	2	■	
17	214	54	2	■	
18	219	56	2	■	
20	228	60	2	■	

Form / Form					ILIX NORM
Typ / Type					Schneiden gerade straight
Schneidrichtung Cutting direction					
Schneidstoff Material					HSS-Co
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	MK MT		<b>6307</b>

Zwischenmaße Preise auf Anfrage/ for intermediate sizes prices upon request

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## Aufsteck-Reibahlen, aus HSS mit kegelförmiger Bohrung 1 : 30 für Bohrungen mit Passung H7

Shell reamers, made of HSS

taper hole 1 : 30 to produce holes with H7 tolerance



Form / Form			A	B	C
Typ / Type			Schneiden gerade straight	Schneiden 7/8° LH	Schneiden 45° LH
Schneidrichtung Cutting direction					
Schneidstoff Material			HSS	HSS	HSS
Ø mm	l <sub>1</sub> mm	Bohrungs-Ø / bore Ø d <sub>2</sub>	6361	6360	6362
25	45	13	●	●	●
26	45	13	●	●	●
27	45	13	●	●	●
28	45	13	●	●	●
29	45	13	●	●	●
30	45	13	●	●	●
31	50	16	●	●	●
32	50	16	●	●	●
33	50	16	●	●	●
34	50	16	●	●	●
35	50	16	●	●	●
36	56	19	●	●	●
37	56	19	●	●	●
38	56	19	●	●	●
39	56	19	●	●	●
40	56	19	●	●	●
42	56	19	●	●	●
44	63	22	●	●	●
45	63	22	●	●	●
46	63	22	●	●	●
47	63	22	●	●	●
48	63	22	●	●	●

Form / Form			A	B	C
Typ / Type			Schneiden gerade straight	Schneiden 7/8° LH	Schneiden 45° LH
Schneidrichtung Cutting direction					
Schneidstoff Material			HSS	HSS	HSS
Ø mm	l <sub>1</sub> mm	Bohrungs-Ø / bore Ø d <sub>2</sub>	6361	6360	6362
50	63	22	●	●	●
52	71	27	●	●	●
55	71	27	●	●	●
58	71	27	●	●	●
60	71	27	●	●	●
62	80	32	●	●	●
65	80	32	●	●	●
68	80	32	●	●	●
70	80	32	●	●	●
72	90	40	●	●	●
75	90	40	●	●	●
78	90	40	●	●	●
80	90	40	●	●	●
82	90	40	●	●	●
85	90	40	●	●	●
88	100	50	●	●	●
90	100	50	●	●	●
92	100	50	●	●	●
95	100	50	●	●	●
98	100	50	●	●	●
100	100	50	●	●	●

Durchmesser Diameter range	6361 Anzahl der Schneiden No. of cutting lips	6360 Anzahl der Schneiden No. of cutting lips	6362 Anzahl der Schneiden No. of cutting lips
25,0 mm - 32,0 mm	10	10	6
33,0 mm - 44,0 mm	12	12	6
45,0 mm - 58,0 mm	14	14	6
60,0 mm	16	16	6
62,0 mm - 78,0 mm	16	16	8
80,0 mm - 98,0 mm	18	18	8
100,0 mm	18	18	10

Zwischenmaße Preise auf Anfrage / Deviating sizes prices upon request

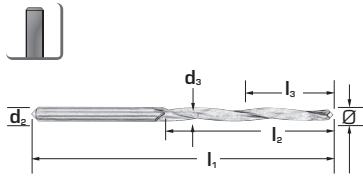
● Standardartikel / Items available ex stock



## Kegel-Reibahlen mit Zylinderschaft, aus HSS Kegel 1 : 100 Kleinst-Reibahlen mit Zylinderschaft zum Aufreihen und Justieren von Bohrungen geringer Tiefe (Kat.-Nr. 6318)

Taper pin reamers with straight shank, made of HSS taper 1 : 100

Micro reamers with straight shank for fast smooth reaming of shallow holes [Cat.-No. 6318]



