



Standard programme – Countersinks

EUC-Speed

BECK
MAPAL GROUP

EUC-Speed

Extremely unequally spaced countersinks

The countersinks work with significantly reduced axial forces. Their cutting edges are unevenly spaced. With the selected pitch, the axial force is reduced by more than 50 percent and the radial force by 25 percent, compared to conventional countersinks. The result: significantly less vibration on the tool.

1 Spacing extremely unequal

- Less vibration, better surface, smooth running and long tool life
- Significantly reduced axial and radial force

2 Special coating

- Long tool life, reliable and process-safe even at high cutting speeds

3 Shank form

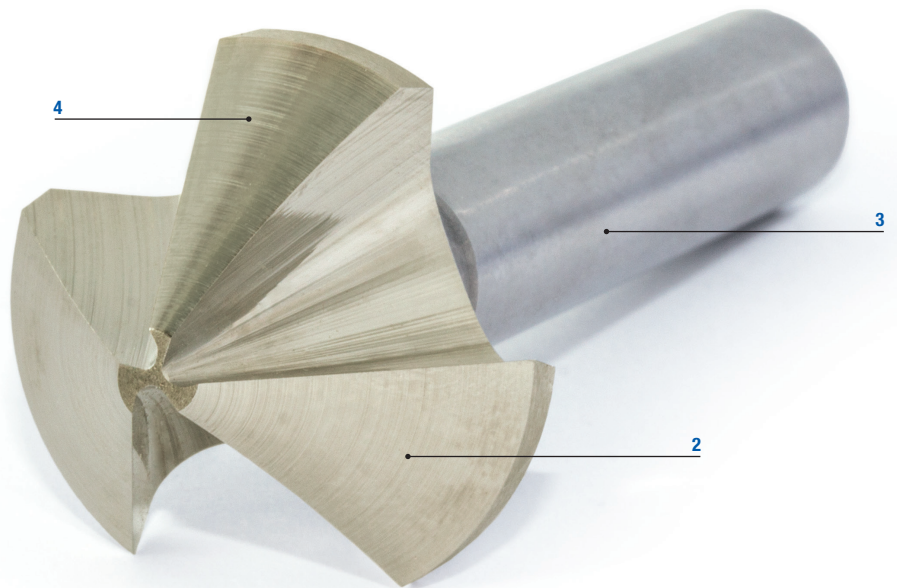
- Also available as long version and with clamping surfaces

4 Countersink angle

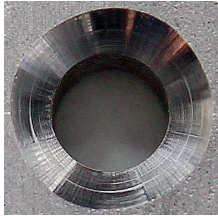
- Available as 60° and 90° versions

Universally applicable

- For the material groups **P M K N S H**



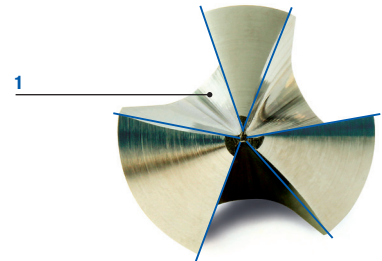
No chatter marks thanks to extremely unequal



Standard countersink



EUC-Speed

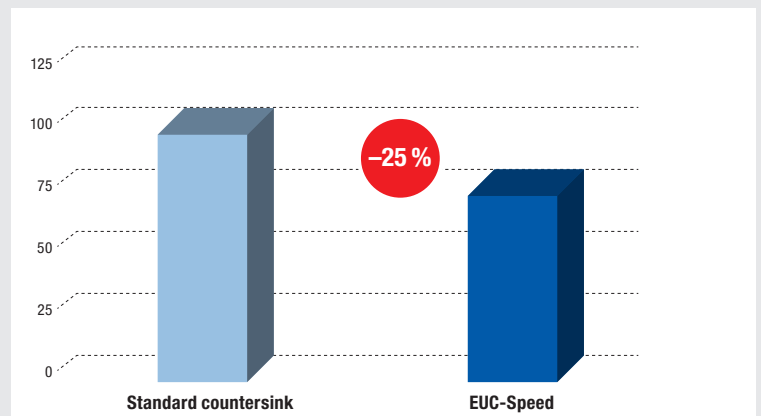


Features

Design:

