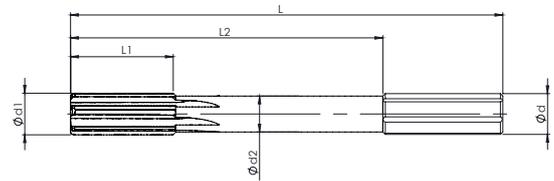




UMT 5005 Z-6

Solid carbide reamers with left hand helix, right hand cut and irregular teeth developed for the machining of through holes in all kinds of materials.



**nano
TEC1**

| d1 (+0,004) | L1 | L2 | d2 | d (h6) | L | Stock | ART No |
|-------------|----|-----|------|--------|-----|-------|-----------------|
| 9.95 | 20 | 68 | 7.8 | 10 | 108 | o | 5005099510800-1 |
| 10.95 | 22 | 73 | 8.8 | 12 | 118 | o | 5005109511800-1 |
| 11.95 | 24 | 73 | 9.8 | 12 | 118 | o | 5005119511800-1 |
| 13.95 | 28 | 79 | 11.8 | 14 | 124 | o | 5005139512400-1 |
| 15.95 | 40 | 120 | 13.8 | 16 | 165 | o | 5005159516500-1 |
| 17.95 | 44 | 168 | 15.8 | 18 | 216 | o | 5005179521600-1 |
| 19.95 | 44 | 80 | 17.8 | 20 | 130 | o | 5005199513000-1 |

- In stock
- Produced to order only

Recommended cutting conditions for reamers 5005

| Work material | Cutting speed Vc (m/min) | d1 - diameter in mm | | | | | | f - feed per revolution in mm/rev. |
|--|--------------------------|---------------------|-----------|-----------|-----------|-----------|-----------|------------------------------------|
| | | ø10 | ø12 | ø14 | ø16 | ø18 | ø20 | |
| | nanoTEC1 | | | | | | | |
| P Carbon steel and Alloy steel < 25 HRC | 25-30 | 0.18-0.25 | 0.20-0.30 | 0.22-0.32 | 0.24-0.34 | 0.26-0.36 | 0.28-0.38 | |
| Alloy steel and Tool steel 25-45 HRC | 20-25 | 0.08-0.12 | 0.08-0.12 | 0.10-0.14 | 0.11-0.15 | 0.12-0.16 | 0.13-0.17 | |
| M Stainless steel | 20-25 | 0.15-0.20 | 0.15-0.20 | 0.16-0.22 | 0.17-0.23 | 0.18-0.24 | 0.20-0.26 | |
| K Cast iron GG | 25-30 | 0.22-0.28 | 0.24-0.30 | 0.26-0.32 | 0.28-0.34 | 0.30-0.36 | 0.32-0.38 | |
| Nodular cast iron GGG | 20-30 | 0.20-0.25 | 0.22-0.28 | 0.24-0.30 | 0.24-0.32 | 0.25-0.34 | 0.26-0.35 | |

For high alloyed steels (> 12% Cr), INOX, titanium alloys, cutting speed must be reduced by 20-30% when used emulsion