Form / Form		ILIX NORM		ILIX NORM		
Typ / Type		Schneiden 12° LH	Schneiden gerade straight			
Schneidrichtung Cutting direction						
Schneidstoff Material		HSS	HSS			
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	d <sub>3</sub> mm	6318	6303
1,20	58	35	1,7	1,65	■	-
1,50	62	37	2,7	1,77	-	●
1,75	68	43	2,7	2,08	-	●
1,90	85	55	2,5	2,45	■	-
2,00	73	48	2,7	2,38	-	●
2,25	77	51	2,7	2,66	-	●
2,50	80	53	2,7	2,93	-	●
3,00	91	63	2,7	3,53	-	●
3,50	96	69	3,0	4,09	-	●
4,00	100	75	3,8	4,65	-	●
4,50	108	81	3,8	5,21	-	●
5,00	115	87	4,9	5,77	-	●
5,50	133	103	4,9	6,43	-	●
6,00	150	119	5,5	7,09	-	●
7,00	164	130	6,2	8,20	-	●
8,00	177	141	7,0	9,31	-	●
9,00	190	152	8,0	10,42	-	●
10,00	205	163	9,0	11,53	-	●
11,00	216	173	9,0	12,63	-	●
12,50	234	189	10,0	14,29	-	●
14,00	257	207	12,0	15,97	-	●
16,00	290	234	13,0	18,24	-	●
18,00	325	252	16,0	20,42	-	●
20,00	340	270	18,0	22,50	-	●

Form / Form		ILIX NORM		ILIX NORM		
Typ / Type		Schneiden 12° LH	Schneiden gerade straight			
Schneidrichtung Cutting direction						
Schneidstoff Material		HSS	HSS			
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	d <sub>3</sub> mm	6318	6303

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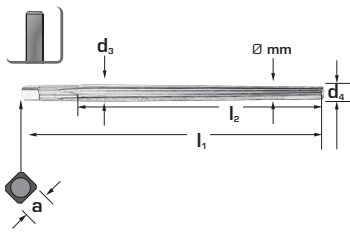


## Kegel-Reibahlen mit Zylinderschaft, aus HSS

### Kegel 1 : 50, Vierkant nach DIN 10, für Kegelstifte nach DIN 1

Taper pin reamers with straight shank, made of HSS

taper 1 : 50, square acc. to DIN 10, to produce holes for taper pins acc. to DIN 1



Form / Form		A		B			
Typ / Type		Schneiden gerade straight		Schneiden 7-8° LH			
Schneidrichtung Cutting direction							
Schneidstoff Material		HSS		HSS			
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>4</sub> mm	d <sub>3</sub> mm	a	6315	6304
0,8	46	28	0,90	1,46	3,15	●	-
1,0	46	28	0,90	1,46	3,15	●	-
1,2	50	32	1,10	1,74	3,15	●	-
1,5	57	37	1,40	2,14	2,50	●	●
1,6	57	37	1,50	2,24	2,50	■	●
2,0	68	48	1,90	2,86	2,50	●	●
2,5	68	48	2,40	3,36	2,50	●	●
3,0	80	58	2,90	4,06	3,15	●	●
3,5	100	75	3,40	4,90	3,80	●	●
4,0	93	68	3,90	5,26	4,00	●	●
4,5	115	87	4,40	6,14	4,90	-	●
5,0	100	73	4,90	6,36	5,00	●	●
5,5	150	119	5,40	7,78	7,00	-	●
6,0	135	105	5,90	8,00	6,30	●	●
6,5	150	119	6,40	8,78	7,00	-	●
7,0	177	141	6,90	9,72	8,00	-	●
8,0	180	145	7,90	10,80	8,00	●	●
9,0	205	163	8,90	12,16	11,00	-	●
10,0	215	175	9,90	13,40	10,00	●	●
12,0	255	210	11,80	16,00	11,20	●	●
13,0	240	194	12,86	16,74	14,50	-	●
14,0	240	194	13,86	17,74	14,50	-	●
16,0	280	230	15,80	20,40	14,00	●	●
20,0	310	250	19,80	24,80	18,00	●	●
25,0	370	300	24,70	30,70	22,40	●	●
30,0	400	320	29,70	36,10	25,00	●	●
40,0	430	340	39,70	46,50	31,50	-	●
50,0	460	360	49,70	56,90	40,00	-	●

Form / Form		A		B			
Typ / Type		Schneiden gerade straight		Schneiden 7-8° LH			
Schneidrichtung Cutting direction							
Schneidstoff Material		HSS		HSS			
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>4</sub> mm	d <sub>3</sub> mm	a	6315	6304

