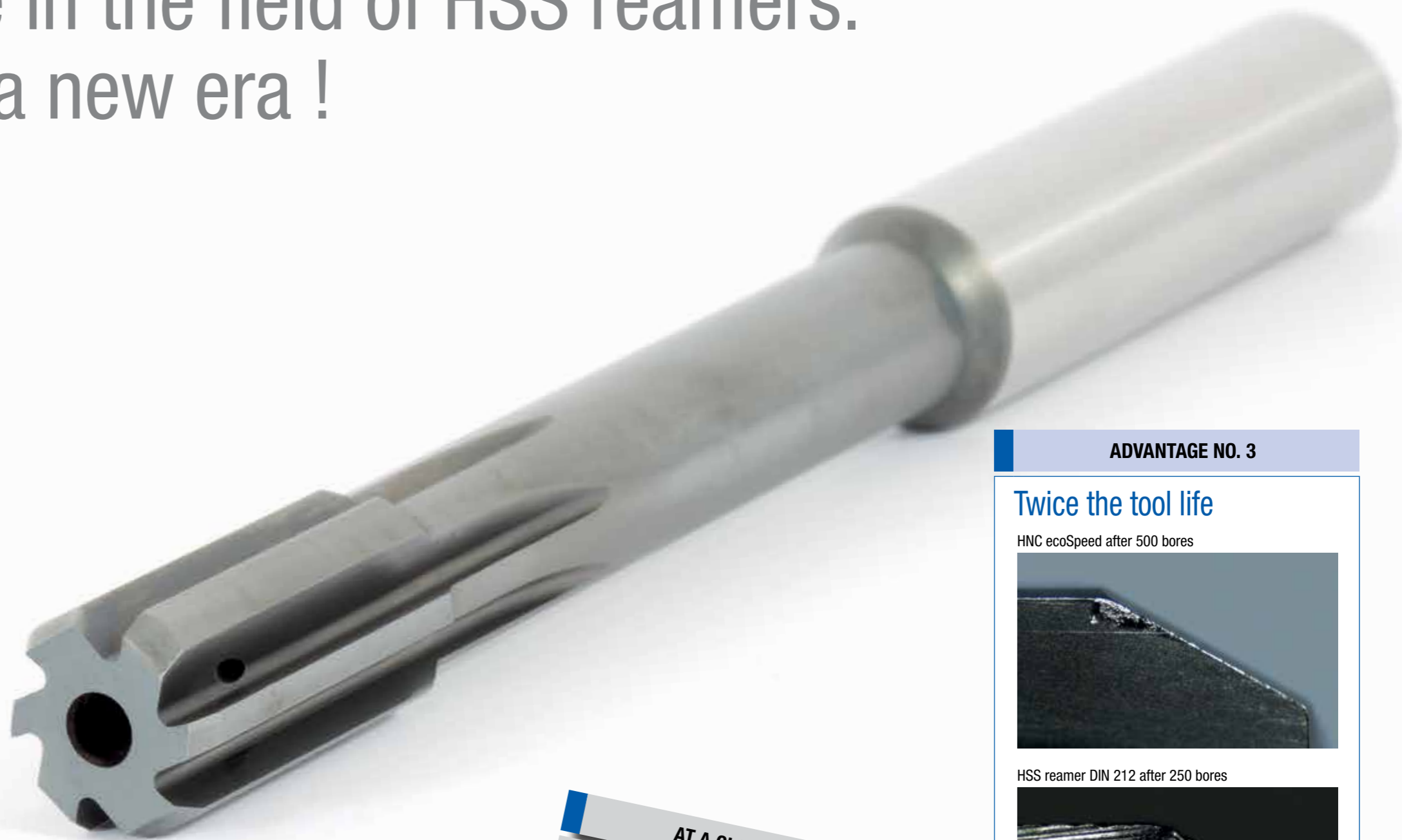


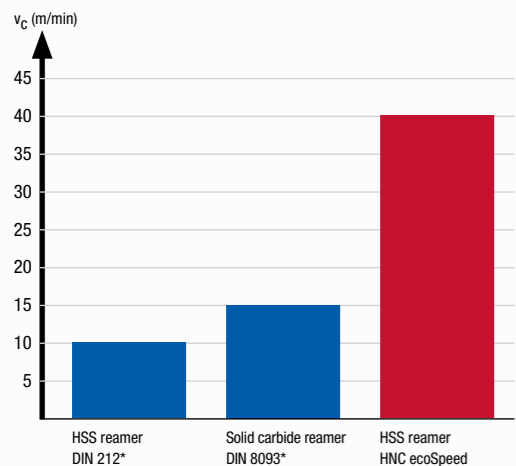
Standard Programme – High Performance Reamers
HNC ecoSpeed, HSS

High performance in the field of HSS reamers. The beginning of a new era !



