

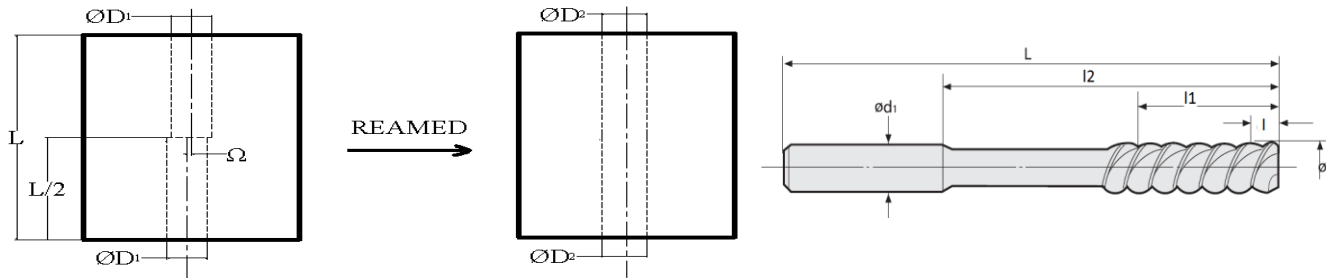
KH-SP01



SPECIAL TOOLS

CARBIDE/HSS

• **QUICK REAMERS - SOLID CARBIDE**






Code.No	Order.No	$\varnothing d_1$	$\varnothing D(H7)$	L	l	l1	l2
KHQR-2.0,2.1..to 2.5	KHQR-2.2	3.0	2.2	75	5.7	30	50
KHQR-2.6,2.7..to 3.0	KHQR-2.6	3.0	2.6	80	5.7	35	54
KHQR-3.1,3.2..to 3.5	KHQR-3.4	6.0	3.4	100	5.7	35	70
KHQR-3.6 to 4.0	KHQR-4.0	6.0	4.0	100	5.7	35	70
KHQR-4.1 to 4.5	KHQR-4.2	6.0	4.2	100	5.7	35	70
KHQR-4.5 to 5.0	KHQR-4.78	6.0	4.78	100	5.7	35	70
KHQR-5.0 to 6.0	KHQR-5.78	6.0	5.78	130	5.7	35	100
KHQR-6.0 to 7.0	KHQR-6.78	8.0	6.78	130	5.7	35	100
KHQR-7.0- to 8.0	KHQR-7.78	8.0	7.78	150	5.7	35	120
KHQR-8.0- to 9.0	KHQR-8.78	10.0	8.78	150	5.7	35	120
KHQR-9.0- to 10.0	KHQR-9.78	10.0	9.78	150	5.7	35	120

Will be made by the special order.

CUTTING DATA

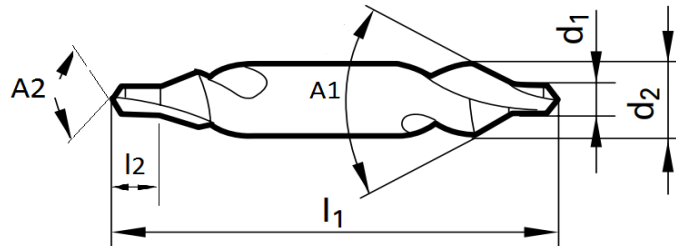
Material	Cutting speed	Feed (mm/re)					
		$\varnothing 2-\varnothing 3.0$	$\varnothing 3.0-\varnothing 4.0$	$\varnothing 4.0-\varnothing 5.0$	$\varnothing 5.0-\varnothing 6.0$	$\varnothing 6-\varnothing 7.0$	$\varnothing 8-\varnothing 10$
Steels < 500 N/mm ²	30-50	0.04-0.16	0.08-0.2	0.12-0.25	0.15-0.3	0.15-0.32	0.17-0.35
Steels < 500-700 N/mm ²	30-40	0.04-0.16	0.08-0.2	0.12-0.25	0.15-0.3	0.15-0.32	0.17-0.35
Aluminum < 500 N/mm ³	70-80	0.04-0.16	0.08-0.2	0.12-0.25	0.15-0.3	0.15-0.32	0.17-0.35
Steels < 500-700 N/mm ³	30-35	0.04-0.16	0.08-0.2	0.12-0.25	0.15-0.3	0.15-0.32	0.17-0.35
Corpper ,Brass	-	-	-	-	-	-	-
Plastic	-	-	-	-	-	-	-

• **CHAMFER MILL - SOLID CARBIDE**

CHAMFER MILL	A_p max	Steels < 500 N/mm ²	Steels < 500-700 N/mm ²	Aluminum < 500 N/mm ³	Steels < 500-700 N/mm ³	Stainless steel	Corpper ,Brass
OD : 25 ID : 15 Length : 20 Code: JC2536 	Roughing 5.0C	••	••	•	••	•	•
OD : 25 ID : 15 Length : 20 Code: JC2536M 	Midium 3.0C	••	••	•	••	•	•
OD : 25 ID : 15 Length : 20 Code: JC2536F 	Finishing 1.5C	••	••	•	••	•	•

• Used for the machine - JAM JC2536

• STEP DRILL - SOLID CARBIDE



Code.No	Order.No	$\varnothing d1$	$\varnothing d2$	A1	A2	l1	l2
KHSD-2.0 to 3.0	#1 LTII/LTI	2.80	6.0	60°	90°	50.0	1.2
KHSD-3.0 to 4.0	#2 LTII/LTI	3.45	6.0	60°	90°	50.0	1.2
KHSD-4.0 to 5.0	#3 LTII/LTI	4.70	6.0	60°	90°	50.0	1.6
KHSD-5.0 to 6.0	#4 LTII/LTI	5.20	6.0	60°	90°	60.0	1.6
KHSD-6.0 to 7.0	#5 LTII/LTI	6.75	8.0	60°	90°	60.0	1.6
KHSD-7.0 to 8.0		-	-	-	-	-	-
KHSD-8.0 to 9.0	#9 LTII/LTI	8.40	10.0	60°	90°	70.0	1.6
KHSD-9.0 to 10.0		-	-	-	-	-	-

Will be made by the special order.

CUTTING DATA

Material	Cutting speed	Feed (mm/re)					
		$\varnothing 2-\varnothing 3.0$	$\varnothing 3.0-\varnothing 4.0$	$\varnothing 4.0-\varnothing 5.0$	$\varnothing 5.0-\varnothing 6.0$	$\varnothing 6-\varnothing 7.0$	$\varnothing 8-\varnothing 10$
Steels < 500 N/mm ²	30-50	0.04-0.16	0.08-0.2	0.12-0.25	0.15-0.3	0.15-0.32	0.17-0.35
Steels < 500-700 N/mm ²	30-40	0.04-0.16	0.08-0.2	0.12-0.25	0.15-0.3	0.15-0.32	0.17-0.35
Aluminum < 500 N/mm ³	70-80	0.04-0.16	0.08-0.2	0.12-0.25	0.15-0.3	0.15-0.32	0.17-0.35
Steels < 500-700 N/mm ³	30-35	0.04-0.16	0.08-0.2	0.12-0.25	0.15-0.3	0.15-0.32	0.17-0.35
Corpper ,Brass	-	-	-	-	-	-	-
Plastic	-	-	-	-	-	-	-

