REIBAHLEN
REAMERS

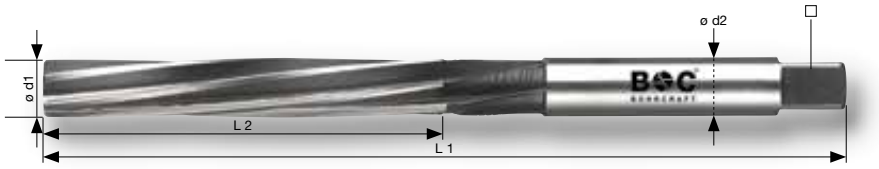
	DIN	Qualität Quality	Form	Bezeichnung Description	Code	Seite Page
Reibahlen / Reamers						
	206	HSS	B	Handreibahlen Hand reamers	1670	**161**
	9	HSS	B	Hand-Kegelreibahlen Taper hand reamers	1671	**162**
	311	HSS		Nietloch-Reibahlen MK Taper shank bridge reamers	1672	**163**
	212	HSS-E Co5	B/D	Maschinen-Reibahlen Machine reamers	1673	**164**
	212	HSS-E Co5	C	NC Maschinen-Reibahlen NC Machine reamers	1674	**165**
	208	HSS-E Co5	B	Maschinen-Reibahlen MK Taper shank machine reamers	1675	**166**

Anwendungsempfehlung für Reibahlen
Application recommendation for reamers

DIN		206	9	311	212	212	208
Schneidstoff Cutting material		HSS	HSS	HSS	HSS-E Co5	HSS-E Co5	HSS-E Co5
Form		B	B	-	B/D	C	B
Drallwinkel Helix angle		7 – 9°	7°	25°	7 – 9°	45°	7°
Toleranz Tolerance		H7	H7	H11	H7	H7	H7
Schaft Shank		zyl. cyl.	zyl. cyl.	MK MT	zyl. cyl.	zyl. cyl.	MK MT
Bereich Range		4 – 30 mm	4 – 20 mm	10 – 30 mm	3 – 20 mm	3 – 20 mm	10 – 30 mm
Qualität Quality		★★★★	★★★★	★★★★	★★★★	★★★★	★★★★
Code		1670	1671	1672	1673	1674	1675
Seite Page		161	162	163	164	165	166
P	1.1	●	●	●	●	●	●
	2.1	●	●	●	●	●	●
	3.1	◐	◐	◐	◐	◐	◐
	4.1	◐	◐	◐	◐	◐	◐
	5.1						
M	1.1 – 2.1				◐	◐	◐
	3.1 – 4.1						
K	1.1 – 1.2	●	●	●	●	●	●
	2.1 – 2.2	●	●	●	●	●	●
	3.1 – 3.2						
	4.1 – 4.2	●	●	●	●	●	●
N	1.1 – 1.3			●	●	●	●
	1.4 – 1.5						
	1.6						
	2.1 – 2.2			●	●	●	●
	2.3 – 2.6			●	●	●	●
	4.1 – 4.2	◐	◐	◐	◐	◐	◐
S	1.1 – 1.3				◐	◐	◐
	2.1 – 2.6				◐	◐	◐

● geeignet / suitable ◐ bedingt geeignet / limited suitable

Handreibahlen DIN 206 Form B HSS
Hand reamers DIN 206 form B HSS



Code **1670**

DIN 206 | HSS | FORM B | 45° | L 7-9° | R | Tol. H7

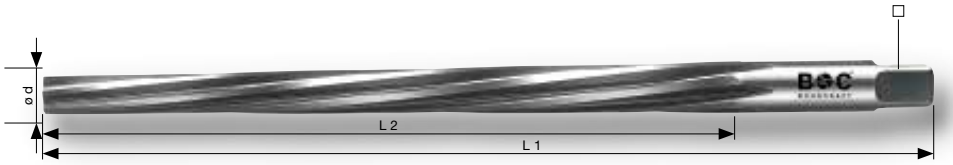
Code	P			M	K	N			S
	1.1 – 2.1	3.1 – 4.1	5.1	1.1 – 4.1	1.1 – 2.2 / 4.1 – 4.2	1.1 – 1.3	2.1 – 2.6	4.1 – 4.2	1.1 – 2.6
1670	●	●			●	●		●	

Zum Reiben von Durchgangsbohrungen in Eisen, NE-Metallen, harten und weichen Kunststoffen.
Nicht für die Bearbeitung von Sacklöchern geeignet.

For reaming of through holes in ferrous and non-ferrous materials, hard and soft plastic.
Not suitable for blind holes.

