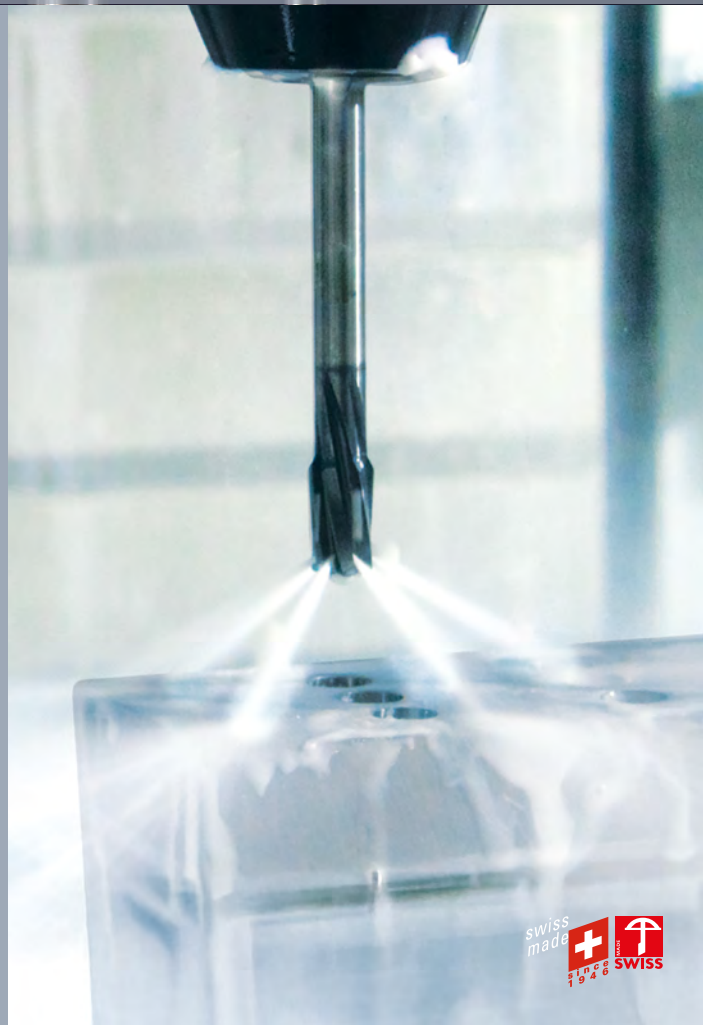
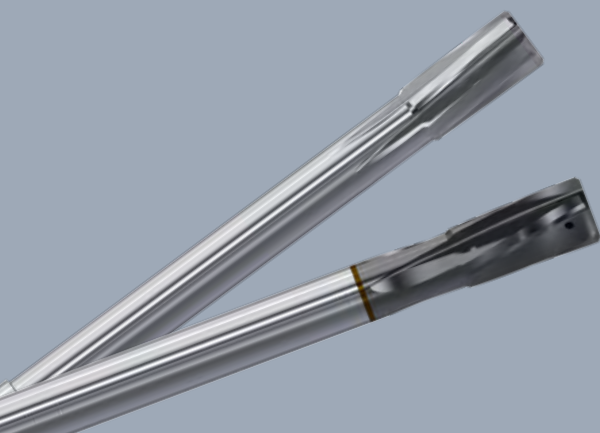


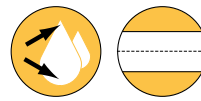


Reamers for through holes POLY 4008-FC

**Increase the quality
and productivity of
your reaming operation !**

From Ø2.50 mm to 12.03 mm.





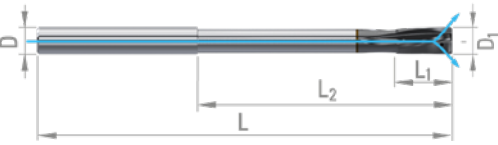
> Ø2.50

HELICAL REAMERS, LEFT-HAND HELIX
RIGHT-HAND CUT

Ref. A



Ref. B



- Solid carbide reamers with left hand helix, right hand cut, irregular teeth and coolant in the flutes developed for the machining of through holes in all kind of materials.
- Forward chip removal facilitated by the left hand helix.
- The extra smooth POLYCUT coating improves tool life even at high temperatures in difficult to machine materials.

