

Adjustable Expanding Hand Reamers Type K

Application:

The precision reamer for inline reaming of holes.

Design:

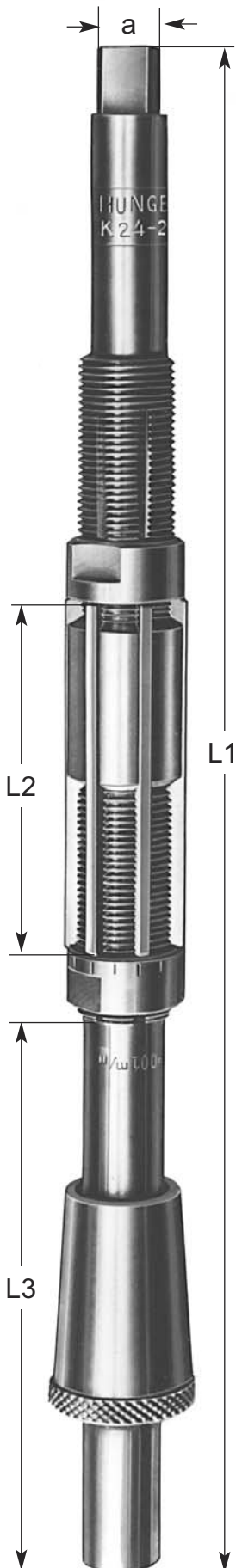
Righth-hand cutting reamer with expanding blades.

Parallel shank with square at the back and integral pilot with sliding cone bush at the front of the reamer.

Due to the unique Hunger relief grinding operation the blades have a progressively increasing clearance angle giving a softer cutting action.

Starting with size K 12 the adjusting nut is marked with a circular scale.

One graduation of the scale corresponds to an alteration of the reaming diameter by 0,01 mm.



| Size | Size Range | | Length Overall L1 mm | Length Blades L2 mm | Length Pilot L3 mm | Size of Square a mm | No. of Blades | Weight kg |
|---------------|-------------|-------------------|-------------------------|------------------------|-----------------------|------------------------|---------------|--------------|
| | mm | Inches | | | | | | |
| K 7 | 7 - 8 | 9/32 - 5/16 | 175 | 32 | 65 | 3,5 | 4 | 0,030 |
| K 8 | 8 - 9 | 5/16 - 23/64 | 175 | 32 | 65 | 4,3 | 5 | 0,055 |
| K 9 | 9 - 10 | 23/64 - 25/64 | 175 | 32 | 65 | 4,3 | 5 | 0,060 |
| K 10 | 10 - 11 | 25/64 - 7/16 | 185 | 35 | 68 | 4,9 | 5 | 0,085 |
| K 11 | 11 - 12 | 7/16 - 15/32 | 195 | 35 | 72 | 6,2 | 5 | 0,100 |
| K 12 | 12 - 13,5 | 15/32 - 17/32 | 215 | 42 | 84 | 6,2 | 5 | 0,130 |
| K 13,5 | 13,5 - 15,5 | 17/32 - 39/64 | 235 | 50 | 89 | 7 | 5 | 0,180 |
| K 15,5 | 15,5 - 18 | 39/64 - 45/64 | 265 | 60 | 98 | 8 | 5 | 0,280 |
| K 18 | 18 - 21 | 45/64 - 53/64 | 290 | 65 | 109 | 9 | 5 | 0,410 |
| K 21 | 21 - 24 | 53/64 - 15/16 | 310 | 70 | 119 | 10 | 5 | 0,620 |
| K 24 | 24 - 27,5 | 15/16 - 1 5/64 | 335 | 75 | 129 | 11 | 5 | 0,820 |
| K 27,5 | 27,5 - 31,5 | 1 5/64 - 1 15/64 | 365 | 80 | 137 | 12 | 6 | 1,040 |
| K 31,5 | 31,5 - 37 | 1 15/64 - 1 29/64 | 400 | 90 | 159 | 14,5 | 6 | 1,550 |
| K 37 | 37 - 45 | 1 29/64 - 1 49/64 | 465 | 100 | 180 | 16 | 6 | 2,600 |
| K 45 | 45 - 55 | 1 49/64 - 2 5/32 | 530 | 109 | 198 | 20 | 6 | 4,100 |
| K 55 | 55 - 65 | 2 5/32 - 2 9/16 | 570 | 120 | 213 | 24 | 8 | 6,450 |
| K 65 | 65 - 80 | 2 9/16 - 3 5/32 | 670 | 145 | 250 | 29 | 10 | 15,100 |
| K 80 | 80 - 95 | 3 5/32 - 3 47/64 | 700 | 150 | 250 | 32 | 10 | 21,100 |
| K 95 | 95 - 110 | 3 47/64 - 4 21/64 | 700 | 150 | 250 | 36 | 10 | 25,400 |

Packing of the reamers:

From size K 7 to K 37 individually in clear plastic tube containers.

