



Replaceable Head Reamers XR

Standard Programme

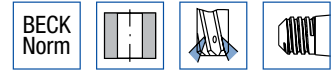
Simple handling, high clamping force
Highest changeover accuracy and stability
Particularly cost-effective from \varnothing 20 mm
High cutting speeds possible



XR 01 / XR 06

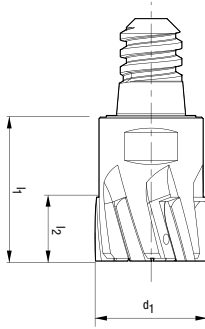
XR 01 | 081610, 081618, 081611, 081612, 081605

Preferred series for through bore



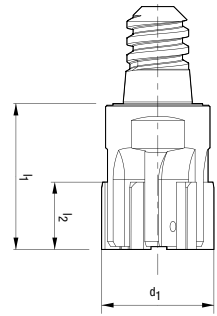
Design 081610 – 081618

Diameter: 8.00 – 40.00 mm
 Flute direction: Left-hand fluted
 Cutting direction: Right-hand cutting
 Number of cutting edges: 4 – 8
 Rake angle: 6°
 Lead angle: 30°
 Dimensions: Works standard



Design 081605

Diameter: 8.00 – 40.00 mm
 Flute direction: Straight fluted
 Cutting direction: Right-hand cutting
 Number of cutting edges: 4 – 8
 Rake angle: 0°
 Lead angle: 45°
 Dimensions: Works standard



Product code	Cutting material	Coating	P ₁	P ₂	P ₃	M ₁	M ₂	K ₁	K ₂	K ₃	N ₁	N ₂	N ₃	N ₄	N ₅	S	H
081610	Carbide	Uncoated	☐	☐	☐			☐	☐	☐	●	☐	☐	●			
081618	Carbide	BSP	●	●	●			●	●	●					☐	★	★
081611	Carbide	BVA				●	●										
081612	Cermet	Uncoated	●	●	☐				●								
081605	PCD	Uncoated										●	●				

Dimensions							081610		081618		081611		081612		081605	
d ₁	Tol.	l ₁	l ₂	z	xs	sw	Order No.	Stock	Order No.	Stock	Order No.	Stock	Order No.	Stock	Order No.	Stock
8.00	H7	18	8	4	6	6	30516058	○	30432555	●	30383184	○	30383155	●	30383223	○
10.00	H7	18	8	6	6	8	30516059	○	30432556	●	30383185	○	30383172	●	30383224	○
12.00	H7	20	8	6	8	8	30516060	○	30432557	●	30383186	○	30383173	●	30383225	○
14.00	H7	22	8	6	10	10	30516061	○	30432558	●	30383187	○	30383174	●	30383226	○
16.00	H7	22	8	6	10	10	30516062	○	30432559	●	30383188	○	30383175	●	30383227	○
18.00	H7	26	12	6	12	13	30516063	○	30432560	●	30383189	○	30383176	●	30383228	○
20.00	H7	26	12	6	12	16	30516064	○	30432561	●	30383190	○	30383177	●	30383229	○
22.00	H7	26	12	6	16	16	30516065	○	30432562	●	30383191	○	30383178	●	30383230	○
24.00	H7	26	12	6	16	16	30516066	○	30432563	●	30383192	○	30383179	●	30383231	○
25.00	H7	26	12	6	16	19	30516067	○	30432564	●	30383193	○	30383180	●	30383232	○
26.00	H7	26	12	6	16	19	30516068	○	30432565	●	30383194	○	30383181	●	30383233	○
28.00	H7	26	12	6	16	21	30516069	○	30432566	●	30383195	○	30383182	●	30383234	○
30.00	H7	26	12	8	16	24	30516070	○	30432567	●	30383196	○	30383183	●	30383235	○
32.00	H7	30	12	8	24	24	30516071	○	30432667	●	30455216	○	30455212	●	30455232	○
34.00	H7	30	12	8	24	27	30516072	○	30432669	●	30455217	○	30455212	●	30455233	○
36.00	H7	30	12	8	24	30	30516073	○	30432670	●	30455218	○	30455213	●	30455235	○
38.00	H7	30	12	8	24	30	30516074	○	30432671	●	30455219	○	30455214	●	30455236	○
40.00	H7	30	12	8	24	30	30516075	○	30432672	●	30455220	○	30455215	●	30455237	○

All dimensions in mm.

