



DRILL

RE 45

For material application is ≤ 45 HRC

Index RE 45, For ≤ 45 HRC

 Suitable for Material Groups
  Adapté pour les matériaux
  适用于材料
 Geeignet für die Materialgruppen
  Adatto per il materiale

P	M	K
N	S	

EDP Number	Type	No. Z	Helix Angle	Coating	Performance	Page Number
621	 RE 45 Short	4/6	-	UC	G	502
623	 RE 45 L.H. / R.H. Short	4/6	12°	UC	G	503
625	 RE 45 R.H. DIN 212	4/6	-	UC	G	504
627	 RE 45 L.H. / R.H. DIN 212	4/6	12°	UC	G	505
629	 RE 45 HIGH L.H. / R.H. DIN 212	3/4/6	60°	UC	G	506

G - General P - Performance

RE 45 SHORT MACHINE REAMERS STRAIGHT FLUTES, 4 - 6 FLUTES

 VHM RE 45 Maschinenreibahlen, kurz, gerade Nuten, 4 bzw. 6 Schneiden

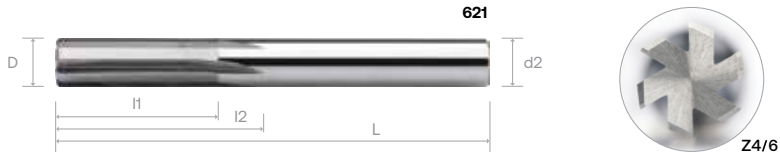
 Alesatori a macchina corti RE 45, con gole diritte, 4 - 6 taglienti

 Alésoirs machine RE 45 courts, dents droites, 4 - 6 dents

 整体硬质合金 RE 45 系列 4/6刃螺旋槽铰刀(带颈位)



RE 45



Order Number	Dimension (mm)						UC
	D (H7)	I1	I2	L	d2 (h9)	Z	
621 0150	1.5	9.5	11/15*	38	2	4	°
621 0200	2	12.5	14.5	44	2	4	•
621 0250	2.5	16	18.5	57	2.5	4	°
621 0300	3		19	57	3	4	•
621 0350	3.5	19	22.5	63	3.5	4	°
621 0400	4		23	63	4	4	•
621 0450	4.5	22	26.5	70	4.5	6	°
621 0500	5	25.5	30.5	76	5	6	°
621 0550	5.5		31	76	5.5	6	°
621 0600	6	28.5	31.5	76	6	6	°
621 0650	6.5		35	83	6.5	6	°
621 0700	7	32	35.5	83	7	6	•
621 0750	7.5		36	83	7.5	6	°
621 0800	8	35	36.5	83	8	6	°
621 0850	8.5		40.5	89	8.5	6	°
621 0900	9	38	41	89	9	6	°
621 0950	9.5		41.5	89	9.5	6	°
621 1000	10	44.5	42	89	10	6	°
621 1050	10.5		42.5	89	10.5	6	°
621 1100	11	35	46	95	11	6	°
621 1150	11.5		46.5	95	11.5	6	°
621 1200	12	38	47	95	12	6	°
621 1300	13		51	102	13	6	°
621 1400	14	44.5	52	102	14	6	°
621 1500	15		53	102	15	6	°
621 1600	16		54	102	16	6	°

* - DIN 6535

Material Group | Material-Gruppe | Groupe Matière | Gruppo Materiali | 材质主类

Cutting Parameter

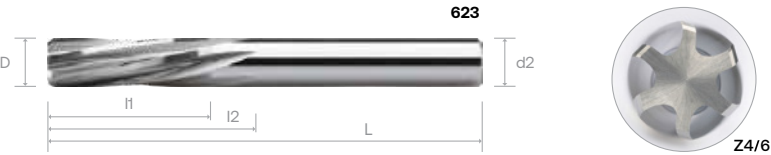
N01	N02	N03	K01	K02	P01	P02	P03	M01	M02	S01	S02	S03	H01	H02	O01	O02
●	●	●	●	●	●	●	●	●	○	○	○					