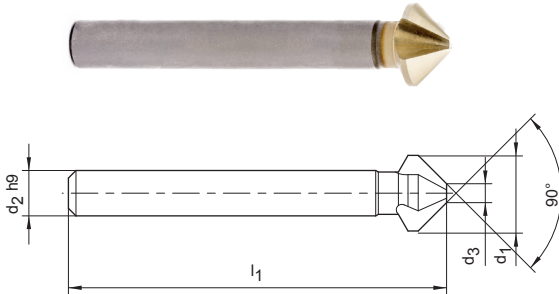
- HSS version coated
- Solid carbide version coated
- Available as long version
- In the diameter range 4.30 to 31.00 mm
- As set with and without surface
- As 60° and 90° version also with clamping surface

Radial force [N]



EUC-Speed 90°

HSS design, coated, extremely unequal spacing
B054210 | B054207



Short design, B054210 / B054207 | Preferred series in stock

| Dimensions | | | | | 90° version | | 90° version with clamping surface | |
|----------------|-------------------|----------------|----------------|---|------------------------------|-----------|-----------------------------------|-----------|
| d ₁ | d ₂ h9 | d ₃ | l ₁ | z | Specification | Order no. | Specification | Order no. |
| 4,30 | 4 | 1,3 | 40 | 3 | B05421004.3z9 EUC-SPEED 90° | 30662977 | B05420704.3z9 EUC-SPEED 90°FL | 30881866 |
| 6,00 | 5 | 1,5 | 45 | 3 | B05421006.0z9 EUC-SPEED 90° | 30662978 | B05420706.0z9 EUC-SPEED 90°FL | 30881867 |
| 6,30 | 5 | 1,5 | 45 | 3 | B05421006.3z9 EUC-SPEED 90° | 30602669 | B05420706.3z9 EUC-SPEED 90°FL | 30881868 |
| 8,00 | 6 | 2,0 | 50 | 3 | B05421008.0z9 EUC-SPEED 90° | 30662979 | B05420708.0z9 EUC-SPEED 90°FL | 30881869 |
| 8,30 | 6 | 2,0 | 50 | 3 | B05421008.3z9 EUC-SPEED 90° | 30662980 | B05420708.3z9 EUC-SPEED 90°FL | 30881870 |
| 10,00 | 6 | 2,5 | 50 | 3 | B054210010z9 EUC-SPEED 90° | 30662982 | B054207010.0z9 EUC-SPEED 90°FL | 30881871 |
| 10,40 | 6 | 2,5 | 50 | 3 | B054210010.4z9 EUC-SPEED 90° | 30602672 | B054207010.4z9 EUC-SPEED 90°FL | 30881872 |
| 11,50 | 8 | 2,8 | 56 | 3 | B054210011.5z9 EUC-SPEED 90° | 30662984 | B054207011.5z9 EUC-SPEED 90°FL | 30881873 |
| 12,40 | 8 | 2,8 | 56 | 3 | B054210012.4z9 EUC-SPEED 90° | 30662985 | B054207012.4z9 EUC-SPEED 90°FL | 30881874 |
| 15,00 | 10 | 3,2 | 60 | 3 | B054210015.0z9 EUC-SPEED 90° | 30662986 | B054207015.0z9 EUC-SPEED 90°FL | 30881875 |
| 16,50 | 10 | 3,2 | 60 | 3 | B054210016.5z9 EUC-SPEED 90° | 30602673 | B054207016.5z9 EUC-SPEED 90°FL | 30881876 |
| 19,00 | 10 | 3,5 | 63 | 3 | B054210019.0z9 EUC-SPEED 90° | 30662987 | B054207019.0z9 EUC-SPEED 90°FL | 30881877 |
| 20,50 | 10 | 3,5 | 63 | 3 | B054210020.5z9 EUC-SPEED 90° | 30602674 | B054207020.5z9 EUC-SPEED 90°FL | 30881878 |
| 23,00 | 10 | 3,8 | 67 | 3 | B054210023.0z9 EUC-SPEED 90° | 30662988 | B054207023.0z9 EUC-SPEED 90°FL | 30881879 |
| 25,00 | 10 | 3,8 | 67 | 3 | B054210025.0z9 EUC-SPEED 90° | 30602675 | B054207025.0z9 EUC-SPEED 90°FL | 30881880 |
| 31,00 | 12 | 4,2 | 71 | 3 | B054210031.0z9 EUC-SPEED 90° | 30662989 | B054207031.0z9 EUC-SPEED 90°FL | 30881881 |