For machining values see end of catalogue.

Information on special designs and other coatings on request.

● These products are available ex stock.

○ These products are available from semi-finished stock on short notice.

● Outstanding material suitability.

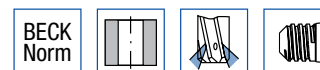
☐ Limited material suitability.

★ Suitability only with special blade geometry and coating.

XR 01 – Configurable

081610, 081618, 081611, 081612, 081605

Configurable series for through bore



Product code	Cutting material	Coating	P ₁	P ₂	P ₃	M ₁	M ₂	K ₁	K ₂	K ₃	N ₁	N ₂	N ₃	N ₄	N ₅	S	H
081610	Carbide	Uncoated	☐	☐	☐			☐	☐	☐	■	☐	☐	■			
081618	Carbide	BSP	■	■	■			■	■	■					☐	★	★
081611	Carbide	BVA				■	■										
081612	Cermet	Uncoated	■	■	☐				■								
081605	PCD	Uncoated										■	■				

Dimensions							
d ₁	l ₁	l ₂	z	xs	sw	Stock	
8.000–8.700	18	8	4	6	6	○	
8.701–9.200	18	8	4	6	6	○	
9.201–9.700	18	8	4	6	6	○	
9.701–10.200	18	8	6	6	8	○	
10.201–10.700	18	8	6	6	8	○	
10.701–11.200	20	8	6	8	8	○	
11.201–11.700	20	8	6	8	8	○	
11.701–12.200	20	8	6	8	8	○	
12.201–12.700	20	8	6	8	8	○	
12.701–13.200	22	8	6	10	10	○	
13.201–14.200	22	8	6	10	10	○	
14.201–15.200	22	8	6	10	10	○	
15.201–16.200	22	8	6	10	10	○	
16.201–17.200	22	8	6	10	13	○	
17.201–18.200	26	12	6	12	13	○	
18.201–19.200	26	12	6	12	13	○	
19.201–20.200	26	12	6	12	16	○	
20.201–21.200	26	12	6	12	16	○	
21.201–22.200	26	12	6	16	16	○	
22.201–23.200	26	12	6	16	16	○	
23.201–24.200	26	12	6	16	16	○	
24.201–25.200	26	12	6	16	19	○	
25.201–26.200	26	12	6	16	19	○	
26.201–27.200	26	12	6	16	21	○	
27.201–28.200	26	12	6	16	21	○	
28.201–29.200	26	12	6	16	24	○	
29.201–30.200	26	12	8	16	24	○	
30.201–31.200	30	12	8	24	24	○	
31.201–32.200	30	12	8	24	24	○	
32.201–33.200	30	12	8	24	27	○	
33.201–34.200	30	12	8	24	27	○	
34.201–35.200	30	12	8	24	30	○	
35.201–36.200	30	12	8	24	30	○	
36.201–37.200	30	12	8	24	30	○	
37.201–38.200	30	12	8	24	30	○	
38.201–39.200	30	12	8	24	30	○	
39.201–40.200	30	12	8	24	30	○	

Explanation of the order specifications for replaceable head reamers in configurable design, see beginning of catalogue.

All dimensions in mm.

For machining values see end of catalogue.

Information on special designs and other coatings on request.

● These products are available ex stock.

○ These products are available from semi-finished stock on short notice.

■ Outstanding material suitability.

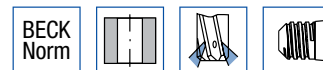
☐ Limited material suitability.

★ Suitability only with special blade geometry and coating.

XR 06 | 081631

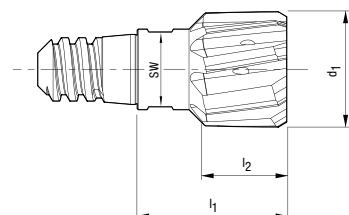
Preferred series of solid carbide for through bore

NEW



Design

Diameter: 8.00 – 40.00 mm
 Flute direction: Left-hand fluted
 Cutting direction: Right-hand cutting
 Number of cutting edges: 6 – 8
 Geometry: HPC cutting edge geometry
 Dimensions: Works standard