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RE 45 SHORT MACHINE REAMERS 12° LEFT HAND HELIX RIGHT HAND CUT, 4 - 6 FLUTES

RE 45

- VHM RE 45 Maschinenreibahlen, kurz, 12° Linksdrall, rechtsschneidend, doppelter Anschitt 4 bzw. 6 Schneiden
- Alesatori a macchina corti RE 45, con elica 12° sinistra, taglio a destra, doppio imbocco, 4 - 6 taglienti
- Alésoirs machine RE 45 courts, hélice 12° à gauche, coupe à droite double entrée 4 - 6 dents
- 整体硬质合金 RE 45 系列 4/6刃螺旋槽铰刀(带颈位)



Order Number	Dimension (mm)						UC
	D (H7)	I1	I2	L	d2 (h9)	Z	
623 0150	1.5	9.5	11/15*	38		4	•
623 0200 *	2	12.5	14.5	44	2	4	•
623 0250	2.5	16	18.5	57	2.5	4	◦
623 0300	3		19	57	3	4	•
623 0350	3.5	19	22.5	63	3.5	4	◦
623 0400	4		23	63	4	4	•
623 0450	4.5	22	26.5	70	4.5	6	◦
623 0500	5	25.5	30.5	76	5	6	◦
623 0550	5.5		31	76	5.5	6	•
623 0600	6	28.5	31.5	76	6	6	•
623 0650	6.5		35	83	6.5	6	•
623 0700	7	28.5	35.5	83	7	6	◦
623 0750	7.5		36	83	7.5	6	◦
623 0800	8	32	36.5	83	8	6	◦
623 0850	8.5		40.5	89	8.5	6	◦
623 0900	9	32	41	89	9	6	◦
623 0950	9.5		41.5	89	9.5	6	◦
623 1000	10	35	42	89	10	6	◦
623 1050	10.5		42.5	89	10.5	6	◦
623 1100	11	35	46	95	11	6	◦
623 1150	11.5		46.5	95	11.5	6	◦
623 1200	12	38	47	95	12	6	◦
623 1300	13		51	102	13	6	•
623 1400	14	44.5	52	102	14	6	◦
623 1500	15		53	102	15	6	◦
623 1600	16		54	102	16	6	•

* - DIN 6535

Material Group | Material-Gruppe | Groupe Matiere | Gruppo Materiali | 材质主类

Cutting Parameter

N01	N02	N03	K01	K02	P01	P02	P03	M01	M02	S01	S02	S03	H01	H02	O01	O02	507
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RE 45 MACHINE REAMERS ACC. TO DIN 212, STRAIGHT FLUTES, 4 - 6 FLUTES

🇩🇪 VHM RE 45 Maschinenreibahlen nach DIN 212, gerade Nuten, 4 bzw. 6 Schneiden

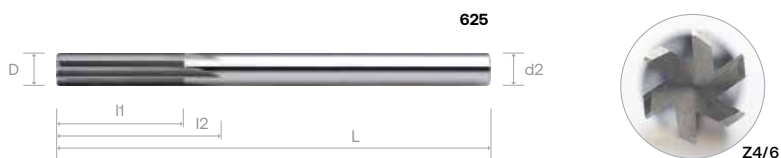
🇮🇹 Alesatori a macchina RE 45, DIN 212, 4 - 6 taglienti