Long design, B054209 | Preferred series in stock

| | | | | | | |
|-------|----|-----|-----|---|-----------------------------|----------|
| 6,30 | 5 | 1,5 | 104 | 3 | B05420906.3z9 EUC 90° long | 31006152 |
| 8,30 | 6 | 2,0 | 105 | 3 | B05420908.3z9 EUC 90° long | 31006153 |
| 10,40 | 6 | 2,5 | 107 | 3 | B054209010.4z9 EUC 90° long | 31006154 |
| 12,40 | 8 | 2,8 | 108 | 3 | B054209012.4z9 EUC 90° long | 31006155 |
| 16,50 | 10 | 3,2 | 111 | 3 | B054209016.5z9 EUC 90° long | 31006156 |
| 20,50 | 10 | 3,5 | 114 | 3 | B054209020.5z9 EUC 90° long | 31006157 |
| 25,00 | 10 | 3,8 | 118 | 3 | B054209025.0z9 EUC 90° long | 31006158 |
| 31,00 | 12 | 4,2 | 140 | 3 | B054209031.0z9 EUC 90° long | 31006159 |

Countersink sets, EUC-Speed | B054218 / B054217

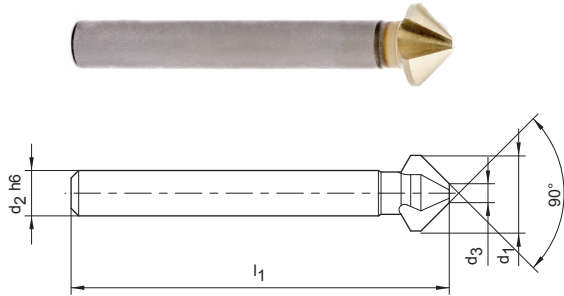
| Set | Diameter | HSS, cylindrical shank B054218 | HSS, 3 clamping surfaces B054217 |
|---------|--------------------------------------|-----------------------------------|-------------------------------------|
| | | Order no. | Order no. |
| 5-piece | 6,30 / 10,40 / 16,50 / 20,50 / 25,00 | 30602967 | 30897967 |



Dimensions in mm.
For recommended cutting values see pages 6/7.

EUC-Speed 90°

Solid carbide design, coated, extremely unequal spacing
B044210



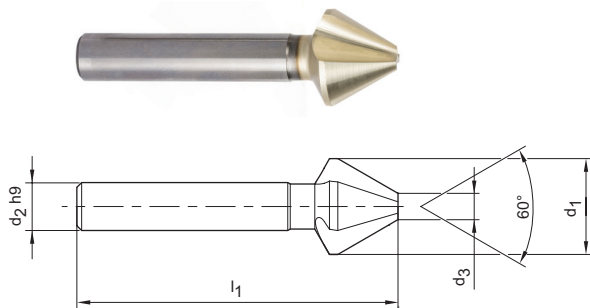
Preferred series in stock

| Dimensions | | | | | Specification | Order no. |
|----------------|-------------------|----------------|----------------|---|------------------------------|-----------|
| d ₁ | d ₂ h6 | d ₃ | l ₁ | z | | |
| 6,30 | 5 | 1,5 | 45 | 3 | B044210Ø6.3z9 EUC-SPEED VHM | 30729770 |
| 8,30 | 6 | 2,0 | 50 | 3 | B044210Ø8.3z9 EUC-SPEED VHM | 30729772 |
| 10,40 | 6 | 2,5 | 50 | 3 | B044210Ø10.4z9 EUC-SPEED VHM | 30729774 |
| 12,40 | 8 | 2,8 | 56 | 3 | B044210Ø12.4z9 EUC-SPEED VHM | 30729776 |
| 16,50 | 10 | 3,2 | 60 | 3 | B044210Ø16.5z9 EUC-SPEED VHM | 30729778 |
| 20,50 | 10 | 3,5 | 63 | 3 | B044210Ø20.5z9 EUC-SPEED VHM | 30729780 |
| 25,00 | 10 | 3,8 | 67 | 3 | B044210Ø25.0z9 EUC-SPEED VHM | 30729782 |
| 31,00 | 12 | 4,2 | 71 | 3 | B044210Ø31.0z9 EUC-SPEED VHM | 30729783 |

Dimensions in mm.
For recommended cutting values see pages 6/7.