Product code	Cutting material	Coating	P ₁	P ₂	P ₃	M ₁	M ₂	K ₁	K ₂	K ₃	N ₁	N ₂	N ₃	N ₄	N ₅	S	H
081631	Solid carbide	BSP	■	■	■			■	■	■					□		

Dimensions							081631	
d ₁	Tol.	l ₁	l ₂	z	xs	sw	Order No.	Stock*
8.00	H7	18	10	6	6	6	30461204	●
8.50	H7	18	10	6	6	6	30461206	○
9.00	H7	18	10	6	6	6	30461208	○
9.50	H7	18	10	6	6	6	30461211	○
10.00	H7	18	10	6	6	6	30461213	●
10.50	H7	18	10	6	6	6	30461225	○
11.00	H7	20	10	6	8	8	30461226	○
11.50	H7	20	10	6	8	8	30461227	○
12.00	H7	20	10	6	8	8	30461229	●
12.50	H7	20	10	6	8	8	30461231	○
13.00	H7	22	10	6	10	10	30461232	○
14.00	H7	22	12	6	10	10	30461237	●
15.00	H7	22	12	6	10	10	30461239	○
16.00	H7	22	12	6	10	10	30461243	●
17.00	H7	22	12	8	10	10	30461244	○
18.00	H7	26	14	8	12	13	30461245	●
19.00	H7	26	14	8	12	13	30461248	○
20.00	H7	26	14	8	12	13	30461249	●
21.00	H7	26	14	8	12	13	30552610	○
22.00	H7	26	14	8	16	16	30552611	●
23.00	H7	26	14	8	16	16	30552612	○
24.00	H7	26	14	8	16	16	30552613	●
25.00	H7	26	14	8	16	16	30552614	●
26.00	H7	26	14	8	16	16	30552615	○
27.00	H7	26	14	8	16	16	30552616	○
28.00	H7	26	14	8	16	16	30552617	●
29.00	H7	26	14	8	16	16	30552618	○
30.00	H7	26	14	8	16	16	30552619	●
31.00	H7	30	14	8	24	24	30552620	○
32.00	H7	30	14	8	24	24	30552621	●
33.00	H7	30	14	8	24	24	30552622	○
34.00	H7	30	14	8	24	24	30552623	○
35.00	H7	30	14	8	24	24	30552624	○
36.00	H7	30	14	8	24	24	30552625	●
37.00	H7	30	14	8	24	24	30552626	○
38.00	H7	30	14	8	24	24	30552627	○
39.00	H7	30	14	8	24	24	30552628	○
40.00	H7	30	14	8	24	24	30540962	●

* Currently establishing stock. Please enquire.

All dimensions in mm.

For machining values see end of catalogue.

Information on special designs and other coatings on request.

● These products are available ex stock.

○ These products are available from semi-finished stock on short notice.

■ Outstanding material suitability.

□ Limited material suitability.

★ Suitability only with special blade geometry and coating.

XR 06 – Configurable I 081631

Configurable series of solid carbide for through bore

NEW

 BECK
 Norm


Product code	Cutting material	Coating	P ₁	P ₂	P ₃	M ₁	M ₂	K ₁	K ₂	K ₃	N ₁	N ₂	N ₃	N ₄	N ₅	S	H
081631	Solid carbide	BSP	■	■	■			■	■	■					□		

Dimensions

d ₁	l ₁	l ₂	z	xs	sw	Stock*
8.000–8.200	18	10	6	6	6	○
8.201–8.700	18	10	6	6	6	○
8.701–9.200	18	10	6	6	6	○
9.201–9.700	18	10	6	6	6	○
9.701–10.200	18	10	6	6	6	○
10.201–10.700	18	10	6	6	6	○
10.701–11.200	20	10	6	8	8	○
11.201–11.700	20	10	6	8	8	○
11.701–12.200	20	10	6	8	8	○
12.201–12.700	20	10	6	8	8	○
12.701–13.200	22	10	6	10	10	○
13.201–14.200	22	12	6	10	10	○
14.201–15.200	22	12	6	10	10	○
15.201–16.200	22	12	6	10	10	○
16.201–17.200	22	12	8	10	10	○
17.201–18.200	26	14	8	12	13	○
18.201–19.200	26	14	8	12	13	○
19.201–20.200	26	14	8	12	13	○
20.201–21.200	26	14	8	12	13	○
21.201–22.200	26	14	8	16	16	○
22.201–23.200	26	14	8	16	16	○
23.201–24.200	26	14	8	16	16	○
24.201–25.200	26	14	8	16	16	○
25.201–26.200	26	14	8	16	16	○
26.201–27.200	26	14	8	16	16	○
27.201–28.200	26	14	8	16	16	○
28.201–29.200	26	14	8	16	16	○
29.201–30.200	26	14	8	16	16	○
30.201–31.200	30	14	8	24	24	○
31.201–32.200	30	14	8	24	24	○
32.201–33.200	30	14	8	24	24	○
33.201–34.200	30	14	8	24	24	○
34.201–35.200	30	14	8	24	24	○
35.201–36.200	30	14	8	24	24	○
36.201–37.200	30	14	8	24	24	○
37.201–38.200	30	14	8	24	24	○
38.201–39.200	30	14	8	24	24	○
39.201–40.200	30	14	8	24	24	○