🇫🇷 Alésoirs machine RE 45 selon DIN 212, dents droites, 4 - 6 dents

🇨🇳 整体硬质合金 RE 45 系列 4/6刃直槽铰刀(带颈位) ~DIN 212



RE 45



Order Number	Dimension (mm)						UC
	D (H7)	I1	I2	L	d2 (h9)	Z	
625 0200	2	11	13	49	2	4	•
625 0250	2.5	14	16.5	57	2.5	4	◦
625 0300	3	15	18	61	3	4	◦
625 0350	3.5	18	21.5	70	3.5	4	◦
625 0400	4	19	23	75	4	4	•
625 0450	4.5	21	25.5	49	4.5	6	◦
625 0500	5	23	28	57	5	6	•
625 0550	5.5	26	31.5	61	5.5	6	◦
625 0600	6	26	32	70	6	6	◦
625 0650	6.5	28	34.5	75	6.5	6	◦
625 0700	7	31	38	83	7	6	◦
625 0750	7.5	31	38.5	83	7.5	6	◦
625 0800	8	33	41	83	8	6	◦
625 0850	8.5	33	41.5	89	8.5	6	◦
625 0900	9	36	45	89	9	6	◦
625 0950	9.5	36	45.5	89	9.5	6	◦
625 1000	10	38	48	89	10	6	•
625 1050	10.5	38	48.5	89	10.5	6	◦
625 1100	11	41	52	95	11	6	◦
625 1150	11.5	41	52.5	95	11.5	6	◦
625 1200	12	44	56	95	12	6	◦
625 1300	13	44	57	102	13	6	◦
625 1400	14	47	61	102	14	6	◦
625 1500	15	50	65	102	15	6	◦
625 1600	16	52	68	102	16	6	◦

Material Group | Material-Gruppe | Groupe Matière | Gruppo Materiali | 材质主类

Cutting Parameter

N01	N02	N03	K01	K02	P01	P02	P03	M01	M02	S01	S02	S03	H01	H02	O01	O02
•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•

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RE 45 MACHINE REAMERS ACC. TO DIN 212, 12° L.H. HELIX, R.H. CUT, DOUBLE LEAD ENTRANCE, 4 - 6 FLUTES

RE 45

 VHM RE 45 Maschinenreibahlen, kurz, 12° Linksdrall, rechtsschneidend, doppelter Anschitt 4 bzw. 6 Schneiden

 Alesatori a macchina corti RE 45, con elica 12° sinistra, taglio a destra, doppio imbocco, 4 - 6 taglienti

 Alésoirs machine RE 45 courts, hélice 12° à gauche, coupe à droite double entrée 4 - 6 dents

 整体硬质合金 RE 45 系列 4/6 刀螺旋槽铰刀 (带颈位)