Für Kegelstifte nach DIN 1 - 258 - 1447 - 7977 - 7978  
 For taper pin according to DIN 1 - 258 - 1447 - 7977 - 7978

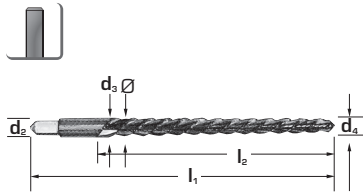
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Frz.-Norm / French standard

**Kegel-Schälreibahnen mit Zylinderschaft, aus HSS  
nur für Maschinengebrauch**

High spiral fluted taper pin reamers with straight shank, made of HSS for machine use only



<b>Form / Form</b>							NF
<b>Typ / Type</b>							Schneiden 45° LH
<b>Schneidrichtung</b> Cutting direction							
<b>Schneidstoff</b> Material							HSS
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>3</sub> mm	d <sub>2</sub> mm	d <sub>4</sub> mm	6319	
1,0	45	20	1,1	1,1	0,7	■	
3,5	65	45	3,6	3,6	2,7	●	
4,0	70	50	4,1	4,1	3,1	●	
4,5	80	55	4,6	4,6	3,5	■	

<b>Form / Form</b>							NF
<b>Typ / Type</b>							Schneiden 45° LH
<b>Schneidrichtung</b> Cutting direction							
<b>Schneidstoff</b> Material							HSS
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>3</sub> mm	d <sub>2</sub> mm	d <sub>4</sub> mm	6319	

<b>Durchmesser</b> Diameter range	<b>6319</b> <b>Anzahl der</b> <b>Schneiden</b> No. of cutting lips
1,0 mm - 5,0 mm	2
5,0 mm - 10,0 mm	3

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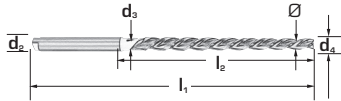


## Kegel-Schälreibahnen mit Zylinderschaft, aus HSS

### Kegel 1 : 50, für Kegelstifte nach DIN 1, nur für Maschinengebrauch

High spiral fluted taper pin reamers with straight shank, made of HSS

taper 1 : 50, to produce holes for taper pins acc. to DIN 1, for machine use only



<b>Form / Form</b>							-
<b>Typ / Type</b>							Schneiden 45° LH
<b>Schneidrichtung</b> Cutting direction							
<b>Schneidstoff</b> Material							HSS
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	d <sub>3</sub> mm	d <sub>4</sub> mm	6313	
1,0	60	33	1,40	1,52	0,8	●	
1,25	70	42	1,80	1,97	1,05	●	
1,5	70	42	2,10	2,22	1,3	●	
1,6	70	42	2,10	2,22	1,3	●	
2,0	86	48	3,15	2,86	1,9	●	
2,5	86	48	3,15	3,36	2,4	●	
3,0	100	58	4,00	4,06	2,9	●	
4,0	112	68	5,00	5,26	3,9	●	
5,0	122	73	6,30	6,36	4,9	●	
6,0	160	105	8,00	8,00	5,9	●	
8,0	207	145	10,00	10,80	7,9	●	
10,0	245	175	12,50	13,40	9,9	●	
12,0	290	210	16,00	16,00	11,8	●	

<b>Form / Form</b>							-
<b>Typ / Type</b>							Schneiden 45° LH
<b>Schneidrichtung</b> Cutting direction							
<b>Schneidstoff</b> Material							HSS
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	d <sub>3</sub> mm	d <sub>4</sub> mm	6313	

Für Kegelstifte nach DIN 1 - 258 - 1447 - 7977 - 7978  
For taper pin according to DIN 1 - 258 - 1447 - 7977 - 7978

<b>Diametri</b> Diameter range	<b>6313</b> <b>Anzahl der Schneiden</b> No. of cutting lips
1,0 mm - 5,0 mm	2
6,0 mm - 10,0 mm	3
12,0 mm	4

