

Hole Finishing

Tool Selection Guide



									standard diameter		engineered solution diameter			
			P	M	K	N	S	H	range	accuracy	range	accuracy		
reaming tools		HSR™ – Solid Carbide High-Speed Reamer Carbide	●	●	●	●	○		.196–.551" 5–14mm	IT7	.056–1.00" 1,4–25,4mm	IT6 >.39" >10mm	.0004" 10 μm	.0003" 7 μm
		HSR – Carbide Tipped High-Speed Reamer Carbide/Cermet	●	●	●	●	○		.551–1.26" 14–32mm	IT7	.551–2.55" 14–65mm	IT6	.0004" 10 μm	.0003" 7 μm
boring/fine-boring tools		ROTAFLEX™ FBHBB Fine-Boring Carbide/Cermet/PCD/CBN	●	●	●	●	●	○	.236–.866" 6–22mm	IT7	—	—	.0002" 5 μm	.0002– .0004" 5–10 μm
		ROTAFLEX FBH Fine-Boring Carbide/Cermet/PCD/CBN	●	●	●	●	●	○	.866–4.25" 22–115mm	IT7	—	—	.0002" 5 μm	.0002– .0004" 5–10 μm
		ROTAFLEX TCHS Roughing Carbide/Cermet/PCD/CBN	●	●	●	●	●		.886–4.52" 22,5–115mm	IT7	—	—	.0004" 10 μm	>.0008" >20 μm
		ROTAFLEX Small Bridge Tools Roughing Carbide/Cermet/PCD/CBN	●	●	●	●	●		3.425–7.87" 87–200mm	IT7	—	—	.0004" 10 μm	>.0008" >20 μm
		ROTAFLEX Large Bridge Tools Roughing Carbide/Cermet/PCD/CBN	●	●	●	●	●		7.87–20.47" 200–520mm	IT7	—	—	.0004" 10 μm	>.0008" >20 μm
		Fine-Boring Cartridges Fine-Boring Carbide/Cermet/PCD/CBN	●	○	●	●	○		3.425–20.47" 87–520mm	IT7	—	—	.0002" 5 μm	.0002– .0004" 5–10 μm
countersinking		Countersinking Round Tools Steel Base				●			—	—	—	IT7	.0004" 10 μm	.0004" 10 μm
		Port Cutters Carbide/Cermet Steel Base				●			for standard ports SAE, BSPP, ISO	—	—	IT7	.0004" 10 μm	.0004" 10 μm
PCD		PCD Round Tools Steel Base CBN				●			—	—	.394–4.00" 10–100mm	IT6	.0004" 10 μm	.0004" 10 μm
		PCD Round Tools Carbide Base				●			—	—	.197–1.00" 5–25mm	IT6	.0002" 5 μm	.0003" 7 μm



Cylindricity

NOTE: Process- and application-dependent.

Highly dependent on the pre-machine hole accuracy.
Use of high-performance drilling/pre-machining tools
mandatory to reach values.



Position

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