ADVANTAGE NO. 1

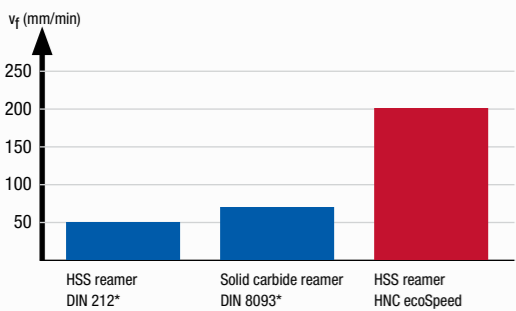
Four times the cutting speed through internal coolant supply



* Uncoated

ADVANTAGE NO. 2

Four times the feed rate through HNC geometry



* Uncoated

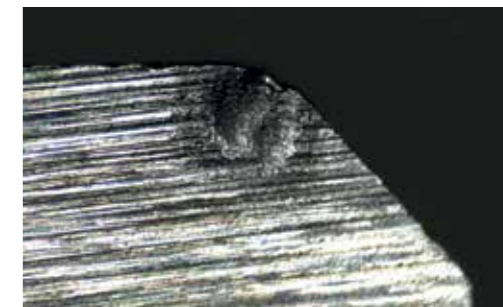
ADVANTAGE NO. 3

Twice the tool life

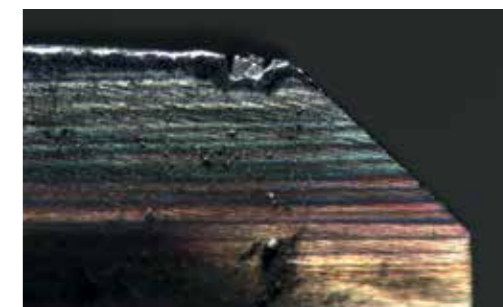
HNC ecoSpeed after 500 bores



HSS reamer DIN 212 after 250 bores



Solid carbide reamer DIN 8093 after 250 bores



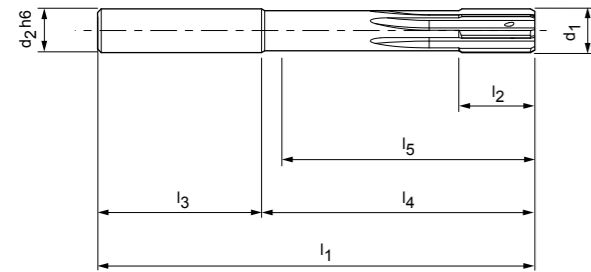
AT A GLANCE

- Internal coolant supply (directly to the cutting edge)
- With high performance coating
- Available in diameter range 6-40mm
- Unique price-performance ratio

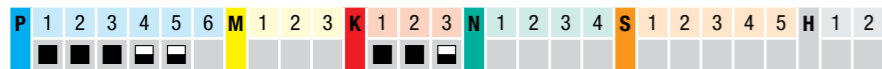
Tough, rugged, non-sensitive and cheap – that's HSS.
A HSS reamer with HNC know-how is particularly efficient.
Combine all of that and you will save a lot of time and money – per bore!

HNC ecoSpeed, HSS I 033260

Preferred series for through bore, internal coolant supply



Design:
 Diameter: 6,00-40,00 mm
 Cutting direction: Right-hand cutting
 Cutting material: HSS, coated
 Flute direction: Straight fluted
 Geometry: HPC, EU spacing



