

EXCLUSIVELINE®

HR 500 ACTIVE Cutting rates on the highest level

Tools with **bold** feed column no.
are preferred choice.

Tool material/carbide grade

Carb./K10

Form

Reamer- Ø mm	Feed column no.						
	71	72	73	74	75	76	77
	f (mm/rev.)						
< 4.00	0.080	0.100	0.125	0.300	0.500	0.800	1.000
4.00	0.100	0.125	0.160	0.300	0.500	1.000	1.200
5.00	0.100	0.125	0.160	0.400	0.600	1.000	1.400
6.30	0.125	0.160	0.200	0.400	0.700	1.200	1.600
8.00	0.160	0.200	0.250	0.600	1.000	1.800	2.400
10.00	0.200	0.250	0.315	0.600	1.200	1.800	2.400
12.50	0.200	0.250	0.315	0.800	1.200	2.000	2.500
16.00	0.250	0.315	0.400	0.800	1.400	2.200	2.600
20.00	0.315	0.400	0.500	0.800	1.400	2.200	2.600
25.00	0.400	0.500	0.630	1.000	1.600	2.500	3.000
31.50	0.400	0.500	0.630	1.000	2.000	3.000	3.600
40.00	0.500	0.630	0.800	1.200	2.000	3.000	3.600
50.00	0.630	0.800	1.000	1.400	2.200	3.200	3.600
> 50.00	0.800	1.000	1.250	1.600	2.200	3.200	3.600

For an optimal cooling lubricant supply to
HR 500 type D reamer cutting edges for through
holes we recommend clamping in hydraulic or
shrink fit chucks to the maximum clamping depth.

○ bright

● TiAlN

Coolant:

