



**SUPERION, Inc.**

# SOLID CARBIDE AND CARBIDE HEAD BORING REAMERS

## FEATURES

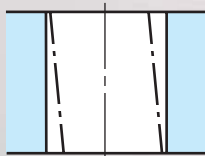
- Eliminate Boring Operations
- Improve Surface Finish
- High Production Consistency
- CNC Manufactured
- Submicro Grain Carbide

## DESIGNED PER APPLICATIONS

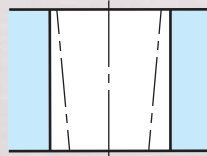
- Solid Carbide
- Carbide Head
- Taper Shanks
- Straight Shanks
- Multiple Diameters
- Coolant Thru
- Various Coatings Available
- Hole Concentricity within .00004 - .0002
- Finish Hole Size (See Chart)

## APPLICATIONS

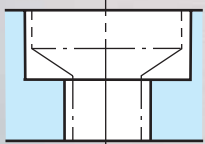
- Aluminum
- Cast Iron
- Mild Steel
- Alloy Steel
- Stainless & Die Steel
- Through Holes
- Blind Holes
- Steps



Through Hole



Multi-Diameter as Cast



Counter Bore

## Speed and Feed Recommendations

Material		Speed (SFPM)	Feed (ipr.)	Ream Stock/ Dia.
Aluminum	in.	120 - 250	.008 - .015	*.020 - .120
Cast Iron	mm	40 - 80	0.20 - 0.38	*0.50 - 3.0
Mild Steel	in.	100 - 120	.006 - .020	.015 - .060
	mm	30 - 40	0.15 - 0.50	0.38 - 1.50
Alloy Steel	in.	100 - 160	.006 - .020	.015 - .060
	mm	30 - 50	0.15 - 0.50	0.38 - 1.50
Stainless & Die Steel	in.	80 - 110	.005 - .015	.010 - .040
	mm	25 - 35	0.13 - 0.38	0.25 - 1.0

\*as cast possible

## Finish Hole Size

Tool Diameter	in.	.236 - .394	.394 - .700	.701 - 1.180	1.181 - 2.0
	mm	6.0 - 10.0	10.0 - 18.0	18.0 - 30.0	30.0 - 50.0
Tolerance Hold	in.	0 - .0006	0 - .0007	0 - .0008	0 - .0012
	mm	0 - 0.015	0 - 0.018	0 - 0.021	0 - 0.030



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