* Currently establishing semi-finished stock. Please enquire.

Explanation of the order specifications for replaceable head reamers in configurable design, see beginning of catalogue.

All dimensions in mm.

For machining values see end of catalogue.

Information on special designs and other coatings on request.

● These products are available ex stock.

○ These products are available from semi-finished stock on short notice.

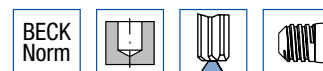
■ Outstanding material suitability.

□ Limited material suitability.

★ Suitability only with special blade geometry and coating.

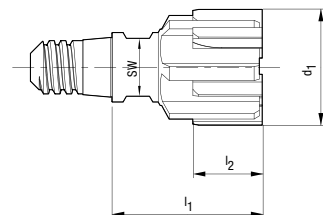
XR 01 | 081650, 081651, 081659, 081652, 081655

Preferred series for blind bore



Design

Diameter: 14.00 – 40.00 mm
 Flute direction: Straight fluted
 Cutting direction: Right-hand cutting
 Number of cutting edges: 6 – 8
 Rake angle: 0°
 Lead angle: 60° (081655 = 75°)
 Dimensions: Works standard



Product code	Cutting material	Coating	P ₁	P ₂	P ₃	M ₁	M ₂	K ₁	K ₂	K ₃	N ₁	N ₂	N ₃	N ₄	N ₅	S	H
081650	Carbide	Uncoated	□	□	□			□	□	□	■	□	□	■			
081651	Carbide	BSP	■	■	■			■	■	■					□	★	★
081659	Carbide	BVA				■	■										
081652	Cermet	Uncoated	■	■	□				■								
081655	PCD	Uncoated										■	■				

Dimensions							081650		081651		081659		081652		081655	
d ₁	Tol.	l ₁	l ₂	z	xs	sw	Order No.	Stock	Order No.	Stock	Order No.	Stock	Order No.	Stock	Order No.	Stock
14.00	H7	22	8	6	6	6	30383271	○	30383259	●	30383248	○	30383237	●	30383282	○
16.00	H7	22	8	6	8	8	30383272	○	30383260	●	30383249	○	30383238	●	30383283	○
18.00	H7	26	12	6	10	10	30383273	○	30383261	●	30383250	○	30383239	●	30383284	○
20.00	H7	26	12	6	10	10	30383274	○	30383262	●	30383251	○	30383240	●	30383285	○
22.00	H7	26	12	6	12	13	30383275	○	30383263	●	30383252	○	30383241	●	30383286	○
24.00	H7	26	12	6	12	13	30383276	○	30383264	●	30383253	○	30383242	●	30383287	○
25.00	H7	26	12	6	16	16	30383277	○	30383265	●	30383254	○	30383243	●	30383288	○
26.00	H7	26	12	6	16	16	30383278	○	30383267	●	30383255	○	30383244	●	30383289	○
28.00	H7	26	12	6	16	16	30383279	○	30383268	●	30383256	○	30383245	●	30383290	○
30.00	H7	26	12	8	16	16	30383280	○	30383269	●	30383257	○	30383246	●	30383291	○
32.00	H7	30	12	8	16	16	30455254	○	30455248	●	30455243	○	30455238	●	30455260	○
34.00	H7	30	12	8	24	24	30455256	○	30455250	●	30455244	○	30455239	●	30455261	○
36.00	H7	30	12	8	24	24	30455257	○	30455251	●	30455245	○	30455240	●	30455262	○
38.00	H7	30	12	8	24	24	30455258	○	30455252	●	30455246	○	30455241	●	30455263	○
40.00	H7	30	12	8	24	24	30455259	○	30455253	●	30455247	○	30455242	●	30455264	○

All dimensions in mm.

