

Application values
Solid carbide TiAlN high-performance reamer (Art. no. 1013524 101-117)



Material groups for cutting values	Strength Class [N/mm ²]	Description regarding DIN	Vc [m/min]	1-5	5-8	8-12	12-16	16-20
6. Hard materials								
6.1 Hardened steel -55 HRC	-55HRC	x40CrMoV5-1	8-12	0.05-0.08	0.08-0.12	0.12-0.15	0.15-0.16	0.16-0.19
6.2 Hardened steel -65 HRC	<65HRC	90MnCrV8	7-10	0.05-0.08	0.08-0.12	0.12-0.15	0.15-0.16	0.16-0.19