○ soluble oil

● neat oil

○ air



Material group	Material examples, new description (old description in brackets) <i>Figures in bold = material no. to DIN EN 10 027</i>	Tensile strength N/mm ²	Cool- ant	Sur- face	V _c m/min	FC no.
Common structural steels	1.0035 S185, 1.0486 StE P275N, 1.0345 P235GH, 1.0425 P265GH 1.0050 E295, 1.0070 E360, 1.8937 P500NH	≤500 >500-850	○ ○	● ●	120-250 120-250	75-76 75-76
Free-cutting steels	1.0718 11SMnPb30, 1.0736 115Mn37 1.0727 46 S20, 1.0728 60 S20, 1.0757 46SPb20	≤850 850-1000	○ ○	● ●	120-250 120-250	75-76 75-76
Unalloyed heat-treatable steels	1.0402 C22, 1.1178 C30E 1.0503 C45, 1.1191 C45E 1.0601 C60, 1.1221 C60E	≤ 700 700-850 850-1000	○ ○ ○	● ● ●	120-250 120-250 120-250	75-76 75-76 75-76
Alloyed heat-treatable steels	1.5131 50MnSi4, 1.7003 38Cr2, 1.7030 28Cr4 1.5710 36NiCr6, 1.7035 41Cr4, 1.7225 42CrMo4	850-1000 1000-1200	○ ○	● ●	120-250 120-250	75-76 75-76
Unalloyed case hardened steels	1.0301 C10, 1.1121 C10E	≤750	○	●	120-250	75-76
Alloyed case hardened steels	1.7043 38Cr4 1.5752 14NiCr14, 1.7131 16MnCr5, 1.7264 20CrMo5	850-1000 1000-1200	● ●	● ●	120-250 120-250	75-76 75-76
Nitriding steels	1.8504 34CrAl6 1.8519 31CrMoV9, 1.8550 34CrAlNi7	≥850-1000 1000-1200	○ ●	● ●	120-250 120-250	75-76 75-76
Tool steels	1.1750 C75W, 1.2067 102Cr6, 1.2307 29CrMoV9 1.2080 X210Cr12, 1.2083 X42Cr13, 1.2419 105WCr6, 1.2767 X45NiCrMo4	≤850 850-1000	○ ●	● ●	120-250 120-250	75-76 75-76
High speed steels	1.3243 S 6-5-2-5, 1.3343 S 6-5-2, 1.3344 61CrV4	≥650-1000	●	●	60-120	75-76
Spring steels	1.5026 55Si7, 1.7176 55Cr3, 1.8159 51CrV4	≥330 HB	●	●	30-60	73-74
Stainless steels, sulphured austenitic martensitic	1.4005 X12CrS13, 1.4104 X14CrMoS17, 1.4105 X6CrMoS17, 1.4305 1.4301 X5CrNi18 10, 1.4541 X6CrNiTi18 10, 1.4571 X6CrNiMoTi 17 12 2 1.4057 X17CrNi16-1, 1.4122 X39CrMo17-1, 1.4521 X2CrMoTi18 2	≤850 ≤850 ≤850	● ● ●	● ● ●	60-120 40-80 60-120	74-75 74-75 74-75
Hardened steels	-	≤40-48 HRC >48-62 HRC	● ●	● ●	40-60 30-60	73-74 73-74
Special alloys	Nimonic, Inconel, Monel, Hastelloy	≤1200	●	●	40-60	74-75
Cast iron	0.6010 EN-GJL-100 (GG10) 0.6020 EN-GJL-200 (GG20) 0.6025 EN-GJL-250 (GG25) 0.6035 EN-GJL-350 (GG35)	≤240 HB <300 HB	○ ○	● ●	60-140 60-140	75-76 75-76
Spheroidal graphite and malleable cast iron	0.7050 EN-GJS-500-7 (GGG50) 0.8035 EN-GJMW-350-4 (GTW5) 0.7070 EN-GJS-700-2 (GGG70) 0.8170 EN-GJMB-700-2 (GTS70)	≤240 HB <300 HB	○ ○	● ●	120-250 60-120	75-76 75-76
Chilled cast iron	-	≤350 HB	○	●	30-50	74-75
Ti and Ti-alloys	3.7024 Ti99.5, 3.7114 TiAl5Sn2.5, 3.7124 TiCu2 3.7154 TiAl6Zr5, 3.7164 TiAl6V4, 3.7184 TiAl4Mo4Sn2.5, -TiAl8Mo1V1	≤850 850-1200	● ●	○ ○	30-80 30-80	74-75 74-75
Aluminium and Al-alloys	3.0255 Al99.5, 3.2315 AlMgSi1, 3.3515 AlMg1	≤400	○	○		
Al-wrought alloys		≤450	○	○		
Al-cast alloys ≤ 10 % Si > 10 % Si	3.2131 G-AlSi5Cu1, 3.2153 G-AlSi7Cu3, 3.2573 G-AlSi9 3.2581 G-AlSi12, 3.2583 G-AlSi12Cu, - G-AlSi12CuNiMg	≤600 ≤600	○ ○	○ ○		
Magnesium-alloys	MgMn2, G-MgAl8Zn1, G-MgAl6Zn3	≤450	○	○	80-160	75-76
Copper, low-alloyed	2.0070 SE-Cu, 2.1020 CuSn6, 2.1096 G-CuSn5Zn5Pb	≤400	○	○		
Brass, short-chipping long-chipping	2.0380 CuZn39Pb2, 2.0401 CuZn39Pb3, 2.0410 CuZn43Pb2 2.0250 CuZn20, 2.0280 CuZn3, 2.0332 CuZn37Pb0.5	≤600 ≤600	○ ○	● ●	100-250	75-76
Bronze, short-chipping	2.1090 CuSn7Zn5Pb, 2.1170 CuPb5Sn5, 2.1176 CuPb10Sn 2.0790 CuNi18Zn19Pb	≤600 >600-850	○ ●	● ●	100-250 100-250	75-76 75-76
Bronze, long-chipping	2.0916 CuAl5, 2.0960 CuAl9Mn, 2.1050 CuSn10 2.0980 CuAl11Ni, 2.1247 CuBe2	≤850 850-1000	● ●	○ ○		
Duroplastics	Bakelite, Resopal, Pertinax, Moltopren		○	●	80-200	75-76
Thermoplastics	Plexiglass, Hostalen, Novodur, Makralon		○	○	80-200	75-76
Kevlar			○	○	80-200	75-76
Glass/carbon fibre reinf. plastics	GFP/CFP		○	○	80-200	75-76