For machining values see end of catalogue.

Information on special designs and other coatings on request.

● These products are available ex stock.

○ These products are available from semi-finished stock on short notice.

■ Outstanding material suitability.

□ Limited material suitability.

★ Suitability only with special blade geometry and coating.

XR 01 - Configurable

081650, 081651, 081659, 081652, 081655

Configurable series for blind bore



Product code	Cutting material	Coating	P ₁	P ₂	P ₃	M ₁	M ₂	K ₁	K ₂	K ₃	N ₁	N ₂	N ₃	N ₄	N ₅	S	H
081650	Carbide	Uncoated	☐	☐	☐			☐	☐	☐	■	☐	☐	■			
081651	Carbide	BSP	■	■	■			■	■	■					☐	★	★
081659	Carbide	BVA				■	■										
081652	Cermet	Uncoated	■	■	☐				■								
081655	PCD	Uncoated										■	■				

Dimensions

d ₁	l ₁	l ₂	z	xs	sw	Stock
12.201–12.700	20	8	6	6	6	○
12.701–13.200	22	8	6	6	6	○
13.201–14.200	22	8	6	6	6	○
14.201–15.200	22	8	6	8	8	○
15.201–16.200	22	8	6	8	8	○
16.201–17.200	22	8	6	10	10	○
17.201–18.200	26	12	6	10	10	○
18.201–19.200	26	12	6	10	10	○
19.201–20.200	26	12	6	10	10	○
20.201–21.200	26	12	6	12	13	○
21.201–22.200	26	12	6	12	13	○
22.201–23.200	26	12	6	12	13	○
23.201–24.200	26	12	6	12	13	○
24.201–25.200	26	12	6	16	16	○
25.201–26.200	26	12	6	16	16	○
26.201–27.200	26	12	6	16	16	○
27.201–28.200	26	12	6	16	16	○
28.201–29.200	26	12	6	16	16	○
29.201–30.200	26	12	8	16	16	○
30.201–31.200	30	12	8	16	16	○
31.201–32.200	30	12	8	16	16	○
32.201–33.200	30	12	8	24	24	○
33.201–34.200	30	12	8	24	24	○
34.201–35.200	30	12	8	24	24	○
35.201–36.200	30	12	8	24	24	○
36.201–37.200	30	12	8	24	24	○
37.201–38.200	30	12	8	24	24	○
38.201–39.200	30	12	8	24	24	○
39.201–40.200	30	12	8	24	24	○

Explanation of the order specifications for replaceable head reamers in configurable design, see beginning of catalogue.

All dimensions in mm.

For machining values see end of catalogue.

Information on special designs and other coatings on request.

● These products are available ex stock.

○ These products are available from semi-finished stock on short notice.

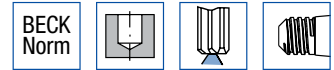
■ Outstanding material suitability.

☐ Limited material suitability.

★ Suitability only with special blade geometry and coating.

XR 06 | 081661

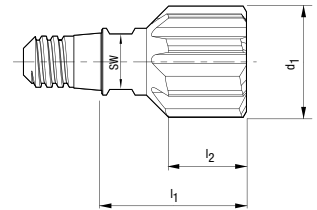
Preferred series of solid carbide for blind bore



NEW

Design

Diameter: 10.00 – 40.00 mm
 Flute direction: Straight fluted
 Cutting direction: Right-hand cutting
 Number of cutting edges: 6 – 8
 Geometry: HPC cutting edge geometry
 Dimensions: Works standard



Product code	Cutting material	Coating	P ₁	P ₂	P ₃	M ₁	M ₂	K ₁	K ₂	K ₃	N ₁	N ₂	N ₃	N ₄	N ₅	S	H
081661	Solid carbide	BSP	■	■	■			■	■	■					□		