○ good ○ excellent

ISO	P													M				K					
Materials description	Unalloyed steel					Low alloyed steel				High alloyed steel	Martensitic stainless steel			Austenitic stainless steel (DUPLIX/PH)				Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	14.4	15	16	17	18	19	20
Recommendations	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

ISO	N										S						H						
Materials description	Wrought aluminium alloy		Cast aluminium alloy			Cu + Pb alloy	Cu alloy difficult		Gold, Silver	Graphite	Plastic	Wood	Special alloy Ni / Co			Titanium, titanium alloy			Hardened steel		Hard cast iron		
VDI 3323	21	22	23	24	25	26	27	28	-	-	29	30	31	32	33-35	36	37	38	39	40	41		
Recommendations	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○				

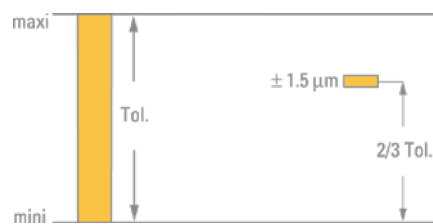
D nom. D₁ L₁ L₂ D_{h5} L Z Ref. POLYCUT
H7 ± 1.5 µm

D nom. D₁ L₁ L₂ D_{h5} L Z Ref. POLYCUT
H7 ± 1.5 µm

2.50 (2.507)	10	25	3	70	4	B	416681
2.51 (2.517)	10	25	3	70	4	B	416682
2.52 (2.527)	10	25	3	70	4	B	416683
2.53 (2.537)	10	25	3	70	4	B	416684
2.60 (2.607)	10	25	3	70	4	B	416685
2.70 (2.707)	10	25	3	70	4	B	416686
2.80 (2.807)	10	25	3	70	4	B	416687
2.90 (2.907)	10	25	3	70	4	B	416688
2.97 (2.977)	10	25	3	70	4	B	416689
2.98 (2.987)	10	25	3	70	4	B	416690
2.99 (2.997)	10	25	3	70	4	B	416691
3.00 (3.007)	10	25	3	70	4	B	416692
3.01 (3.018)	10	25	3	70	4	B	416693
3.02 (3.028)	10	25	3	70	4	B	416694
3.03 (3.038)	10	25	3	70	4	B	416695
3.10 (3.108)	10	25	3	70	4	B	416696
3.20 (3.208)	10	-	3	70	4	A	416697
3.30 (3.308)	10	-	3	70	4	A	416698
3.40 (3.408)	10	-	3	70	4	A	416699
3.50 (3.508)	10	-	3	70	4	A	416700
3.60 (3.608)	10	-	3	70	4	A	416701
3.70 (3.708)	10	-	3	70	4	A	416702
3.80 (3.808)	10	-	3	70	4	A	416703
3.90 (3.908)	10	-	3	70	4	A	416704
3.97 (3.978)	10	-	3	70	4	A	416705
3.98 (3.988)	10	-	3	70	4	A	416706
3.99 (3.998)	10	-	3	70	4	A	416707
4.00 (4.008)	10	-	3	70	4	A	416708
4.01 (4.018)	10	-	3	70	4	A	416709
4.02 (4.028)	10	-	3	70	4	A	416710

4.03 (4.038)	10	-	3	70	4	A	416711
4.50 (4.508)	12	-	4	80	4	A	416712
4.97 (4.978)	12	-	4	80	4	A	416713
4.98 (4.988)	12	-	4	80	4	A	416714
4.99 (4.998)	12	-	4	80	4	A	416715
5.00 (5.008)	12	-	4	80	4	A	416716
5.01 (5.018)	12	-	4	80	4	A	416717
5.02 (5.028)	12	-	4	80	4	A	416718
5.03 (5.038)	12	-	4	80	4	A	416719
5.50 (5.508)	12	-	4	80	4	A	416720
5.97 (5.978)	12	-	4	80	4	A	416721
5.98 (5.988)	12	-	4	80	4	A	416722
5.99 (5.998)	12	-	4	80	4	A	416723
6.00 (6.008)	12	-	4	80	4	A	416724
6.01 (6.020)	12	-	4	80	4	A	416725
6.02 (6.030)	12	-	4	80	4	A	416726
6.03 (6.040)	12	-	4	80	4	A	416727
6.50 (6.510)	16	-	6	101	6	A	416728
6.97 (6.980)	16	-	6	101	6	A	416729
6.98 (6.990)	16	-	6	101	6	A	416730
6.99 (7.000)	16	-	6	101	6	A	416731
7.00 (7.010)	16	-	6	101	6	A	416732
7.01 (7.020)	16	-	6	101	6	A	416733
7.02 (7.030)	16	-	6	101	6	A	416734
7.03 (7.040)	16	-	6	101	6	A	416735
7.50 (7.510)	16	-	6	101	6	A	416736
7.97 (7.980)	16	-	6	101	6	A	416737
7.98 (7.990)	16	-	6	101	6	A	416738
7.99 (8.000)	16	-	6	101	6	A	416739
8.00 (8.010)	16	-	6	101	6	A	416740

