

Adjustable Reamers Type D

Application Range

The standard reamer for repair and assembly jobs.

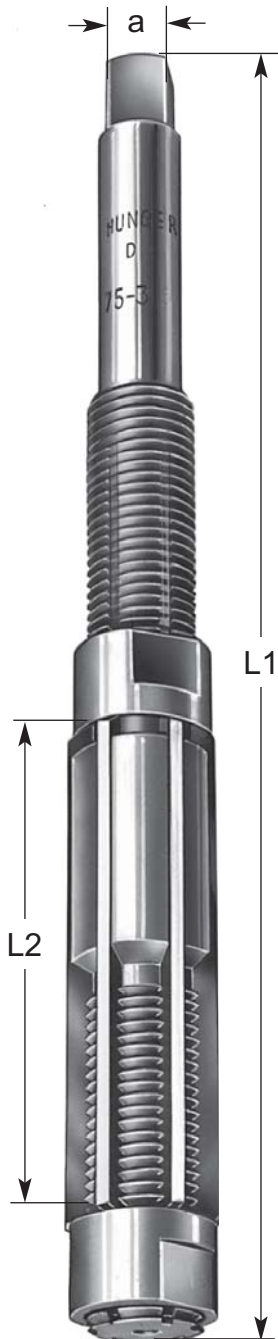
Description

Right-hand cutting reamer with expanding blades.

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

From size D 12 the front adjusting nut is marked with a circumferential scale.

One graduation on the scale corresponds to a 0,01 mm change in cutting diameter.



Size	Size Range		Length Overall L1 mm	Length Blades L2 mm	Size of Square a mm	No. of Blades	Weight kg
	mm	Inches					
D 6,4	6,4 - 7,2	1/4 - 9/32	111	32	3	4	0,010
D 7,2	7,2 - 8	9/32 - 5/16	111	32	3,5	4	0,020
D 8	8 - 9	5/16 - 23/64	111	32	4,3	5	0,026
D 9	9 - 10	23/64 - 25/64	115	32	4,3	5	0,030
D 10	10 - 11	25/64 - 7/16	120	35	4,9	5	0,048
D 11	11 - 12	7/16 - 15/32	125	35	6,2	5	0,060
D 12	12 - 13,5	15/32 - 17/32	130	42	6,2	5	0,075
D 13,5	13,5 - 15,5	17/32 - 39/64	145	50	7	5	0,090
D 15,5	15,5 - 18	39/64 - 45/64	165	60	8	5	0,160
D 18	18 - 21	45/64 - 53/64	180	65	9	5	0,220
D 21	21 - 24	53/64 - 15/16	190	70	10	5	0,330
D 24	24 - 27,5	15/16 - 1 5/64	205	75	11	5	0,445
D 27,5	27,5 - 31,5	1 5/64 - 1 15/64	225	80	12	6	0,620
D 31,5	31,5 - 37	1 15/64 - 1 29/64	240	90	14,5	6	0,890
D 37	37 - 45	1 29/64 - 1 49/64	285	100	16	6	1,450
D 45	45 - 55	1 49/64 - 2 5/32	320	109	20	6	2,360
D 55	55 - 65	2 5/32 - 2 9/16	350	120	24	8	3,720
D 65	65 - 80	2 9/16 - 3 5/32	460	145	29	10	9,200
D 80	80 - 95	3 5/32 - 3 47/64	490	150	32	10	13,500
D 95	95 - 110	3 47/64 - 4 21/64	490	150	36	10	17,400

Packing of the reamers:

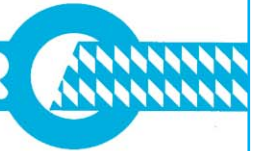
From size D 6,4 to D 45 individually in clear plastic tubes.

Size D 55 in a plastic net.

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

Sets of Reamers Type D in Wooden Cases

Symbol	Size Range		No. of Reamers	Weight kg
	mm	Inches		
DAN	8 - 31,5	21/64 - 1 15/64	11	3,300
DEN	8 - 45	21/64 - 1 49/64	13	6,000



Adjustable Reamers Type D - Standard Version and Hard Chrome Version

The blades of the standard reamers type D are made of a special steel with excellent cutting properties.

Hunger has also manufactured a "hard chrome" version in which the blades are coated with hard chrome. The hard chrome coating has a low coefficient of friction.

Hard chrome reamers are therefore particularly suitable for reaming materials with a high wear tendency and materials that tend to stick and form built-up edges.

Hard chrome reamers and hard chrome replacement blades have been discontinued. Remaining stocks of nearly all reamer sizes are available while supplies last.

As an advanced alternative to the hard chrome version, Hunger now offers the DLC version, in which the blades are coated with diamond-like carbon (DLC), See page 3 for details.