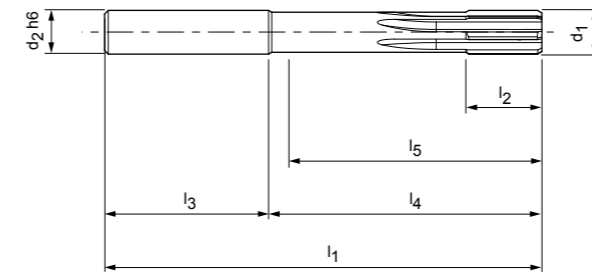
Dimensions								z	Order No.	Stock
d ₁	Tol.	d ₂ h6	l ₁	l ₂	l ₃	l ₄	l ₅			
6,00	H7	8	100	16	36	64	58	6	30730611	●
7,00	H7	8	100	16	36	64	58	6	30730616	●
8,00	H7	8	100	16	36	64	59	6	30730621	●
9,00	H7	10	100	20	40	60	54	6	30730626	●
10,00	H7	10	120	20	40	80	75	6	30730631	●
11,00	H7	12	120	20	45	75	69	6	30730636	●
12,00	H7	12	120	20	45	75	70	6	30730641	●
13,00	H7	14	130	22	45	85	79	6	30730645	●
14,00	H7	14	130	22	45	85	80	6	30730646	●
15,00	H7	16	130	22	48	82	76	6	30730647	●
16,00	H7	16	150	25	48	102	97	6	30730648	●
17,00	H7	18	150	25	48	102	96	8	30730649	●
18,00	H7	18	150	25	48	102	97	8	30730650	●
19,00	H7	20	150	25	50	100	94	8	30730651	●
20,00	H7	20	150	25	50	100	95	8	30730652	●
21,00	H7	20	160	25	50	110	105	8	30730653	○
22,00	H7	20	160	25	50	110	105	8	30730654	○
23,00	H7	20	180	25	50	130	125	8	30730655	○
24,00	H7	20	180	25	50	130	125	8	30730656	○
25,00	H7	20	180	25	50	130	125	8	30730657	●
26,00	H7	20	180	25	50	130	125	8	30730658	○
27,00	H7	20	180	25	50	130	125	8	30730659	○
28,00	H7	25	180	25	56	124	119	8	30730660	○
29,00	H7	25	180	25	56	124	119	8	30730661	○
30,00	H7	25	200	25	56	144	139	8	30730662	●
31,00	H7	25	200	25	56	144	139	8	30730663	○
32,00	H7	25	200	25	56	144	139	8	30730664	●
33,00	H7	25	200	25	56	144	139	8	30730665	○
34,00	H7	25	200	25	56	144	139	8	30730666	○
35,00	H7	25	200	25	56	144	139	8	30730667	○
36,00	H7	25	200	25	56	144	139	8	30730668	●
37,00	H7	25	200	25	56	144	139	8	30730669	○
38,00	H7	25	200	25	56	144	139	8	30730670	○
39,00	H7	25	200	25	56	144	139	8	30730671	○
40,00	H7	25	200	25	56	144	139	8	30730672	○

- Available from stock.
- Available from semi-finished stock.
- Outstanding material suitability.
- ▣ Limited material suitability.

Dimensions in mm.

HNC ecoSpeed, HSS I 033261

Preferred series for blind bore, internal coolant supply



Design:
 Diameter: 6,00-40,00 mm
 Cutting direction: Right-hand cutting
 Cutting material: HSS, coated
 Flute direction: Straight fluted
 Geometry: HPC, EU spacing



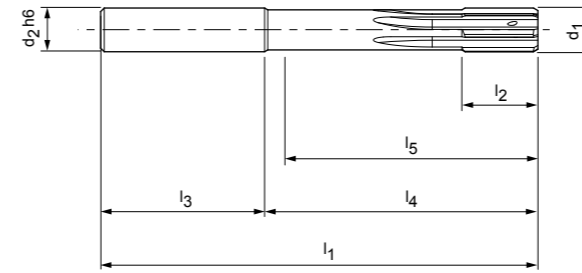
Dimensions								z	Order No.	Stock
d ₁	Tol.	d ₂ h6	l ₁	l ₂	l ₃	l ₄	l ₅			
6,00	H7	8	100	16	36	64	39	6	30730726	●
7,00	H7	8	100	16	36	64	42	6	30730731	●
8,00	H7	8	100	16	36	64	46	6	30730736	●
9,00	H7	10	100	20	40	60	40	6	30730741	●
10,00	H7	10	120	20	40	80	60	6	30730746	●
11,00	H7	12	120	20	45	75	52	6	30730751	●
12,00	H7	12	120	20	45	75	54	6	30730756	●
13,00	H7	14	130	22	45	85	59	6	30730760	●
14,00	H7	14	130	22	45	85	63	6	30730761	●
15,00	H7	16	130	22	48	82	58	6	30730762	●
16,00	H7	16	150	25	48	102	78	6	30730763	●
17,00	H7	18	150	25	48	102	78	6	30730764	●
18,00	H7	18	150	25	48	102	80	6	30730765	●
19,00	H7	20	150	25	50	100	80	6	30730766	●
20,00	H7	20	150	25	50	100	82	6	30730767	●
21,00	H7	20	160	25	50	110	93	8	30730768	○
22,00	H7	20	160	25	50	110	95	8	30730769	○
23,00	H7	20	180	25	50	130	115	8	30730770	○
24,00	H7	20	180	25	50	130	115	8	30730771	○
25,00	H7	20	180	25	50	130	125	8	30730772	●
26,00	H7	20	180	25	50	130	125	8	30730773	○
27,00	H7	20	180	25	50	130	125	8	30730774	○
28,00	H7	25	180	25	56	124	119	8	30730775	○
29,00	H7	25	180	25	56	124	119	8	30730776	○
30,00	H7	25	200	25	56	144	139	8	30730777	●
31,00	H7	25	200	25	56	144	139	8	30730778	○
32,00	H7	25	200	25	56	144	139	8	30730779	●
33,00	H7	25	200	25	56	144	139	8	30730780	○
34,00	H7	25	200	25	56	144	139	8	30730781	○
35,00	H7	25	200	25	56	144	139	8	30730782	○
36,00	H7	25	200	25	56	144	139	8	30730783	●
37,00	H7	25	200	25	56	144	139	8	30730784	○
38,00	H7	25	200	25	56	144	139	8	30730785	○
39,00	H7	25	200	25	56	144	139	8	30730786	○
40,00	H7	25	200	25	56	144	139	8	30730787	○