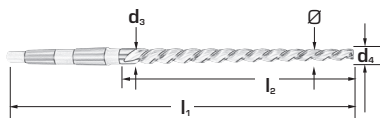
● Standardartikel



## Kegel-Schälreibahnen mit Zylinderschaft, aus HSS

### Kegel 1 : 50, für Kegelstifte nach DIN 1, nur für Maschinengebrauch

High spiral fluted taper pin reamers with Morse taper shank, made of HSS  
 taper 1 : 50, to produce holes for taper pins acc. to DIN 1, for machine use only



<b>Form / Form</b>							-
<b>Typ / Type</b>							Schneiden 45° LH
<b>Schneidrichtung</b> Cutting direction							
<b>Schneidstoff</b> Material							HSS
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>4</sub> mm	d <sub>3</sub> mm	MK MT	6314	
5	155	73	4,9	6,36	1	●	
6	187	105	5,9	8,00	1	●	
8	227	145	7,9	10,80	1	●	
10	257	175	9,9	13,40	1	●	
12	315	210	11,8	16,00	2	●	
16	335	230	15,8	20,40	2	●	
20	377	250	19,8	24,80	3	●	

<b>Form / Form</b>							-
<b>Typ / Type</b>							Schneiden 45° LH
<b>Schneidrichtung</b> Cutting direction							
<b>Schneidstoff</b> Material							HSS
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>4</sub> mm	d <sub>3</sub> mm	MK MT	6314	

<b>Durchmesser</b> Diameter range	<b>6314</b> Anzahl der Schneiden No. of cutting lips
3,0 mm - 6,0 mm	2
6,0 mm - 10,0 mm	3
12,0 mm - 20,0 mm	4

● Standardartikel

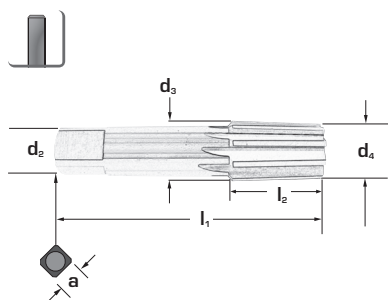


## Kegel-Reibahlen mit Zylinderschaft, aus HSS Kegel 1 : 16

Taper reamers with straight shank, made of HSS taper 1 : 16

Kernloch **NPT - NPTF**

Geradegenutet / Straight Flutes



**Form / Form**

**Typ / Type**

**Schneidrichtung**  
Cutting direction

**Schneidstoff**  
Material

-  
Schneiden  
gerade  
straight  
  
HSS

Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	d <sub>2</sub> mm	d <sub>3</sub> mm	d <sub>4</sub> mm	a h11	Z	
1/16"	70	17	6	6,998	5,935	4,5	6	●
1/8"	70	17	8	9,105	8,042	6,3	6	●
1/4"	80	27	11	11,996	10,308	9,0	6	●
3/8"	85	27	12	15,416	13,728	10,0	8	●
1/2"	95	35	16	19,126	16,938	12,5	8	●
3/4"	105	35	20	24,411	22,253	16,0	10	●
1"	130	43	25	30,684	27,996	20,0	10	●
1 1/4"	140	44	32	39,471	36,721	25,0	12	●
1 1/2"	150	45	36	45,604	42,791	28,0	12	●
2"	160	46	48	57,678	54,803	35,5	14	●

● Standardartikel / Items available ex stock

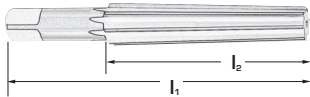






## Kegel-Reibahlen mit Zylinderschaft, aus HSS Fertigreibahlen für Morsekegel nach DIN 228

Morse taper socket reamers, made of HSS  
finishing for taper sleeves acc. to DIN 228



Form / Form			C	-
Typ / Type			Schneiden gerade straight	Schneiden 7-8° LH
Schneidrichtung Cutting direction				
Schneidstoff Material			HSS	HSS
MK MT	L <sub>1</sub> mm	L <sub>2</sub> mm	6317	6312
0	93	61	●	●
1	102	66	●	●
2	121	79	●	●
3	146	96	●	●
4	146	119	●	●
5	222	150	●	●
6	300	208	●	●

Form / Form			C	-
Typ / Type			Schneiden gerade straight	Schneiden 7-8° LH
Schneidrichtung Cutting direction				
Schneidstoff Material			HSS	HSS
MK MT	L <sub>1</sub> mm	L <sub>2</sub> mm	6317	6312