EUC-Speed 60°

HSS design, coated, extremely unequal spacing
B054110 | B054107



B054110 / B054107 | Preferred series in stock

| Dimensions | | | | | 60° version | | 60° version with clamping surface | |
|----------------|-------------------|----------------|----------------|---|------------------------------|-----------|-----------------------------------|-----------|
| d ₁ | d ₂ h9 | d ₃ | l ₁ | z | Specification | Order no. | Specification | Order no. |
| 6,30 | 5 | 1,6 | 45 | 3 | B054110Ø6.3z9 EUC-SPEED 60° | 31051748 | B054107Ø6.3z9 EUC-SPEED 60° FL | 31051765 |
| 8,00 | 6 | 2,0 | 50 | 3 | B054110Ø8.0z9 EUC-SPEED 60° | 31051749 | B054107Ø8.0z9 EUC-SPEED 60° FL | 31051766 |
| 10,00 | 6 | 2,5 | 50 | 3 | B054110Ø10.0z9 EUC-SPEED 60° | 31051760 | B054107Ø10.0z9 EUC-SPEED 60° FL | 31051767 |
| 12,50 | 8 | 3,2 | 56 | 3 | B054110Ø12.5z9 EUC-SPEED 60° | 31051761 | B054107Ø12.5z9 EUC-SPEED 60° FL | 31051768 |
| 16,00 | 10 | 4,0 | 63 | 3 | B054110Ø16.0z9 EUC-SPEED 60° | 31051762 | B054107Ø16.0z9 EUC-SPEED 60° FL | 31051769 |
| 20,00 | 10 | 5,0 | 67 | 3 | B054110Ø20.0z9 EUC-SPEED 60° | 31051763 | B054107Ø20.0z9 EUC-SPEED 60° FL | 31051770 |
| 25,00 | 10 | 6,3 | 71 | 3 | B054110Ø25.0z9 EUC-SPEED 60° | 31051764 | B054107Ø25.0z9 EUC-SPEED 60° FL | 31051771 |

Explanation

Pictograms

Performance Line:
High-performance tools, broad field of application,
high productivity in series production manufacturing

Countersink according to DIN

90°
countersinking

60°
countersinking

Material suitability

Highly suitable

Suitable in some situations

E.g. Standard material suitability table

Dimensions in mm.
For recommended cutting values see pages 6/7.