- Available from stock.
- Available from semi-finished stock.
- Outstanding material suitability.
- ▣ Limited material suitability.

Dimensions in mm.

HNC ecoSpeed, HSS I 033260, 033261 Overview

Configurable series for through bore and blind bore, internal coolant supply



Design:
 Diameter: 6,000-40,200 mm
 Cutting direction: Right-hand cutting
 Cutting material: HSS, coated
 Flute direction: Straight fluted
 Geometry: HPC, EU spacing

Dimensions								z	Stock
d ₁	d ₂ h6	l ₁	l ₂	l ₃	l ₄	l ₅ (033260)	l ₅ (033261)		
6,000-6,700	8	100	16	36	64	58	39	6	○
6,701-7,200	8	100	16	36	64	58	42	6	○
7,201-7,700	8	100	16	36	64	59	44	6	○
7,701-8,200	8	100	16	36	64	59	46	6	○
8,201-8,700	10	100	20	40	60	54	38	6	○
8,701-9,200	10	100	20	40	60	54	40	6	○
9,201-9,700	10	120	20	40	80	75	60	6	○
9,701-10,200	10	120	20	40	80	75	60	6	○
10,201-10,700	12	120	20	45	75	69	51	6	○
10,701-11,200	12	120	20	45	75	69	52	6	○
11,201-11,700	12	120	20	45	75	70	53	6	○
11,701-12,200	12	120	20	45	75	70	54	6	○
12,201-13,200	14	130	22	45	85	79	59	6	○
13,201-14,200	14	130	22	45	85	80	63	6	○
14,201-15,200	16	130	22	48	82	76	58	6	○
15,201-16,200	16	150	25	48	102	97	78	6	○
16,201-17,200	18	150	25	48	102	96	78	8/6	○
17,201-18,200	18	150	25	48	102	97	80	8/6	○
18,201-19,200	20	150	25	50	100	94	80	8/6	○
19,201-20,200	20	150	25	50	100	95	82	8/6	○

Dimensions								z	Stock
d ₁	d ₂ h6	l ₁	l ₂	l ₃	l ₄	l ₅ (033260)	l ₅ (033261)		
20,201-21,200	20	160	25	50	110	105	93	8	○
21,201-22,200	20	160	25	50	110	105	95	8	○
22,201-23,200	20	180	25	50	130	125	115	8	○
23,201-24,200	20	180	25	50	130	125	115	8	○
24,201-25,200	20	180	25	50	130	125	125	8	○
25,201-26,200	20	180	25	50	130	125	125	8	○
26,201-27,200	20	180	25	50	130	125	125	8	○
27,201-28,200	25	180	25	56	124	119	119	8	○
28,201-29,200	25	180	25	56	124	119	119	8	○
29,201-30,200	25	200	25	56	144	139	139	8	○
30,201-31,200	25	200	25	56	144	139	139	8	○
31,201-32,200	25	200	25	56	144	139	139	8	○
32,201-33,200	25	200	25	56	144	139	139	8	○
33,201-34,200	25	200	25	56	144	139	139	8	○
34,201-35,200	25	200	25	56	144	139	139	8	○
35,201-36,200	25	200	25	56	144	139	139	8	○
36,201-37,200	25	200	25	56	144	139	139	8	○
37,201-38,200	25	200	25	56	144	139	139	8	○
38,201-39,200	25	200	25	56	144	139	139	8	○
39,201-40,200	25	200	25	56	144	139	139	8	○

