

Solid carbide HPC reamers Type 156

HPC
LINE

Reamers convince with their production safety, quality and reliability.

The extremely unequal pitch enables vibration free machining of bores at an economically high feed rate.

botek[®]

DEEP HOLE DRILLING SYSTEMS
SOLID CARBIDE TOOLS

- 156-05 – Solid carbide HPC reamer 6 cutting edges with internal cooling for blind hole
- 156-06 – Solid carbide HPC reamer 6 cutting edges with internal cooling for through hole
- 156-07 – Solid carbide HPC reamer 6 cutting edges for internal cooling via cooling grooves on the clamping shank
- 156-08 – Solid carbide HPC reamer 6 cutting edges without internal cooling

DC	DCON (h6)	OAL	LH	LU	Z	Order number			
						Type 156-05	Type 156-06	Type 156-07	Type 156-08
4	6	75	12	40	6	750002100	750002200	750002300	750002400
5	6	75	12	40	6	750002101	750002201	750002301	750002401
6	6	75	12	40	6	750002102	750002202	750002302	750002402
8	8	100	16	65	6	750002103	750002203	750002303	750002403
10	10	120	20	75	6	750002104	750002204	750002304	750002404
12	12	120	20	75	6	750002105	750002205	750002305	750002405
14	14	130	22	85	6	750002106	750002206	750002306	750002406
16	16	150	25	100	6	750002107	750002207	750002307	750002407
18	18	150	25	100	6	750002108	750002208	750002308	750002408
20	20	150	25	100	6	750002109	750002209	750002309	750002409

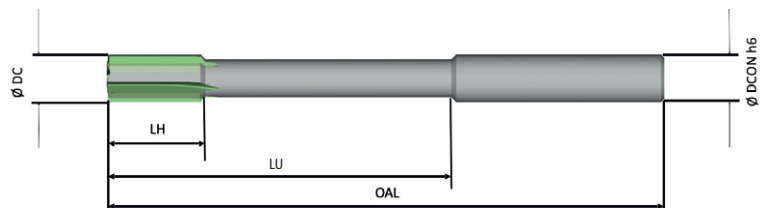
Special dimensions on request

DC= Cutting- \varnothing / +0.005 | DCON = Shank diameter h6 | OAL = Functional length | LH = Cutting edge length | LU = Usable length | Z = Number of cutting edges

Features:

HA	HPC		XT	
extremely unequal tooth pitch	Type 156		through hole	blind hole

for bore quality H7



Nose grind shapes			Material								
Cuts	Positive cut	Cut angle	P1	P2	M	K1	K2	N	S1	S2	TI
1	↓	45°	■	■	■	■	■	■	■	■	■
2*	↓	45°/8°	■	■	■	■	■	■	■	■	■
3*	↓	30°/2°								■	
4*	↓	75°	■	■	■	■	■	■	■	■	■
5*	↓ ↓ ↓	90°/0.2 x 45°	■	■	■	■	■	■	■	■	■

*on request

ISO Code	Material
P1	Steel < 1000 N/mm ²
P2	Steel > 1000 N/mm ²
M	Corrosion and acid resistant steel
K1	Cast iron
K2	Ductile iron
N	Non-ferrous metals
S1	Super-alloys (Inconel, Hasteloy)
S2	Titanium alloys
TI	Hard material

- ↓ Basic drilling quality
- ↓ ↓ ↓ more precise position accuracy of the reamed bore
- Main application
- Secondary application / Alternative