Cutting data recommendations for countersinks

Countersink with extremely unequal spacing
Feed and cutting speed

EUC-Speed HSS | B054210, B054207, B054209, B054110, B054107

EUC-Speed SC | B044210

| MG* | Workpiece material | | Strength/hardness [N/mm ²] [HRC] | ø < 5 [mm] | | | ø > 5 - 8 [mm] | | | |
|------|--------------------|--------------------------------|--|--|-------|-----------|------------------------|------|-----------|------|
| | | | | v _c [m/min] | | f [mm] | v _c [m/min] | | f [mm] | |
| | | | | HSS | SC | | HSS | SC | | |
| P | P1 | P1.1 | Structural, free-cutting, case hardened and heat-treated steels, non-alloy | < 700 | 40 | 60 | 0,06 | 40 | 60 | 0,08 |
| | | P1.2 | Structural, free-cutting, case hardened and heat-treated steels, non-alloy | < 1.200 | 30 | 50 | 0,04 | 30 | 50 | 0,06 |
| | P2 | P2.1 | Nitrided, case hardened and heat-treated steels, alloy | < 900 | 30 | 50 | 0,04 | 30 | 50 | 0,06 |
| | | P2.2 | Nitrided, case hardened and heat-treated steels, alloy | < 1.400 | 12 | 40 | 0,03 | 12 | 40 | 0,04 |
| | P3 | P3.1 | Tool, bearing, spring and high-speed steels** | < 800 | 30 | 50 | 0,04 | 30 | 50 | 0,06 |
| | | P3.2 | Tool, bearing, spring and high-speed steels** | < 1.000 | 30 | 50 | 0,04 | 30 | 50 | 0,06 |
| | | P3.3 | Tool, bearing, spring and high-speed steels** | < 1.500 | 12 | 40 | 0,03 | 12 | 40 | 0,04 |
| | P4 | P4.1 | Stainless steels, ferritic and martensitic | | | 30 | 0,04 | | 30 | 0,05 |
| | P5 | P5.1 | Cast steel | | | 50 | 0,04 | | 50 | 0,06 |
| | P6 | P6.1 | Stainless cast steel, ferritic and martensitic | | | 30 | 0,04 | | 30 | 0,05 |
| M | M1 | M1.1 | Stainless steels, austenitic | < 700 | | 30 | 0,04 | | 30 | 0,05 |
| | | M1.2 | Stainless steels, ferritic/austenitic (duplex) | < 1.000 | | 25 | 0,04 | | 25 | 0,05 |
| | M2 | M2.1 | Stainless/heat-resistant cast steel, austenitic | < 700 | | 30 | 0,04 | | 30 | 0,05 |
| | M3 | M3.1 | Stainless cast steel, ferritic/austenitic (duplex) | < 1.000 | | 25 | 0,04 | | 25 | 0,05 |
| K | K1 | K1.1 | Cast iron with lamellar graphite (grey cast iron), GJL | < 300 | 20 | 50 | 0,06 | 20 | 50 | 0,10 |
| | | K2.1 | Cast iron with spheroidal graphite, GJS | < 500 | 20 | 45 | 0,06 | 20 | 45 | 0,10 |
| | K2 | K2.2 | Cast iron with spheroidal graphite, GJS | ≤ 800 | 20 | 45 | 0,06 | 20 | 45 | 0,10 |
| | | K2.3 | Cast iron with spheroidal graphite, GJS | > 800 | 20 | 45 | 0,06 | 20 | 45 | 0,10 |
| | K3 | K3.1 | Cast iron with spheroidal graphite, GJV; malleable cast iron, GJM | < 500 | 20 | 35 | 0,06 | 20 | 35 | 0,10 |
| | | K3.2 | Cast iron with spheroidal graphite, GJV; malleable cast iron, GJM | > 500 | 20 | 35 | 0,06 | 20 | 35 | 0,10 |
| N | N1 | N1.1 | Aluminium, non-alloy and alloy < 3 % Si | | | 80 | 0,08 | | 80 | 0,10 |
| | | N1.2 | Aluminium, alloy ≤ 7 % Si | | | 80 | 0,08 | | 80 | 0,10 |
| | | N1.3 | Aluminium, alloy > 7-12 % Si | | | 60 | 0,08 | | 60 | 0,10 |
| | | N1.4 | Aluminium, alloy > 12 % Si | | | 60 | 0,08 | | 60 | 0,10 |
| | N2 | N2.1 | Copper, non-alloy and low-alloy | < 300 | 40 | 70 | 0,10 | 40 | 70 | 0,12 |
| | | N2.2 | Copper, alloy | > 300 | 40 | 70 | 0,10 | 40 | 70 | 0,12 |
| | | N2.3 | Brass, bronze, gunmetal | < 1.200 | 40 | 70 | 0,10 | 40 | 70 | 0,12 |
| | N3 | N3.1 | Graphite, > 8 µm | | | 25 | 0,06 | | 25 | 0,10 |
| | | N3.2 | Graphite, ≤ 8 µm | | | 25 | 0,06 | | 25 | 0,10 |
| | N4 | N4.1 | Plastic, thermoplastics | | | 40 | 0,10 | | 40 | 0,12 |
| | | N4.2 | Plastic, thermosets | | | 40 | 0,10 | | 40 | 0,12 |
| | | N4.3 | Plastic, foams | | | 40 | 0,10 | | 40 | 0,12 |
| | S | S1 | S1.1 | Titanium, titanium alloys | < 400 | | 15 | 0,05 | | 15 |
| S2.1 | | | Titanium, titanium alloys | < 1.200 | | 15 | 0,05 | | 15 | 0,06 |
| S2 | | S2.2 | Titanium, titanium alloys | > 1.200 | | 15 | 0,05 | | 15 | 0,06 |
| | | S3.1 | Nickel, non-alloy and alloy | < 900 | | 15 | 0,05 | | 15 | 0,06 |
| S3 | | S3.2 | Nickel, non-alloy and alloy | > 900 | | 15 | 0,05 | | 15 | 0,06 |
| | | S4 | S4.1 | High-temperature super alloy Ni, Co and Fe-based | | | 15 | 0,05 | | 15 |
| S5 | S5.1 | Tungsten and molybdenum alloys | | | 15 | 0,05 | | 15 | 0,06 | |
| H | H1 | H1.1 | Hardened steel / cast steel | < 44 | | 12 | 0,04 | | 12 | 0,05 |
| | | H1.2 | Hardened steel / cast steel | < 55 | | 8 | 0,04 | | 8 | 0,05 |
| | H2 | H2.1 | Hardened steel / cast steel | < 60 | | 8 | 0,04 | | 8 | 0,05 |
| | | H2.2 | Hardened steel / cast steel | < 65 | | 8 | 0,04 | | 8 | 0,05 |
| | | H2.3 | Hardened steel / cast steel | < 68 | | | | | | |
| | H3 | H3.1 | Wear-resistant cast/chill casting, GJN | | | 12 | 0,04 | | 12 | 0,05 |