Dimensions							081661	
d ₁	Tol.	l ₁	l ₂	z	xs	sw	Order No.	Stock*
10.00	H7	18	10	6	6	6	30461250	○
10.50	H7	18	10	6	6	6	30461259	○
11.00	H7	20	10	6	6	6	30461261	○
11.50	H7	20	10	6	6	6	30461263	○
12.00	H7	20	10	6	6	6	30461267	○
12.50	H7	20	10	6	6	6	30461271	○
13.00	H7	22	12	6	6	6	30461273	○
14.00	H7	22	12	6	6	6	30461274	○
15.00	H7	22	12	6	8	8	30461275	○
16.00	H7	22	12	6	8	8	30461276	●
17.00	H7	22	12	8	10	10	30461278	○
18.00	H7	26	14	8	10	10	30461279	○
19.00	H7	26	14	8	10	10	30461281	○
20.00	H7	26	14	8	10	10	30461283	●
21.00	H7	26	14	8	12	13	30552644	○
22.00	H7	26	14	8	12	13	30552645	●
23.00	H7	26	14	8	12	13	30552646	○
24.00	H7	26	14	8	12	13	30552648	○
25.00	H7	26	14	8	16	16	30552649	●
26.00	H7	26	14	8	16	16	30552650	○
27.00	H7	26	14	8	16	16	30552651	○
28.00	H7	26	14	8	16	16	30552652	○
29.00	H7	26	14	8	16	16	30552653	○
30.00	H7	26	14	8	16	16	30552654	●
31.00	H7	30	14	8	16	16	30552655	○
32.00	H7	30	14	8	16	16	30552656	●
33.00	H7	30	14	8	24	24	30552657	○
34.00	H7	30	14	8	24	24	30552658	○
35.00	H7	30	14	8	24	24	30552659	○
36.00	H7	30	14	8	24	24	30552660	○
37.00	H7	30	14	8	24	24	30552661	○
38.00	H7	30	14	8	24	24	30552662	○
39.00	H7	30	14	8	24	24	30552663	○
40.00	H7	30	14	8	24	24	30552664	●

* Currently establishing stock. Please enquire.

All dimensions in mm.

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■ Outstanding material suitability.

□ Limited material suitability.

★ Suitability only with special blade geometry and coating.

XR 06 – Configurable | 081661

Configurable series for blind bore

NEW

 BECK
 Norm


Product code	Cutting material	Coating	P ₁	P ₂	P ₃	M ₁	M ₂	K ₁	K ₂	K ₃	N ₁	N ₂	N ₃	N ₄	N ₅	S	H
081661	Solid carbide	BSP	■	■	■			■	■	■					□		

Dimensions

d ₁	l ₁	l ₂	z	xs	sw	Stock*
9.701–10.200	18	10	6	6	6	○
10.201–10.700	18	10	6	6	6	○
10.701–11.200	20	10	6	6	6	○
11.201–11.700	20	10	6	6	6	○
11.701–12.200	20	10	6	6	6	○
12.201–12.700	20	10	6	6	6	○
12.701–13.200	22	12	6	6	6	○
13.201–14.200	22	12	6	6	6	○
14.201–15.200	22	12	6	8	8	○
15.201–16.200	22	12	6	8	8	○
16.201–17.200	22	12	8	10	10	○
17.201–18.200	26	14	8	10	10	○
18.201–19.200	26	14	8	10	10	○
19.201–20.200	26	14	8	10	10	○
20.201–21.200	26	14	8	12	13	○
21.201–22.200	26	14	8	12	13	○
22.201–23.200	26	14	8	12	13	○
23.201–24.200	26	14	8	12	13	○
24.201–25.200	26	14	8	16	16	○
25.201–26.200	26	14	8	16	16	○
26.201–27.200	26	14	8	16	16	○
27.201–28.200	26	14	8	16	16	○
28.201–29.200	26	14	8	16	16	○
29.201–30.200	26	14	8	16	16	○
30.201–31.200	30	14	8	16	16	○
31.201–32.200	30	14	8	16	16	○
32.201–33.200	30	14	8	24	24	○
33.201–34.200	30	14	8	24	24	○
34.201–35.200	30	14	8	24	24	○
35.201–36.200	30	14	8	24	24	○
36.201–37.200	30	14	8	24	24	○
37.201–38.200	30	14	8	24	24	○
38.201–39.200	30	14	8	24	24	○
39.201–40.200	30	14	8	24	24	○

* Currently establishing semi-finished stock. Please enquire.

Explanation of the order specifications for replaceable head reamers in configurable design, see beginning of catalogue.

All dimensions in mm.

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