

PCD STEP REAMER

- Bearing bore $\varnothing$ 130mm.
- Tolerance range 25 μ m S6.
- Aluminium AlSi8Cu3.
- Varying depth of cut ca. 0,5–5mm.
- Machining centre with internal coolant.

- PCD tipped, steel-based tool with HSK interface and internal coolant.
- Six effective cutting and chamfering teeth in positive cutting position.

- $vc = 350$ m/min (1.148 SFM).
- $f = 0,60$ mm/rev (.024 IPR).

- Tool life increase versus previous solution.
- Surface finish Ra 0.2 μ m.

- Secure process.
- Most productive solution at large diameter.
- Very long tool life.
- Reconditionable.

CHALLENGE

SOLUTION

CUTTING DATA

RESULT

BENEFIT



Highly uneven flute design
reduces vibrations.

