

## Adjustable Expanding Hand Reamers Type K

### Application:

The precision reamer for inline reaming of holes. .

### Design:

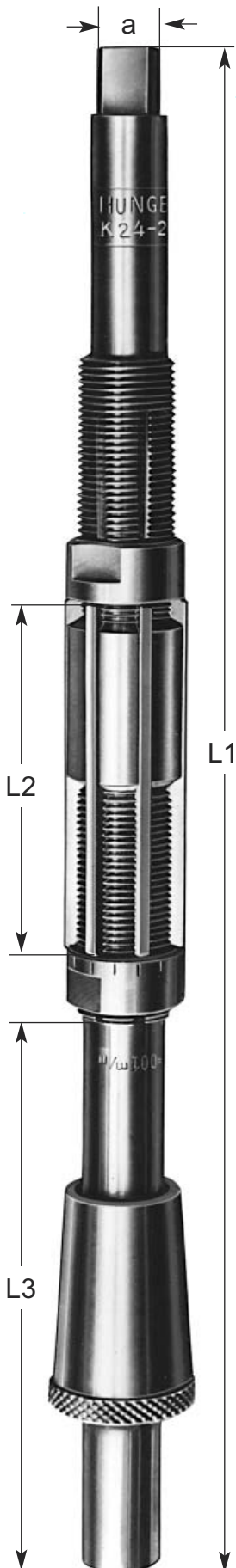
Righth-hand cutting reamer with expanding blades.

Parallel shank with square at the back and integral pilot with sliding cone bush at the front of the reamer.

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

Starting with size K 12 the adjusting nut is marked with a circular scale.

One graduation of the scale corresponds to an alteration of the reaming diameter by 0,01 mm.



Size	Size Range		Length Overall L1 mm	Length Blades L2 mm	Length Pilot L3 mm	Size of Square a mm	No. of Blades	Weight kg
	mm	Inches						
K 7	7 - 8	9/32 - 5/16	175	32	65	3,5	4	0,030
K 8	8 - 9	5/16 - 23/64	175	32	65	4,3	5	0,055
K 9	9 - 10	23/64 - 25/64	175	32	65	4,3	5	0,065
K 10	10 - 11	25/64 - 7/16	185	35	68	4,9	5	0,085
K 11	11 - 12	7/16 - 15/32	195	35	72	6,2	5	0,100
K 12	12 - 13,5	15/32 - 17/32	215	42	84	6,2	5	0,130
K 13,5	13,5 - 15,5	17/32 - 39/64	235	50	89	7	5	0,180
K 15,5	15,5 - 18	39/64 - 45/64	265	60	98	8	5	0,280
K 18	18 - 21	45/64 - 53/64	290	65	109	9	5	0,410
K 21	21 - 24	53/64 - 15/16	310	70	119	10	5	0,570
K 24	24 - 27,5	15/16 - 1 5/64	335	75	129	11	5	0,770
K 27,5	27,5 - 31,5	1 5/64 - 1 15/64	365	80	137	12	6	1,040
K 31,5	31,5 - 37	1 15/64 - 1 29/64	400	90	159	14,5	6	1,550
K 37	37 - 45	1 29/64 - 1 49/64	465	100	180	16	6	2,550
K 45	45 - 55	1 49/64 - 2 5/32	530	109	198	20	6	5,000
K 55	55 - 65	2 5/32 - 2 9/16	570	120	213	24	8	6,450
K 65	65 - 80	2 9/16 - 3 5/32	670	145	250	29	10	11,900
K 80	80 - 95	3 5/32 - 3 47/64	700	150	250	32	10	13,700
K 95	95 - 110	3 47/64 - 4 21/64	700	150	250	36	10	23,900

Packing of the reamers:

From size K 7 to K 37 individually in clear plastic tube containers.

From size K 45 to K 55 individually in plastic nets.