Order Number	Dimension (mm)						UC
	D (H7)	I1	I2	L	d2 (h9)	Z	
627 0200	2	11	13	49	2	4	•
627 0210	2.1		13	49	2.1	4	•
627 0220	2.2	14	16.5	57	2.2	4	°
627 0230	2.3		16.5	57	2.3	4	°
627 0240	2.4		16.5	57	2.4	4	°
627 0250	2.5		16.5	57	2.5	4	°
627 0260	2.6	15	16.5	57	2.6	4	°
627 0270	2.7		16.5	61	2.7	4	°
627 0280	2.8		16.5	61	2.8	4	°
627 0290	2.9		16.5	61	2.9	4	°
627 0300	3	18	18	61	3	4	•
627 0310	3.1		18	61	3.1	4	•
627 0320	3.2		21.5	70	3.2	4	°
627 0330	3.3		21.5	70	3.3	4	•
627 0340	3.4	19	21.5	70	3.4	4	°
627 0350	3.5		21.5	70	3.5	4	°
627 0360	3.6		21.5	70	3.6	4	°
627 0370	3.7		23	75	3.7	4	°
627 0380	3.8	21	23	75	3.8	4	•
627 0390	3.9		23	75	3.9	4	°
627 0400	4		23	75	4	4	•
627 0410	4.1		23	75	4.1	6	•
627 0420	4.2	23	25.5	80	4.2	6	°
627 0430	4.3		25.5	80	4.3	6	°
627 0440	4.4		25.5	80	4.4	6	°
627 0450	4.5		25.5	80	4.5	6	°
627 0460	4.6	26	28	86	4.6	6	°
627 0470	4.7		28	86	4.7	6	°
627 0480	4.8		28	86	4.8	6	•
627 0490	4.9		28	86	4.9	6	°
627 0500	5	28	31.5	93	5	6	•
627 0510	5.1		31.5	93	5.1	6	°
627 0520	5.2		31.5	93	5.2	6	•
627 0530	5.3		31.5	93	5.3	6	•
627 0540	5.4	31	31.5	93	5.4	6	°
627 0550	5.5		31.5	93	5.5	6	•
627 0560	5.6		31.5	93	5.6	6	•
627 0570	5.7		31.5	93	5.7	6	°
627 0580	5.8	33	31.5	93	5.8	6	°
627 0590	5.9		31.5	93	5.9	6	°
627 0600	6		32	93	6	6	•
627 0610	6.1		32	93	6.1	6	°
627 0620	6.2	36	34.5	101	6.2	6	•
627 0630	6.3		34.5	101	6.3	6	°
627 0640	6.4		34.5	101	6.4	6	°
627 0650	6.5		34.5	101	6.5	6	•
627 0660	6.6	38	38	109	6.6	6	°
627 0670	6.7		38	109	6.7	6	°
627 0680	6.8		38	109	6.8	6	°
627 0690	6.9		38	109	6.9	6	°
627 0700	7	41	38	109	7	6	°
627 0710	7.1		38	109	7.1	6	°
627 0720	7.2		38	109	7.2	6	°
627 0730	7.3		38	109	7.3	6	°
627 0740	7.4	44	38	109	7.4	6	°
627 0750	7.5		38.5	109	7.5	6	°
627 0760	7.6		38.5	109	7.6	6	°
627 0770	7.7		41	117	7.7	6	°
627 0780	7.8	47	41	117	7.8	6	°
627 0790	7.9		41	117	7.9	6	°
627 0800	8		41	117	8	6	•
627 0810	8.1		41	117	8.1	6	°
627 0820	8.2	50	41	117	8.2	6	°
627 0830	8.3		41	117	8.3	6	°
627 0840	8.4		41	117	8.4	6	°
627 0850	8.5		41	117	8.5	6	°
627 0860	8.6	52	41	117	8.6	6	°
627 0870	8.7		45.5	125	8.7	6	°
627 0880	8.8		45.5	125	8.8	6	°
627 0890	8.9		45.5	125	8.9	6	°
627 0900	9	54	45.5	125	9	6	•
627 0910	9.1		45.5	125	9.1	6	°
627 0920	9.2		45.5	125	9.2	6	°
627 0930	9.3		45.5	125	9.3	6	°
627 0940	9.4	56	45.5	125	9.4	6	°
627 0950	9.5		45.5	125	9.5	6	°
627 0960	9.6		45.5	125	9.6	6	°
627 0970	9.7		48	133	9.7	6	°
627 0980	9.8	58	48	133	9.8	6	°
627 0990	9.9		48	133	9.9	6	°
627 1000	10		48	133	10	6	°
627 1050	10.5		48.5	133	10.5	6	°
627 1100	11	60	52	142	11	6	•
627 1150	11.5		52.5	142	11.5	6	°
627 1200	12		56	151	12	6	°
627 1300	13		57	151	13	6	°
627 1400	14	62	61	160	14	6	°
627 1500	15		65	160	15	6	°
627 1600	16		68	170	16	6	°

Material Group | Material-Gruppe | Groupe Matière | Gruppo Materiali | 材质主类

Cutting Parameter

N01	N02	N03	K01	K02	P01	P02	P03	M01	M02	S01	S02	S03	H01	H02	O01	O02	507
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RE 45 MACHINE REAMERS ACC. TO DIN 212, 60° L.H. HELIX, R.H. CUT, SPECIAL LEAD ENTRANCE, 3 - 4 RESPECTIVELY 6 FLUTES

🇩🇪 VHM RE 45 Maschinenreihbahnen nach DIN 212, 60° Linksdrall, rechtsschneidend, Sonder- Anschnitt, 3 - 4 bzw. 6 Schneiden

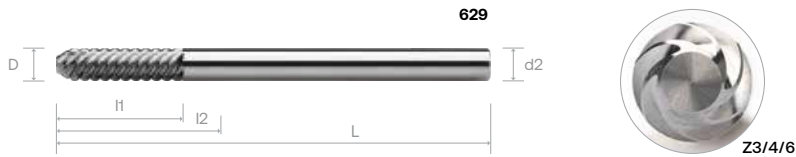
🇮🇹 Alesatori a macchina RE 45, DIN 212, con elica 60° a sinistra, taglio a destra, imbocco speciale, 3-4 resp. 6 taglienti