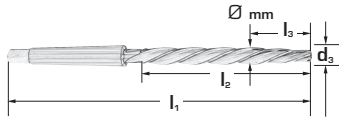
Durchmesser Diameter range		6317 Anzahl der Schneiden No. of cutting lips	6312 Anzahl der Schneiden No. of cutting lips
MK/MT	0 ÷ 1	6	6
CM/MT	2	8	8
CM/MT	3	10	10
CM/MT	4	12	12
CM/MT	5	14	14
CM/MT	6	16	16

● Standardartikel / Items available ex stock



## Nietloch-Reibahlen mit Morsekegel, aus HSS Anschnittlänge etwa 1/3 der Schneidlänge, kurzer Drall

Helicoidal fluted bridge reamers with Morse taper shank, made of HSS tapered over 1/3 of cutting length, quick spiral flutes



Form / Form							-
Typ / Type							Schneiden 25° LH
Schneidrichtung Cutting direction							
Schneidstoff Material							HSS
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>3</sub> mm	d <sub>3</sub> mm	MK MT	6355	
6,4	151	75	19	4,6	1	●	
7,4	156	80	22	5,3	1	●	
8,4	161	85	25	6,0	1	●	
9,5	166	90	27	6,9	1	●	
10,0	171	95	30	7,1	1	●	
11,0	176	100	33	7,8	1	●	
12,0	199	105	39	8,2	2	●	
13,0	199	105	39	9,2	2	●	
14,0	209	115	42	9,9	2	●	
15,0	219	125	45	10,6	2	●	
16,0	229	135	48	11,4	2	●	
17,0	251	135	51	12,1	3	●	
18,0	261	145	58	12,4	3	●	
19,0	261	145	58	13,4	3	●	
20,0	271	155	62	14,0	3	●	
21,0	271	155	62	15,0	3	●	
22,0	281	165	66	15,6	3	●	
23,0	281	165	66	16,6	3	●	
24,0	296	180	72	17,0	3	●	
25,0	296	180	72	18,0	3	●	

Form / Form							-
Typ / Type							Schneiden 25° LH
Schneidrichtung Cutting direction							
Schneidstoff / Material							HSS
Ø mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>3</sub> mm	d <sub>3</sub> mm	MK MT	6355	
26,0	296	180	72	19,0	3	●	
27,0	311	195	78	19,4	3	●	
28,0	311	195	78	20,4	3	●	
29,0	311	195	78	21,4	3	●	
30,0	311	195	78	22,4	3	●	
31,0	326	210	84	22,8	3	●	
32,0	354	210	84	23,8	4	●	

<b>Durchmesser</b> Diameter range	<b>6355</b> Anzahl der Schneiden No. of cutting lips
6,4 mm - 24,0 mm	4
25,0 mm - 32,0 mm	5

Zwischenmaße Preise auf Anfrage / Deviating sizes prices upon request

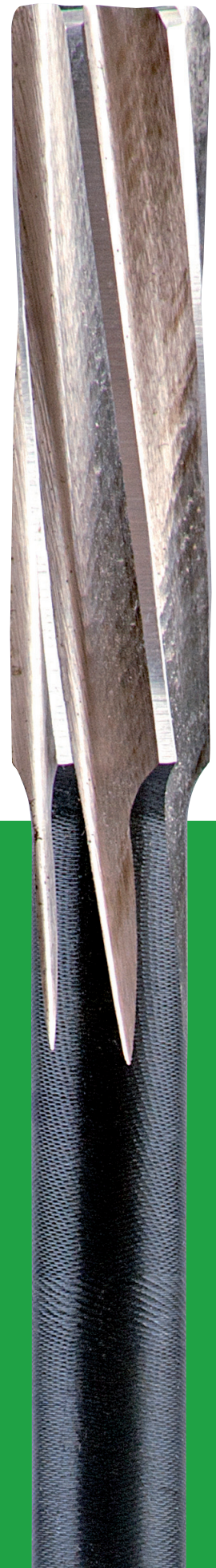
● Standardartikel / Items available ex stock