* BECK machining groups

** If the alloy parts Cr, Mo, Ni, V, W in total > 8 %, then select the next highest machining group.

| | ø > 8 - 12 [mm] | | | ø > 12 - 16 [mm] | | | ø > 16 - 20 [mm] | | | ø > 20 - 25 [mm] | | | ø > 25 - 31 [mm] | | |
|--|------------------------|----|--------|------------------------|----|--------|------------------------|----|--------|------------------------|----|--------|------------------------|----|--------|
| | v _c [m/min] | | f [mm] | v _c [m/min] | | f [mm] | v _c [m/min] | | f [mm] | v _c [m/min] | | f [mm] | v _c [m/min] | | f [mm] |
| | HSS | SC | | HSS | SC | | HSS | SC | | HSS | SC | | HSS | SC | |
| | 40 | 60 | 0,10 | 40 | 60 | 0,12 | 40 | 60 | 0,14 | 40 | 60 | 0,18 | 40 | 60 | 0,22 |
| | 30 | 50 | 0,08 | 30 | 50 | 0,10 | 30 | 50 | 0,12 | 30 | 50 | 0,14 | 30 | 50 | 0,18 |
| | 30 | 50 | 0,08 | 30 | 50 | 0,10 | 30 | 50 | 0,12 | 30 | 50 | 0,14 | 30 | 50 | 0,18 |
| | 12 | 40 | 0,05 | 12 | 40 | 0,06 | 12 | 40 | 0,08 | 12 | 40 | 0,10 | 12 | 40 | 0,12 |
| | 30 | 50 | 0,08 | 30 | 50 | 0,10 | 30 | 50 | 0,12 | 30 | 50 | 0,14 | 30 | 50 | 0,18 |
| | 30 | 50 | 0,08 | 30 | 50 | 0,10 | 30 | 50 | 0,12 | 30 | 50 | 0,14 | 30 | 50 | 0,18 |
| | 12 | 40 | 0,05 | 12 | 40 | 0,06 | 12 | 40 | 0,08 | 12 | 40 | 0,10 | 12 | 40 | 0,12 |
| | | 30 | 0,06 | | 30 | 0,07 | | 30 | 0,08 | | 30 | 0,09 | | 30 | 0,12 |
| | | 50 | 0,08 | | 50 | 0,10 | | 50 | 0,12 | | 50 | 0,14 | | 50 | 0,18 |
| | | 30 | 0,06 | | 30 | 0,07 | | 30 | 0,08 | | 30 | 0,09 | | 30 | 0,12 |
| | | 30 | 0,06 | | 30 | 0,07 | | 30 | 0,08 | | 30 | 0,09 | | 30 | 0,12 |
| | | 25 | 0,06 | | 25 | 0,07 | | 25 | 0,08 | | 25 | 0,09 | | 25 | 0,12 |
| | | 30 | 0,06 | | 30 | 0,07 | | 30 | 0,08 | | 30 | 0,09 | | 30 | 0,12 |
| | | 25 | 0,06 | | 25 | 0,07 | | 25 | 0,08 | | 25 | 0,09 | | 25 | 0,12 |
| | 20 | 50 | 0,12 | 20 | 50 | 0,14 | 20 | 50 | 0,18 | 20 | 50 | 0,20 | 20 | 50 | 0,25 |
| | 20 | 45 | 0,12 | 20 | 45 | 0,14 | 20 | 45 | 0,18 | 20 | 45 | 0,20 | 20 | 45 | 0,25 |
| | 20 | 45 | 0,12 | 20 | 45 | 0,14 | 20 | 45 | 0,18 | 20 | 45 | 0,20 | 20 | 45 | 0,25 |
| | 20 | 45 | 0,12 | 20 | 45 | 0,14 | 20 | 45 | 0,18 | 20 | 45 | 0,20 | 20 | 45 | 0,25 |
| | 20 | 35 | 0,12 | 20 | 35 | 0,14 | 20 | 35 | 0,18 | 20 | 35 | 0,20 | 20 | 35 | 0,25 |