From size K 45 to K 55 individually in plastic nets.

From size K 65 to K 95 individually in wooden boxes.

Sets of Reamers Type K in Wooden Cases

| Symbol | Size Range | | No. of Reamers | Weight kg |
|------------|------------|-----------------|----------------|--------------|
| | mm | Inches | | |
| KAN | 8 - 31,5 | 21/64 - 1 15/64 | 11 | 5,600 |
| KEN | 8 - 45 | 21/64 - 1 49/64 | 13 | 10,200 |

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Order Information:

The reamers are fitted with blades made from high quality special steel to ensure superior cutting efficiency.

The production of reamers with hard chromium coated blades and of hard chromium coated replacement blades has been discontinued.
Remainders of stock are available as long as stock last.

| Size | Size Range mm | Reamers | | Replacement Blades* | | Nuts Part No. | Cone Bushes Part No. |
|---------------|---------------|------------------------|------------------------|------------------------|------------------------|---------------|----------------------|
| | | Special Steel Part No. | Hard Chromium Part No. | Special Steel Part No. | Hard Chromium Part No. | | |
| K 7 | 7 - 8 | 120 07 000 | 121 07 000 | 100 06 400 | 101 06 400 | 140 04 510 | 120 07 600 |
| K 8 | 8 - 9 | 120 08 000 | 121 08 000 | 120 08 400 | 121 08 400 | 100 08 510 | 120 08 600 |
| K 9 | 9 - 10 | 120 09 000 | 121 09 000 | 120 09 400 | 121 09 400 | 100 09 510 | 120 09 600 |
| K 10 | 10 - 11 | 120 10 000 | 121 10 000 | 120 10 400 | 121 10 400 | 100 10 510 | 120 10 600 |
| K 11 | 11 - 12 | 120 11 000 | 121 11 000 | 120 11 400 | 121 11 400 | 100 11 510 | 120 11 600 |
| K 12 | 12 - 13,5 | 120 12 000 | 121 12 000 | 120 12 400 | 121 12 400 | 100 12 520 | 120 12 600 |
| K 13,5 | 13,5 - 15,5 | 120 13 000 | 121 13 000 | 120 13 400 | 121 13 400 | 100 13 520 | 120 13 600 |
| K 15,5 | 15,5 - 18 | 120 15 000 | 121 15 000 | 120 15 400 | 121 15 400 | 100 15 520 | 120 15 600 |
| K 18 | 18 - 21 | 120 18 000 | 121 18 000 | 120 18 400 | 121 18 400 | 100 18 520 | 120 18 600 |
| K 21 | 21 - 24 | 120 21 000 | 121 21 000 | 120 21 400 | 121 21 400 | 100 21 520 | 120 21 600 |
| K 24 | 24 - 27,5 | 120 24 000 | 121 24 000 | 120 24 400 | 121 24 400 | 100 24 520 | 120 24 600 |
| K 27,5 | 27,5 - 31,5 | 120 27 000 | 121 27 000 | 120 27 400 | 121 27 400 | 100 27 520 | 120 27 600 |
| K 31,5 | 31,5 - 37 | 120 31 000 | 121 31 000 | 120 31 400 | 121 31 400 | 100 31 520 | 120 31 600 |
| K 37 | 37 - 45 | 120 37 000 | 121 37 000 | 120 37 400 | 121 37 400 | 100 37 520 | 120 37 600 |
| K 45 | 45 - 55 | 120 45 000 | 121 45 000 | 120 45 400 | 121 45 400 | 100 45 520 | 120 45 600 |
| K 55 | 55 - 65 | 120 55 000 | 121 55 000 | 120 55 400 | 121 55 400 | 100 55 520 | 120 55 600 |
| K 65 | 65 - 80 | 120 65 000 | 121 65 000 | 100 65 400 | 101 65 400 | 100 65 520 | 120 65 600 |
| K 80 | 80 - 95 | 120 80 000 | 121 80 000 | 100 80 400 | 101 80 400 | 100 80 520 | 120 80 600 |
| K 95 | 95 - 110 | 120 95 000 | 121 95 000 | 100 95 400 | 101 95 400 | 100 95 520 | 120 95 600 |

* Replacement blades are furnished in matched sets.
The blades are finish-ground and, therefore, no grinding is needed after the blades have been inserted in the reamer body.

Sets of Reamers Type K in Wooden Cases

| Symbol | Size Range mm | Special Steel Part No. | Hard Chromium Part No. |
|------------|---------------|------------------------|------------------------|
| KAN | 8 - 31,5 | 120 00 100 | 121 00 100 |
| KEN | 8 - 45 | 120 00 200 | 121 00 200 |



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