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

### Sets of Reamers Type K in Wooden Cases

Symbol	Size Range		No. of Reamers	Weight kg
	mm	Inches		
KAN	8 - 31,5	21/64 - 1 15/64	11	5,200
KEN	8 - 45	21/64 - 1 49/64	13	10,700

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## Order Information:

The reamers are available with standard blades made from high quality special steel to ensure superior cutting efficiency.

The reamers are also available with hard chromium coated blades.

The hard chromium coating has superior hardness in combination with a low friction coefficient.

Thus reamers of the „hard chromium“ series are particularly suitable for reaming abrasive materials and materials with a tendency to adhere to and to build-up the cutting edge.

Size	Size Range mm	Reamers		Replacement Blades*		Nuts Part No.	Cone Bushes Part No.
		Special Steel Part No.	Hard Chromium Part No.	Special Steel Part No.	Hard Chromium Part No.		
<b>K 7</b>	7 - 8	120 07 000	121 07 000	100 06 400	101 06 400	140 04 510	120 07 600
<b>K 8</b>	8 - 9	120 08 000	121 08 000	120 08 400	121 08 400	100 08 510	120 08 600
<b>K 9</b>	9 - 10	120 09 000	121 09 000	120 09 400	121 09 400	100 09 510	120 09 600
<b>K 10</b>	10 - 11	120 10 000	121 10 000	120 10 400	121 10 400	100 10 510	120 10 600
<b>K 11</b>	11 - 12	120 11 000	121 11 000	120 11 400	121 11 400	100 11 510	120 11 600
<b>K 12</b>	12 - 13,5	120 12 000	121 12 000	120 12 400	121 12 400	100 12 520	120 12 600
<b>K 13,5</b>	13,5 - 15,5	120 13 000	121 13 000	120 13 400	121 13 400	100 13 520	120 13 600
<b>K 15,5</b>	15,5 - 18	120 15 000	121 15 000	120 15 400	121 15 400	100 15 520	120 15 600
<b>K 18</b>	18 - 21	120 18 000	121 18 000	120 18 400	121 18 400	100 18 520	120 18 600
<b>K 21</b>	21 - 24	120 21 000	121 21 000	120 21 400	121 21 400	100 21 520	120 21 600
<b>K 24</b>	24 - 27,5	120 24 000	121 24 000	120 24 400	121 24 400	100 24 520	120 24 600
<b>K 27,5</b>	27,5 - 31,5	120 27 000	121 27 000	120 27 400	121 27 400	100 27 520	120 27 600
<b>K 31,5</b>	31,5 - 37	120 31 000	121 31 000	120 31 400	121 31 400	100 31 520	120 31 600
<b>K 37</b>	37 - 45	120 37 000	121 37 000	120 37 400	121 37 400	100 37 520	120 37 600
<b>K 45</b>	45 - 55	120 45 000	121 45 000	120 45 400	121 45 400	100 45 520	120 45 600
<b>K 55</b>	55 - 65	120 55 000	121 55 000	120 55 400	121 55 400	100 55 520	120 55 600
<b>K 65</b>	65 - 80	120 65 000	121 65 000	100 65 400	101 65 400	100 65 520	120 65 600
<b>K 80</b>	80 - 95	120 80 000	121 80 000	100 80 400	101 80 400	100 80 520	120 80 600
<b>K 95</b>	95 - 110	120 95 000	121 95 000	100 95 400	101 95 400	100 95 520	120 95 600

\* Replacement blades are furnished in matched sets. The blades are finish-ground and, therefore, no grinding is needed after the blades have been inserted in the reamer body.

## Sets of Reamers Type K in Wooden Cases

Symbol	Size Range mm	Special Steel Part No.	Hard Chromium Part No.
<b>KAN</b>	8 - 31,5	120 00 100	121 00 100
<b>KEN</b>	8 - 45	120 00 200	121 00 200



## Ludwig Hunger GmbH

Graefelfinger Str. 146  
81375 Munich/Germany

Tel.: +49 89 7091-0  
Fax: +49 89 7091-26

info@ludwig-hunger.de  
www.ludwig-hunger.de