Ø d1 mm	L 1 mm	L 2 mm	Ø d2 mm	□ mm	Zähne Teeth		Artikel-Nr. Part-No.
4	76	38	4	3,0	4	1	1670 03 00400
5	87	44	5	3,8	6	1	1670 03 00500
6	93	47	6	4,9	6	1	1670 03 00600
7	107	54	7	5,5	6	1	1670 03 00700
8	115	58	8	6,2	6	1	1670 03 00800
9	124	62	9	7,0	6	1	1670 03 00900
10	133	66	10	8,0	6	1	1670 03 01000
11	142	71	11	9,0	8	1	1670 03 01100
12	152	76	12	9,0	8	1	1670 03 01200
14	163	81	14	11,0	8	1	1670 03 01400
16	175	87	16	12,0	8	1	1670 03 01600
18	188	93	18	14,5	8	1	1670 03 01800
20	201	100	20	16,0	8	1	1670 03 02000
22	215	107	22	18,0	8	1	1670 03 02200
24	231	115	24	20,0	8	1	1670 03 02400
25	231	115	25	20,0	8	1	1670 03 02500
26	231	115	26	20,0	8	1	1670 03 02600
28	247	124	28	22,0	8	1	1670 03 02800
30	247	124	30	24,0	8	1	1670 03 03000

Hand-Kegelreibahlen DIN 9 Form B HSS
Taper hand reamers DIN 9 form B HSS



Code **1671**

DIN 9 | HSS | FORM B | L 7° | R | Tol. H7 | 1:50

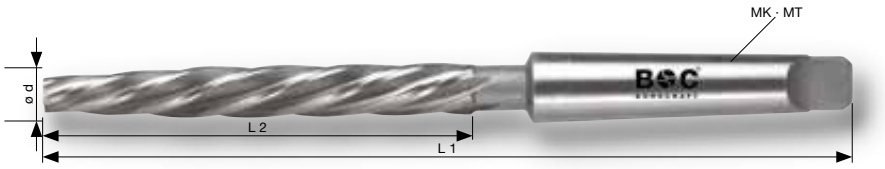
Code	P			M	K	N			S
	1.1 – 2.1	3.1 – 4.1	5.1	1.1 – 4.1	1.1 – 2.2 / 4.1 – 4.2	1.1 – 1.3	2.1 – 2.6	4.1 – 4.2	1.1 – 2.6
1671	●	●			●	●		●	

Zum Reiben konischer Bohrungen für Kegelstifte in Eisen, NE-Metallen, harten und weichen Kunststoffen.

For reaming taper pin holes in ferrous and non-ferrous materials, hard and soft plastic.

Ø d mm	L 1 mm	L 2 mm	Ø min. mm	Ø max. mm	□ mm	Zähne Teeth		Artikel-Nr. Part-No.
4	93	67	3,9	5,25	3,8	4	1	1671 03 00400
5	100	73	4,9	6,36	4,9	6	1	1671 03 00500
6	135	105	5,9	8,00	6,2	6	1	1671 03 00600
8	180	145	7,9	10,80	8,0	6	1	1671 03 00800
10	215	175	8,9	13,40	10,0	6	1	1671 03 01000
12	255	210	11,8	16,00	11,0	6	1	1671 03 01200
16	280	230	15,8	20,40	14,5	8	1	1671 03 01600
20	310	250	19,8	24,80	18,0	8	1	1671 03 02000

Nietloch-Reibahlen DIN 311 HSS
Bridge reamers DIN 311 HSS



Code **1672**

DIN 311 | HSS | L 25° | R | Tol. H11 | 1:10

Code	P			M	K	N			S
	1.1 – 2.1	3.1 – 4.1	5.1	1.1 – 4.1	1.1 – 2.2 / 4.1 – 4.2	1.1 – 1.3	2.1 – 2.6	4.1 – 4.2	1.1 – 2.6
1672	●	●			●	●	●	●	

Zum Korrigieren des Bohrungsversatzes übereinander angeordneter Blechteile auf den gewünschten Bohrungsdurchmesser (z.B. zum Vernieten oder Verschrauben).

For correction of the drill hole offset of superimposed plates to match the drill hole diameter required (e.g. when riveting or screwing).

Ø d mm	L 1 mm	L 2 mm	MK MT	Zähne Teeth		Artikel-Nr. Part-No.
10	171	95	1	5	1	1672 03 01000
12	199	105	2	5	1	1672 03 01200
13	199	105	2	5	1	1672 03 01300
14	209	115	2	5	1	1672 03 01400
15	219	125	2	5	1	1672 03 01500
16	229	135	2	5	1	1672 03 01600
17	251	135	3	5	1	1672 03 01700
18	261	145	3	5	1	1672 03 01800
20	271	155	3	5	1	1672 03 02000
21	271	155	3	5	1	1672 03 02100
22	281	165	3	5	1	1672 03 02200
25	296	180	3	5	1	1672 03 02500
28	311	195	3	5	1	1672 03 02800
30	311	195	3	5	1	1672 03 03000

Maschinen-Reibahlen DIN 212 Form B/D HSS-E (Co5)
Machine-reamers DIN 212 form B/D HSS-E (Co5)

Code **1673**

DIN 212 | HSS-E Co5 | FORM B/D | 45° | L 7-9° | R | Tol. H7

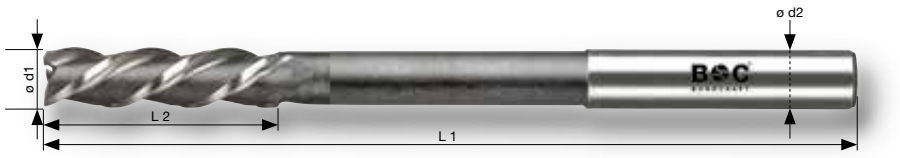
Code	P			M	K	N			S
	1.1 – 2.1	3.1 – 4.1	5.1	1.1 – 4.1	1.1 – 2.2 / 4.1 – 4.2	1.1 – 1.3	2.1 – 2.6	4.1 – 4.2	1.1 – 2.6
1673	●	●		●	●	●	●	●	●

Zum Reiben von Durchgangsbohrungen in Eisen, NE-Metallen, harten und weichen Kunststoffen.