🇫🇷 Alésoirs machine RE 45 selon DIN 212 en carbure, hélices 60° à gauche, coupe à droite, entrée spéciale, 3 - 4 resp. 6 dents

🇨🇳 整体硬质合金 RE 45 系列 3/4/6刃大螺旋槽铰刀(带颈位) ~DIN 212



RE 45



Order Number	Dimension (mm)						UC	Order Number	Dimension (mm)						UC
	D (H7)	I1	I2	L	d2 (h9)	Z			D (H7)	I1	I2	L	d2 (h9)	Z	
629 0200	2	11		49	2	3	°	629 0650	6.5	28		101	6.5	6	°
629 0210	2.1			49	2.1	3	°	629 0660	6.6			101	6.6	6	°
629 0220	2.2			57	2.2	3	°	629 0670	6.7			109	6.7	6	°
629 0230	2.3	14		57	2.3	3	°	629 0680	6.8	31		109	6.8	6	°
629 0240	2.4			57	2.4	3	°	629 0690	6.9			109	6.9	6	°
629 0250	2.5			57	2.5	3	°	629 0700	7			109	7	6	°
629 0260	2.6	15		57	2.6	3	°	629 0710	7.1	31		109	7.1	6	°
629 0270	2.7			61	2.7	3	°	629 0720	7.2			109	7.2	6	°
629 0280	2.8			61	2.8	3	°	629 0730	7.3			109	7.3	6	°
629 0290	2.9	15		61	2.9	3	°	629 0740	7.4	31		109	7.4	6	°
629 0300	3			61	3	3	°	629 0750	7.5			109	7.5	6	°
629 0310	3.1			61	3.1	3	°	629 0760	7.6			109	7.6	6	°
629 0320	3.2	18		70	3.2	3	°	629 0770	7.7	33		117	7.7	6	°
629 0330	3.3			70	3.3	3	°	629 0780	7.8			117	7.8	6	°
629 0340	3.4			70	3.4	3	°	629 0790	7.9			117	7.9	6	°
629 0350	3.5	19		70	3.5	3	°	629 0800	8	36		117	8	6	°
629 0360	3.6			70	3.6	3	°	629 0810	8.1			117	8.1	6	°
629 0370	3.7			75	3.7	3	°	629 0820	8.2			117	8.2	6	°
629 0380	3.8	19		75	3.8	3	°	629 0830	8.3	36		117	8.3	6	°
629 0390	3.9			75	3.9	3	°	629 0840	8.4			117	8.4	6	°
629 0400	4			75	4	3	°	629 0850	8.5			117	8.5	6	°
629 0410	4.1	21		75	4.1	4	°	629 0860	8.6	36		117	8.6	6	°
629 0420	4.2			80	4.2	4	°	629 0870	8.7			125	8.7	6	°
629 0430	4.3			80	4.3	4	°	629 0880	8.8	38		125	8.8	6	°
629 0440	4.4	23		80	4.4	4	°	629 0890	8.9			125	8.9	6	°
629 0450	4.5			80	4.5	4	°	629 0900	9			125	9	6	°
629 0460	4.6	23		80	4.6	4	°	629 0910	9.1	41		125	9.1	6	°
629 0470	4.7			86	4.7	4	°	629 0920	9.2			125	9.2	6	°
629 0480	4.8			86	4.8	4	°	629 0930	9.3	44		125	9.3	6	°
629 0490	4.9	26		86	4.9	4	°	629 0940	9.4			125	9.4	6	°
629 0500	5			86	5	4	°	629 0950	9.5			125	9.5	6	°
629 0510	5.1	26		86	5.1	4	°	629 0960	9.6	47		125	9.6	6	°
629 0520	5.2			93	5.2	4	°	629 0970	9.7			133	9.7	6	°
629 0530	5.3			93	5.3	4	°	629 0980	9.8	50		133	9.8	6	°
629 0540	5.4	28		93	5.4	4	°	629 0990	9.9			133	9.9	6	°
629 0550	5.5			93	5.5	4	°	629 1000	10			133	10	6	°
629 0560	5.6	28		93	5.6	4	°	629 1050	10.5	52		133	10.5	6	°
629 0570	5.7			93	5.7	4	°	629 1100	11			142	11	6	°
629 0580	5.8			93	5.8	4	°	629 1150	11.5	52		142	11.5	6	°
629 0590	5.9	28		93	5.9	4	°	629 1200	12			151	12	6	°
629 0600	6			93	6	4	°	629 1300	13			151	13	6	°
629 0610	6.1			93	6.1	6	°	629 1400	14	52		160	14	6	°
629 0620	6.2	28		101	6.2	6	°	629 1500	15			160	15	6	°
629 0630	6.3			101	6.3	6	°	629 1600	16			170	16	6	°
629 0640	6.4			101	6.4	6	°								