# Reibahlen

Reamers



► **Technische Daten**  
Technical Guide

# TECHNISCHE DATEN

## TECHNICAL DATA



Typ Type		660		660		660		660		660		660	
ILIX Typ-siehe Seite Ilix Type -See page		660		660		660		660		660		660	
DIN		206				859				9			
Form Form		A		B		A		B		A		B	
Schneidrichtung Cutting direction													
Schneidstoff Material		HSS		HSS		HSS		HSS		HSS		HSS	
Spitzenwinkel Point angle		0°		7/8° SX		0		7/8°		0°		7/8°	
Beschichtung Coating		BL		BL		BL		BL		BL		TF	
Innenliegende Kühlkanäle Internal Coolant		-		-		-		-		-		-	
		6301		6302		6306		6309		6315		6304	
		VC	F*	VC	F*	VC	F*	VC	F*	VC	F*	VC	F*
<b>P</b>	< 800 N/mm <sup>2</sup>	10	1.0	10	1.0	10	1.0	10	1.0	10	1.0	10	1.0
<b>P</b>	700-1000 N/mm <sup>2</sup>	6	0.8	6	0.8	6	0.8	6	0.8	6	0.8	6	0.8
<b>P</b>	1000-1300 N/mm <sup>2</sup>	4	0.6	4	0.6	4	0.6	4	0.6	4	0.6	4	0.6
<b>M</b>	Austenitisch	3	0.8	3	0.8	3	0.8	3	0.8	3	0.8	3	0.8
<b>M</b>	Austenitisch / ferritisch	2	0.6	2	0.6	2	0.6	2	0.6	2	0.6	2	0.6
<b>K</b>	GG	10	1.1	10	1.1	10	1.1	10	1.1	10	1.1	10	1.1
<b>K</b>	GGG	6	1.2	6	1.2	6	1.2	6	1.2	6	1.2	6	1.2
<b>N</b>	Aluminium	13	1.6	13	1.6	13	1.6	13	1.6	13	1.6	13	1.6
<b>N</b>	NE-Metalle	8	1.4	8	1.4	8	1.4	8	1.4	8	1.4	8	1.4
<b>S</b>	Titan	-	-	-	-	-	-	-	-	-	-	-	-
<b>S</b>	Sonderlegierungen basiert auf Ni	-	-	-	-	-	-	-	-	-	-	-	-
<b>H</b>	Gehärteter Stahl 38 / 48 HRC	-	-	-	-	-	-	-	-	-	-	-	-
<b>H</b>	Gehärteter Stahl 48 / 58 HRC	-	-	-	-	-	-	-	-	-	-	-	-
<b>H</b>	Gehärteter Stahl 58 / 68 HRC	-	-	-	-	-	-	-	-	-	-	-	-

# TECHNISCHE DATEN

## TECHNICAL DATA



660		660		662		662		662		662		662		662	
204		204		8089		212		208		219		212		212	
C		C		B/D		A/C		A		A		B/D		B/D	
HSS		HSS		HSS-CO		HSS-CO		HSS-CO		HSS		HSS-CO		HSS-CO	
0°		7/8°		7/8°		0°		0°		0°		7/8°		7/8°	
TX		BL		BL		BL		BL		BL		BL		TN	
-		-		-		-		-		-		-		-	
6317		6312		6324		6321		6333		6361		6326 6226C		6326 TN	
VC	F*	VC	F*	VC	F*	VC	F*	VC	F*	VC	F*	VC	F*	VC	F*
10	1.0	10	1.0	12	1.0	12	1.0	12	1.0	10	1.0	12	1.0	12	1.0
6	0.8	6	0.8	8	0.8	8	0.8	8	0.8	6	0.8	8	0.8	8	0.8
4	0.6	4	0.6	6	0.6	6	0.6	6	0.6	4	0.6	6	0.6	6	0.6
3	0.8	3	0.8	5	0.8	5	0.8	5	0.8	3	0.8	5	0.8	5	0.8
2	0.6	2	0.6	3	0.6	3	0.6	3	0.6	2	0.6	3	0.6	3	0.6
10	1.1	10	1.1	12	1.1	12	1.1	12	1.1	10	1.1	12	1.1	12	1.1
6	1.2	6	1.2	8	1.2	8	1.2	8	1.2	6	1.2	8	1.2	8	1.2
13	1.6	13	1.6	15	1.6	15	1.6	15	1.6	13	1.6	15	1.6	15	1.6
8	1.4	8	1.4	10	1.4	10	1.4	10	1.4	8	1.4	10	1.4	10	1.4
-	-	-	-	2	0.6	2	0.6	2	-	-	-	2	0.6	2	0.6
-	-	-	-	2	0.6	2	0.6	2	-	-	-	2	0.6	2	0.6
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