For reaming of through holes in ferrous and non-ferrous materials, hard and soft plastic.

Ø d1 mm	L 1 mm	L 2 mm	Ø d2 mm	Zähne Teeth		Artikel-Nr. Part-No.
3	61	15	3,0	4	1	1673 03 00300
4	75	19	4,0	4	1	1673 03 00400
5	86	23	5,0	6	1	1673 03 00500
6	93	26	6,0	6	1	1673 03 00600
7	109	30	7,0	6	1	1673 03 00700
8	117	32	8,0	6	1	1673 03 00800
9	125	36	9,0	6	1	1673 03 00900
10	133	38	10,0	6	1	1673 03 01000
11	142	41	10,0	8	1	1673 03 01100
12	151	44	10,0	8	1	1673 03 01200
13	151	44	10,0	8	1	1673 03 01300
14	160	47	12,5	8	1	1673 03 01400
15	162	50	12,5	8	1	1673 03 01500
16	170	52	12,5	8	1	1673 03 01600
17	175	54	14,0	8	1	1673 03 01700
18	182	56	14,0	8	1	1673 03 01800
19	189	58	16,0	8	1	1673 03 01900
20	195	60	16,0	8	1	1673 03 02000

NC Maschinen-Reibahlen DIN 212 Form C HSS-E (Co5)
NC Machine-reamers DIN 212 form C HSS-E (Co5)



Code **1674**

DIN 212 | HSS-E Co5 | FORM C | L 45° | R | Tol. H7

Code	P			M	K	N			S
	1.1 – 2.1	3.1 – 4.1	5.1	1.1 – 4.1	1.1 – 2.2 / 4.1 – 4.2	1.1 – 1.3	2.1 – 2.6	4.1 – 4.2	1.1 – 2.6
1674	●	●		●	●	●	●	●	●

NC-gerechte Ausführung. Zum Reiben von Durchgangsbohrungen in Eisen, NE-Metallen, harten und weichen Kunststoffen.

Suitable for CNC-machines. For reaming of through holes in ferrous and non-ferrous materials, hard and soft plastic.

Ø d1 mm	L 1 mm	L 2 mm	Ø d2 mm	Zähne Teeth		Artikel-Nr. Part-No.
3	61	15	3,0	6	1	1674 03 00300
4	75	19	4,0	6	1	1674 03 00400
5	86	23	5,0	6	1	1674 03 00500
6	93	26	6,0	6	1	1674 03 00600
7	109	30	7,0	6	1	1674 03 00700
8	117	32	8,0	6	1	1674 03 00800
9	125	36	9,0	6	1	1674 03 00900
10	133	38	10,0	6	1	1674 03 01000
11	142	41	10,0	8	1	1674 03 01100
12	151	44	10,0	8	1	1674 03 01200
13	151	44	10,0	8	1	1674 03 01300
14	160	47	12,5	8	1	1674 03 01400
16	170	52	12,5	8	1	1674 03 01600
18	182	56	14,0	8	1	1674 03 01800
20	195	60	16,0	10	1	1674 03 02000

Maschinen-Reibahlen DIN 208 Form B HSS-E (Co5)
Machine-reamers DIN 208 form B HSS-E (Co5)

Code **1675**

DIN 208 | HSS-E Co5 | FORM B | 45° | L 7° | R | Tol. H7

Code	P			M	K	N			S
	1.1 – 2.1	3.1 – 4.1	5.1	1.1 – 4.1	1.1 – 2.2 / 4.1 – 4.2	1.1 – 1.3	2.1 – 2.6	4.1 – 4.2	1.1 – 2.6
1675	●	●		●	●	●	●	●	●

Zum Reiben von Durchgangsbohrungen in Eisen, NE-Metallen, harten und weichen Kunststoffen.

For reaming of through holes in ferrous and non-ferrous materials, hard and soft plastic.

Ø d mm	L 1 mm	L 2 mm	MK MT	Zähne Teeth		Artikel-Nr. Part-No.
10	168	38	1	6	1	1675 03 01000
12	182	44	1	6	1	1675 03 01200
14	189	47	1	8	1	1675 03 01400
16	210	52	2	8	1	1675 03 01600
18	219	56	2	8	1	1675 03 01800
20	228	60	2	8	1	1675 03 02000
22	237	64	2	8	1	1675 03 02200
24	268	68	3	8	1	1675 03 02400
25	268	68	3	8	1	1675 03 02500
26	273	70	3	8	1	1675 03 02600
28	277	71	3	10	1	1675 03 02800
30	281	73	3	10	1	1675 03 03000