Material Group | Material-Gruppe | Groupe Matière | Gruppo Materiali | 材质主类

Cutting Parameter

N01	N02	N03	K01	K02	P01	P02	P03	M01	M02	S01	S02	S03	H01	H02	O01	O02
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Recommended Cutting Data



Note: These recommended cutting data indicators are just for reference. They should be adjusted according to the different cutting condition



RE 45

RE 45 Series, 2 / 3 / 4 / 5 / 6 Flutes - 621, 623, 625, 627, 629

Reaming	Stock removal	N						K				S	
Working Material		Wrought Aluminium		Cast Aluminium		Copper alloy		Grey Cast Iron		Ductile Cast Iron		Titanium alloy	
Properties		Si < 9%		Si ≥ 9%		-		-		-		-	
D		Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn
1	0.105	40	0.017	35	0.017	30	0.019	20	0.025	12	0.023	8	0.015
2	0.150		0.035		0.036		0.040		0.052		0.045		0.038
3	0.150		0.055		0.056		0.064		0.076		0.070		0.056
4	0.225		0.076		0.080		0.088		0.110		0.100		0.086
5	0.225		0.100		0.104		0.115		0.135		0.120		0.100
6	0.225		0.120		0.130		0.150		0.170		0.150		0.140
8	0.280		0.170		0.180		0.200		0.230		0.220		0.175
10	0.280		0.220		0.220		0.250		0.280		0.270		0.235
12	0.315		0.270		0.280		0.310		0.320		0.290		0.267
13	0.375		0.280		0.290		0.312		0.370		0.340		0.310
14	0.375		0.280		0.320		0.330		0.375		0.360		0.320
15	0.375		0.290		0.325		0.330		0.380		0.365		0.330
16	0.375		0.320		0.350		0.370		0.430		0.366		0.340

RE 45 Series, 2 / 3 / 4 / 5 / 6 Flutes - 621, 623, 625, 627, 629

Reaming	Stock removal	P						M				S	
Working Material		Carbon steel		Alloy steel		Prehardened steel		Stainless steel		Stainless steel		Nickel alloy	
Properties		-		520 < Rm < 1200		35 ≤ HRC < 45		High machinability		Low machinability		-	
D		Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn
1	0.105	20	0.025	18	0.024	16	0.023	14	0.022	10	0.019	6	0.015
2	0.150		0.052		0.050		0.049		0.045		0.044		0.040
3	0.150		0.076		0.075		0.076		0.070		0.064		0.050
4	0.225		0.110		0.105		0.105		0.100		0.100		0.080
5	0.225		0.135		0.130		0.120		0.130		0.114		0.090
6	0.225		0.170		0.170		0.160		0.160		0.150		0.100
8	0.280		0.230		0.210		0.210		0.210		0.225		0.130
10	0.280		0.280		0.290		0.260		0.280		0.250		0.200
12	0.315		0.320		0.345		0.320		0.330		0.305		0.210
13	0.375		0.370		0.350		0.355		0.335		0.310		0.220
14	0.375		0.375		0.360		0.365		0.340		0.320		0.225
15	0.375		0.380		0.420		0.370		0.370		0.330		0.230
16	0.375		0.430		0.425		0.375		0.375		0.380		0.240