# TECHNISCHE DATEN

## TECHNICAL DATA



Typ Type		6337		6360		6325		6335		6362		6307	
ILIX Typ-siehe Seite Ilix Type -See page		662		662		664		664		664		664	
DIN		<b>208</b>		<b>219</b>		<b>212</b>		<b>208</b>		<b>219</b>		<b>ILIX NORM.</b>	
Form Form		B		B		E		C		C		A	
Schneidrichtung Cutting direction													
Schneidstoff Material		HSS-CO		HSS		HSS-CO		HSS-CO		HSS		HSS	
Spitzenwinkel Point angle		7/8°		7/8°		45°		45°		45°		0°	
Beschichtung Coating		BL		BL		BL		BL		BL		BL	
Innenliegende Kühlkanäle Internal Coolant		-		-		-		-		-		-	
		VC	F*	VC	F*	VC	F*	VC	F*	VC	F*	VC	F*
<b>P</b>	< 800 N/mm <sup>2</sup>	12	1.0	10	1.0	12	1.0	12	1.0	10	1.0	10	1.0
<b>P</b>	700-1000 N/mm <sup>2</sup>	8	0.8	6	0.8	8	0.8	8	0.8	6	0.8	6	0.8
<b>P</b>	1000-1300 N/mm <sup>2</sup>	6	0.6	4	0.6	6	0.6	6	0.6	4	0.6	4	0.6
<b>M</b>	Austenitisch	5	0.8	3	0.8	5	0.8	5	0.8	3	0.8	3	0.8
<b>M</b>	Austenitisch / ferritisch	3	0.6	2	0.6	3	0.6	3	0.6	2	0.6	2	0.6
<b>K</b>	GG	12	1.1	10	1.1	12	1.1	12	1.1	10	1.1	10	1.1
<b>K</b>	GGG	8	1.2	6	1.2	8	1.2	8	1.2	6	1.2	6	1.2
<b>N</b>	Aluminium	15	1.6	13	1.6	15	1.6	15	1.6	13	1.6	13	1.6
<b>N</b>	NE-Metalle	10	1.4	8	1.4	10	1.4	10	1.4	8	1.4	8	1.4
<b>S</b>	Titan	2	0.6	-	-	2	0.6	2	0.6	-	-	-	-
<b>S</b>	Sonderlegierungen basiert auf Ni	2	0.6	-	-	2	0.6	2	0.6	-	-	-	-
<b>H</b>	Gehärteter Stahl 38 / 48 HRC	-	-	-	-	-	-	-	-	-	-	-	-
<b>H</b>	Gehärteter Stahl 48 / 58 HRC	-	-	-	-	-	-	-	-	-	-	-	-
<b>H</b>	Gehärteter Stahl 58 / 68 HRC	-	-	-	-	-	-	-	-	-	-	-	-

# TECHNISCHE DATEN

## TECHNICAL DATA



664		664		664		666		666		666		666					
2179		2180		ILIX NORM.								60-011		331			
												E		B			
HSS		HSS		HSS		HSS		HSS		HSS		HSS		HSS			
45°		45°		0°		0°		7/8°		45°		25°					
BL		BL		BL		BL		BL		BL		BL		BL			
-		-		-		-		-		-		-		-			
6313		6314		6308		6310		6311		6319		6355					
VC	F*	VC	F*	VC	F*	VC	F*	VC	F*	VC	F*	VC	F*	VC	F*		
10	1.0	10	1.0	10	1.0	10	1.0	10	1.0	10	1.0	10	1.0	10	1.0		
6	0.8	6	0.8	6	0.8	6	0.8	6	0.8	6	0.8	6	0.8	6	0.8		
4	0.6	4	0.6	4	0.6	4	0.6	4	0.6	4	0.6	4	0.6	4	0.6		
3	0.8	3	0.8	3	0.8	3	0.8	3	0.8	3	0.8	3	0.8	3	0.8		
2	0.6	2	0.6	2	0.6	2	0.6	2	0.6	2	0.6	2	0.6	2	0.6		
10	1.1	10	1.1	10	1.1	10	1.1	10	1.1	10	1.1	10	1.1	10	1.1		
6	1.2	6	1.2	6	1.2	6	1.2	6	1.2	6	1.2	6	1.2	6	1.2		
13	1.6	13	1.6	13	1.6	13	1.6	13	1.6	13	1.6	13	1.6	13	1.6		
8	1.4	8	1.4	8	1.4	8	1.4	8	1.4	8	1.4	8	1.4	8	1.4		
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-		
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-		
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-		
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-		