Machining values HNC ecoSpeed, HSS

Feed, cutting speed, allowance

Machining group	Material	Tensile strength Hardness [N/mm ²] [HRC]	Machining values for ø [mm]						Machining values for ø [mm]															
			6 - 8			> 8 - 10			> 10 - 14			> 14 - 20			> 20 - 25			> 25 - 30			> 30 - 40			
			v _c	f	Allowance a	v _c	f	Allowance a	v _c	f	Allowance a	v _c	f	Allowance a	v _c	f	Allowance a	v _c	f	Allowance a	v _c	f	Allowance a	
P	P1.1	Structural, free-cutting, case hardened and heat-treated steel, non-alloyed	< 700 N/mm ²	45	0,12	0,10	45	0,15	0,10	45	0,18	0,15	45	0,25	0,20	45	0,30	0,30	45	0,40	0,30	45	0,45	0,30
	P1.2	Structural, free-cutting, case hardened and heat-treated steel, non-alloyed	< 1200 N/mm ²	35	0,12	0,10	35	0,15	0,10	35	0,18	0,15	35	0,25	0,20	35	0,30	0,30	35	0,40	0,30	35	0,45	0,30
	P2.1	Nitrated, case hardened and heat-treated steel, alloyed	< 900 N/mm ²	45	0,12	0,10	45	0,15	0,10	45	0,18	0,15	45	0,25	0,20	45	0,30	0,30	45	0,40	0,30	45	0,45	0,30
	P2.2	Nitrated, case hardened and heat-treated steel, alloyed	< 1400 N/mm ²	35	0,12	0,10	35	0,15	0,10	35	0,18	0,15	35	0,25	0,20	35	0,30	0,30	35	0,40	0,30	35	0,45	0,30
	P3.1	Tool, roller bearing, spring and high speed steel	< 900 N/mm ²	30	0,12	0,10	30	0,15	0,10	30	0,18	0,15	30	0,25	0,20	30	0,30	0,30	30	0,40	0,30	30	0,45	0,30
P3.2	Tool, roller bearing, spring and high speed steel	< 1500 N/mm ²	20	0,12	0,10	20	0,15	0,10	20	0,18	0,15	20	0,25	0,20	20	0,30	0,30	20	0,40	0,30	20	0,45	0,30	
P4	P4.1	Stainless steel, ferritic and martensitic		15	0,12	0,10	15	0,15	0,10	15	0,18	0,15	15	0,25	0,20	15	0,30	0,30	15	0,40	0,30	15	0,45	0,30
P5	P5.1	Stainless cast steel, ferritic and martensitic		15	0,12	0,10	15	0,15	0,10	15	0,18	0,15	15	0,25	0,20	15	0,30	0,30	15	0,40	0,30	15	0,45	0,30
K	K1.1	Cast iron with lamellar graphite (grey cast iron), EN-GJL	< 300 N/mm ²	40	0,15	0,15	40	0,20	0,15	40	0,25	0,20	40	0,30	0,20	40	0,40	0,30	40	0,50	0,30	40	0,60	0,30
	K2.1	Cast iron with spheroidal graphite, EN-GJS	< 500 N/mm ²	35	0,15	0,15	35	0,20	0,15	35	0,25	0,20	35	0,30	0,20	35	0,40	0,30	35	0,50	0,30	35	0,60	0,30
	K2.2	Cast iron with spheroidal graphite, EN-GJS	500-800 N/mm ²	30	0,15	0,15	30	0,20	0,15	30	0,25	0,20	30	0,30	0,20	30	0,40	0,30	30	0,50	0,30	30	0,60	0,30
	K2.3	Cast iron with spheroidal graphite, EN-GJS	> 800 N/mm ²	20	0,15	0,15	20	0,20	0,15	20	0,25	0,20	20	0,30	0,20	20	0,40	0,30	20	0,50	0,30	20	0,60	0,30
	K3.1	Cast iron with vermicular graphite, EN-GJV; Malleable cast iron, GJM	< 500 N/mm ²	20	0,15	0,15	20	0,20	0,15	20	0,25	0,20	20	0,30	0,20	20	0,40	0,30	20	0,50	0,30	20	0,60	0,30
	K3.2	Cast iron with vermicular graphite, EN-GJV; Malleable cast iron, GJM	> 500 N/mm ²	15	0,15	0,15	15	0,20	0,15	15	0,25	0,20	15	0,30	0,20	15	0,40	0,30	15	0,50	0,30	15	0,60	0,30

- Available from stock.
- Available from semi-finished stock.
- Outstanding material suitability.
- ▣ Limited material suitability.

Dimensions in mm.



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