| | 20 | 35 | 0,12 | 20 | 35 | 0,14 | 20 | 35 | 0,18 | 20 | 35 | 0,20 | 20 | 35 | 0,25 |
| | | 80 | 0,12 | | 80 | 0,14 | | 80 | 0,18 | | 80 | 0,22 | | 80 | 0,26 |
| | | 80 | 0,12 | | 80 | 0,14 | | 80 | 0,18 | | 80 | 0,22 | | 80 | 0,26 |
| | | 60 | 0,12 | | 60 | 0,14 | | 60 | 0,18 | | 60 | 0,22 | | 60 | 0,26 |
| | | 60 | 0,12 | | 60 | 0,14 | | 60 | 0,18 | | 60 | 0,22 | | 60 | 0,26 |
| | 40 | 70 | 0,14 | 40 | 70 | 0,18 | 40 | 70 | 0,20 | 40 | 70 | 0,24 | 40 | 70 | 0,30 |
| | 40 | 70 | 0,14 | 40 | 70 | 0,18 | 40 | 70 | 0,20 | 40 | 70 | 0,24 | 40 | 70 | 0,30 |
| | 40 | 70 | 0,14 | 40 | 70 | 0,18 | 40 | 70 | 0,20 | 40 | 70 | 0,24 | 40 | 70 | 0,30 |
| | | 25 | 0,12 | | 25 | 0,14 | | 25 | 0,18 | | 25 | 0,20 | | 25 | 0,25 |
| | | 25 | 0,12 | | 25 | 0,14 | | 25 | 0,18 | | 25 | 0,20 | | 25 | 0,25 |
| | 40 | 70 | 0,14 | 40 | 70 | 0,18 | 40 | 70 | 0,20 | 40 | 70 | 0,24 | 40 | 70 | 0,30 |
| | 40 | 70 | 0,14 | 40 | 70 | 0,18 | 40 | 70 | 0,20 | 40 | 70 | 0,24 | 40 | 70 | 0,30 |
| | 40 | 70 | 0,14 | 40 | 70 | 0,18 | 40 | 70 | 0,20 | 40 | 70 | 0,24 | 40 | 70 | 0,30 |
| | | 15 | 0,07 | | 15 | 0,08 | | 15 | 0,09 | | 15 | 0,10 | | 15 | 0,12 |
| | | 15 | 0,07 | | 15 | 0,08 | | 15 | 0,09 | | 15 | 0,10 | | 15 | 0,12 |
| | | 15 | 0,07 | | 15 | 0,08 | | 15 | 0,09 | | 15 | 0,10 | | 15 | 0,12 |
| | | 15 | 0,07 | | 15 | 0,08 | | 15 | 0,09 | | 15 | 0,10 | | 15 | 0,12 |
| | | 15 | 0,07 | | 15 | 0,08 | | 15 | 0,09 | | 15 | 0,10 | | 15 | 0,12 |
| | | 15 | 0,07 | | 15 | 0,08 | | 15 | 0,09 | | 15 | 0,10 | | 15 | 0,12 |
| | | 15 | 0,07 | | 15 | 0,08 | | 15 | 0,09 | | 15 | 0,10 | | 15 | 0,12 |
| | | 15 | 0,07 | | 15 | 0,08 | | 15 | 0,09 | | 15 | 0,10 | | 15 | 0,12 |
| | | 12 | 0,06 | | 12 | 0,08 | | 12 | 0,08 | | 12 | 0,10 | | 12 | 0,12 |
| | | 8 | 0,06 | | 8 | 0,08 | | 8 | 0,08 | | 8 | 0,10 | | 8 | 0,12 |
| | | 8 | 0,06 | | 8 | 0,08 | | 8 | 0,08 | | 8 | 0,10 | | 8 | 0,12 |
| | | 8 | 0,06 | | 8 | 0,08 | | 8 | 0,08 | | 8 | 0,10 | | 8 | 0,12 |
| | | 12 | 0,06 | | 12 | 0,08 | | 12 | 0,08 | | 12 | 0,10 | | 12 | 0,12 |

The specified cutting values are guide values.
The optimum data for the respective machining task should be determined during the test or machining.

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