# TECHNISCHE DATEN

## TECHNICAL DATA



Typ Type													
ILIX Typ-siehe Seite Ilix Type -See page		666		666		666		668		668		668	
DIN		ILIX NORM.											
Form Form		-											
Schneidrichtung Cutting direction													
Schneidstoff Material		HSS		HSS		VHM		VHM		VHM		VHM	
Spitzenwinkel Point angle		12°		0°		0°		12°		12°		12°	
Beschichtung Coating		BL		BL		BL		TN		TN		BL	
Innenliegende Kühlkanäle Internal Coolant		-		-		-		-		-			
		6318		6303		6369		6372 6372C		6372TN		6370 6371	
		VC	F*	VC	F*	VC	F*	VC	F*	VC	F*	VC	F*
<b>P</b>	< 800 N/mm <sup>2</sup>	10	1.0	10	1.0	20	1.2	20	1.2	20	1.2	20	1.2
<b>P</b>	700-1000 N/mm <sup>2</sup>	6	0.8	6	0.8	15	1.0	15	1.0	15	1.0	15	1.0
<b>P</b>	1000-1300 N/mm <sup>2</sup>	4	0.6	4	0.6	10	0.8	10	0.8	10	0.8	10	0.8
<b>M</b>	Austenitisch	3	0.8	3	0.8	10	1.0	10	1.0	10	1.0	10	1.0
<b>M</b>	Austenitisch / ferritisch	2	0.6	2	0.6	7	0.8	7	0.8	7	0.8	7	0.8
<b>K</b>	GG	10	1.1	10	1.1	20	1.4	20	1.4	20	1.4	20	1.4
<b>K</b>	GGG	6	1.2	6	1.2	15	1.2	15	1.2	15	1.2	15	1.2
<b>N</b>	Aluminium	13	1.6	13	1.6	30	1.8	30	1.8	30	1.8	30	1.8
<b>N</b>	NE-Metalle	8	1.4	8	1.4	25	1.6	25	1.6	25	1.6	25	1.6
<b>S</b>	Titan	-	-	-	-	5	0.8	5	0.8	5	0.8	5	0.8
<b>S</b>	Sonderlegierungen basiert auf Ni	-	-	-	-	5	0.8	5	0.8	5	0.8	5	0.8
<b>H</b>	Gehärteter Stahl 38 / 48 HRC	-	-	-	-	-	-	-	-	-	-	-	-
<b>H</b>	Gehärteter Stahl 48 / 58 HRC	-	-	-	-	-	-	-	-	-	-	-	-
<b>H</b>	Gehärteter Stahl 58 / 68 HRC	-	-	-	-	-	-	-	-	-	-	-	-

# TECHNISCHE DATEN

## TECHNICAL DATA



		Cermet		Pkd											
668		668		668											
<b>ILIX NORM.</b>															
-		-		-											
VHM		CERMET		PKD											
12°		12°		0°											
BL		BL		BL											
-		-													
<b>6376</b>		<b>6323</b>		<b>6373</b>											
VC	F*	VC	F*	VC	F*										
20	1.2	50	1.2	-	-										
15	1.0	40	1.0	-	-										
10	0.8	30	0.8	-	-										
10	1.0	20	1.0	-	-										
7	0.8	15	0.8	-	-										
20	1.4	80	1.4	-	-										
15	1.2	40	1.2	-	-										
30	1.8	150	1.8	800	2.0										
25	1.6	100	1.6	200	1.8										
5	0.8	-	-	-	-										
5	0.8	-	-	-	-										
-	-	-	-	-	-										
-	-	-	-	-	-										
-	-	-	-	-	-										