D nom.	D ₁	L ₁	L ₂	D _{h5}	L	Z	Ref.	POLYCUT
8.01	(8.020)	16	-	6	101	6	A	416741
8.02	(8.030)	16	-	6	101	6	A	416742
8.03	(8.040)	16	-	6	101	6	A	416743
8.50	(8.510)	16	-	8	117	6	A	416744
8.97	(8.980)	16	-	8	117	6	A	416745
8.98	(8.990)	16	-	8	117	6	A	416746
8.99	(9.000)	16	-	8	117	6	A	416747
9.00	(9.010)	16	-	8	117	6	A	416748
9.01	(9.020)	16	-	8	117	6	A	416749
9.02	(9.030)	16	-	8	117	6	A	416750
9.03	(9.040)	16	-	8	117	6	A	416751
9.50	(9.510)	16	-	8	117	6	A	421557
9.97	(9.980)	16	-	8	117	6	A	416752
9.98	(9.990)	16	-	8	117	6	A	416753
9.99	(10.000)	16	-	8	117	6	A	416754
10.00	(10.010)	16	-	8	117	6	A	416755
10.01	(10.022)	16	-	8	117	6	A	416756
10.02	(10.032)	16	-	8	117	6	A	416757
10.03	(10.042)	16	-	8	117	6	A	416758
10.50	(10.512)	19	-	10	133	6	A	416759
10.97	(10.982)	19	-	10	133	6	A	416760
10.98	(10.992)	19	-	10	133	6	A	416761
10.99	(11.002)	19	-	10	133	6	A	416762
11.00	(11.012)	19	-	10	133	6	A	416763
11.01	(11.022)	19	-	10	133	6	A	416764
11.02	(11.032)	19	-	10	133	6	A	416765
11.03	(11.042)	19	-	10	133	6	A	416766
11.50	(11.512)	19	-	10	133	6	A	416767
11.97	(11.982)	19	-	10	133	6	A	416768
11.98	(12.992)	19	-	10	133	6	A	416769
11.99	(12.002)	19	-	10	133	6	A	416770
12.00	(12.012)	19	-	10	133	6	A	416771
12.01	(12.022)	19	-	10	133	6	A	416772
12.02	(12.032)	19	-	10	133	6	A	416773
12.03	(12.042)	19	-	10	133	6	A	416774



ON REQUEST

Ø intermediate delivery within 10 days

Other coatings

Straight-flute tool



POLYCUT COATING

- New generation of dropless coatings
- Excellent adhesion, improved surface finish and ultra-precise thickness for high-quality reaming
- High wear and heat resistance

CUTTING GEOMETRY

- Geometry adapted to materials with high specific cutting forces (Ni-Co, stainless steel, inconel, etc.)
- Optimized irregular pitch for improvement circularity

APPLICATION EXAMPLE

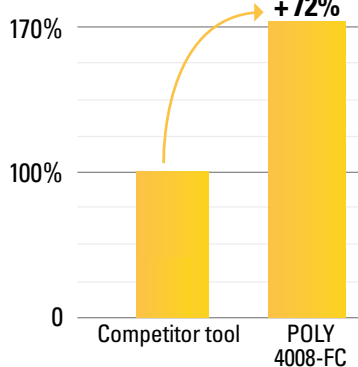
POLY 4008-FC Ø2.98 mm

Material: Steel 1.2379 (X153CrMoV12)

n = 1'399 rpm

Vf = 0.146 mm/rpm

Tool lifetime



RADIAL COOLANT IN THE FLUTES

- Improved cutting edge cooling and chip evacuation for longer service life



DIXI POLYTOOL S.A.

Av. du Technicum 37

CH - 2400 Le Locle

T. +41 (0)32 933 54 44

dixipoly@dixi.ch

www.dixipolytool.com