Ordering Information

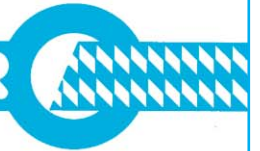
Size	Size Range mm	Reamers		Replacement Blades*		Spare Nuts Part No.
		Special Steel Part No.	Hard Chrome Part No.	Special Steel Part No.	Hard Chrome Part No.	
D 6,4	6,4 - 7,2	100 06 000	101 06 000	100 06 400	101 06 400	140 02 510
D 7,2	7,2 - 8	100 07 000	101 07 000	100 06 400	101 06 400	140 04 510
D 8	8 - 9	100 08 000	101 08 000	100 08 400	101 08 400	100 08 510
D 9	9 - 10	100 09 000	101 09 000	100 09 400	101 09 400	100 09 510
D 10	10 - 11	100 10 000	101 10 000	100 10 400	101 10 400	100 10 510
D 11	11 - 12	100 11 000	101 11 000	100 11 400	101 11 400	100 11 510
D 12	12 - 13,5	100 12 000	101 12 000	100 12 400	101 12 400	100 12 520
D 13,5	13,5 - 15,5	100 13 000	101 13 000	100 13 400	101 13 400	100 13 520
D 15,5	15,5 - 18	100 15 000	101 15 000	100 15 400	101 15 400	100 15 520
D 18	18 - 21	100 18 000	101 18 000	100 18 400	101 18 400	100 18 520
D 21	21 - 24	100 21 000	101 21 000	100 21 400	101 21 400	100 21 520
D 24	24 - 27,5	100 24 000	101 24 000	100 24 400	101 24 400	100 24 520
D 27,5	27,5 - 31,5	100 27 000	101 27 000	100 27 400	101 27 400	100 27 520
D 31,5	31,5 - 37	100 31 000	101 31 000	100 31 400	101 31 400	100 31 520
D 37	37 - 45	100 37 000	101 37 000	100 37 400	101 37 400	100 37 520
D 45	45 - 55	100 45 000	101 45 000	100 45 400	101 45 400	100 45 520
D 55	55 - 65	100 55 000	101 55 000	100 55 400	101 55 400	100 55 520
D 65	65 - 80	100 65 000	101 65 000	100 65 400	101 65 400	100 65 520
D 80	80 - 95	100 80 000	101 80 000	100 80 400	101 80 400	100 80 520
D 95	95 - 110	100 95 000	101 95 000	100 95 400	101 95 400	100 95 520

*Replacement blades are supplied in matched sets.

Sets of Reamers Type D in Wooden Cases

Symbol	Size Range mm	Special Steel Part No.	Hard Chrome Part No.
DAN	8 - 31,5	100 00 100	101 00 100
DEN	8 - 45	100 00 200	101 00 200





Adjustable Reamers Type D - Version DLC

The blades of the reamers type D version DLC are coated with a diamond-like hard material layer, which is applied by a complex PVD process.

The DLC coating is characterized by extreme hardness, wear resistance and smoothness (very low friction). At the same time, the sharpness of the cutting edges is maintained because the DLC coating is extremely thin.

The DLC version of the reamers type is therefore ideal for reaming aluminum alloys, titanium alloys, copper alloys (bronze and brass) as well as materials with a high wear effect and materials that tend to stick and form built-up edges.

Ordering Information

^D Size	Size Range mm	Reamers DLC Part No.	Replacement Blades* DLC Part No.	Sprare Nuts Part No.
D 6,4	6,4 - 7,2	108 06 000	108 06 400	140 02 510
D 7,2	7,2 - 8	108 07 000	108 06 400	140 04 510
D 8	8 - 9	108 08 000	108 08 400	100 08 510
D 9	9 - 10	108 09 000	108 09 400	100 09 510
D 10	10 - 11	108 10 000	108 10 400	100 10 510
D 11	11 - 12	108 11 000	108 11 400	100 11 510
D 12	12 - 13,5	108 12 000	108 12 400	100 12 520
D 13,5	13,5 - 15,5	108 13 000	108 13 400	100 13 520
D 15,5	15,5 - 18	108 15 000	108 15 400	100 15 520
D 18	18 - 21	108 18 000	108 18 400	100 18 520
D 21	21 - 24	108 21 000	108 21 400	100 21 520
D 24	24 - 27,5	108 24 000	108 24 400	100 24 520
D 27,5	27,5 - 31,5	108 27 000	108 27 400	100 27 520
D 31,5	31,5 - 37	108 31 000	10831 400	100 31 520
D 37	37 - 45	108 37 000	108 37 400	100 37 520
D 45	45 - 55	108 45 000	108 45 400	100 45 520
D 55	55 - 65	108 55 000	108 55 400	100 55 520
D 65	65 - 80	108 65 000	108 65 400	100 65 520
D 80	80 - 95	108 80 000	108 80 400	100 80 520
D 95	95 - 110	108 95 000	108 95 400	100 95 520

* Replacement blades are supplied in matched sets.

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