



WINSFEED

QWIKREAM^S

Ø8-12 MM REAMER HEADS
3XD AND 5XD HOLDERS

HEAD EXCHANGEABLE REAMER LINE FOR SMALL DIAMETER Ø8-12 MM HOLES

- User-friendly, ingenious clamping system •*
- No set-up time and minimum machine downtime •*
- Higher productivity compared to solid reamers •*
- Excellent hole accuracy and premium surface roughness •*
- Straight type and helix type heads •*
- Direct coolant supply to each cutting edge •*



Product Overview

QwikReam^S is the high productivity head exchangeable reamer line for Ø8-12 mm holes.

In response to end-user demand for a wider diameter range in the reaming industry and the popularity of the **QwikReam** series, a market leader in exchangeable head reamers, Ingersoll presents the **QwikReam^S**.

This head reamer series is for machining small diameters between 8 and 12 mm.

The user-friendly, distinctive key clamping system of the **QwikReam^S** contributes to its essential features of minimal setup and downtime.

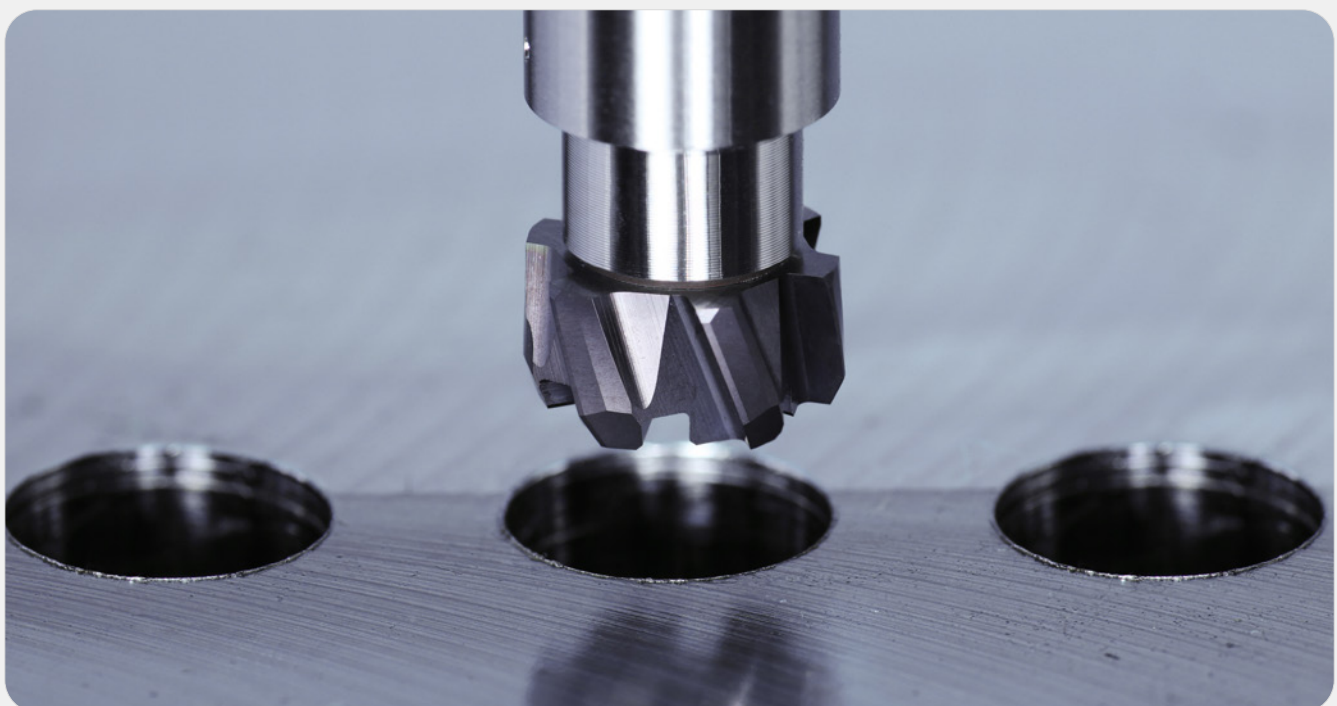
The series consists of holders in lengths of 3xD and 5xD as well as heads for H7 tolerance holes in the 8-12 mm range.

Intermediate sized heads can be supplied upon customer request.



Technical Features & Advantages

- User-friendly, ingenious clamping system - No Set-up time and minimum machine downtime
- Increased number of cutting edges (Z=6) for higher productivity compared to solid reamers
- Straight type and helix type heads suitable for two hole geometries (XSA: blind hole, XLB: through hole)
- Excellent hole accuracy and premium surface roughness (H7 tolerance capable)
- Direct coolant supply to each cutting edge
- Range: Ø8-12 mm heads (1 mm increment), 3xD and 5xD holders

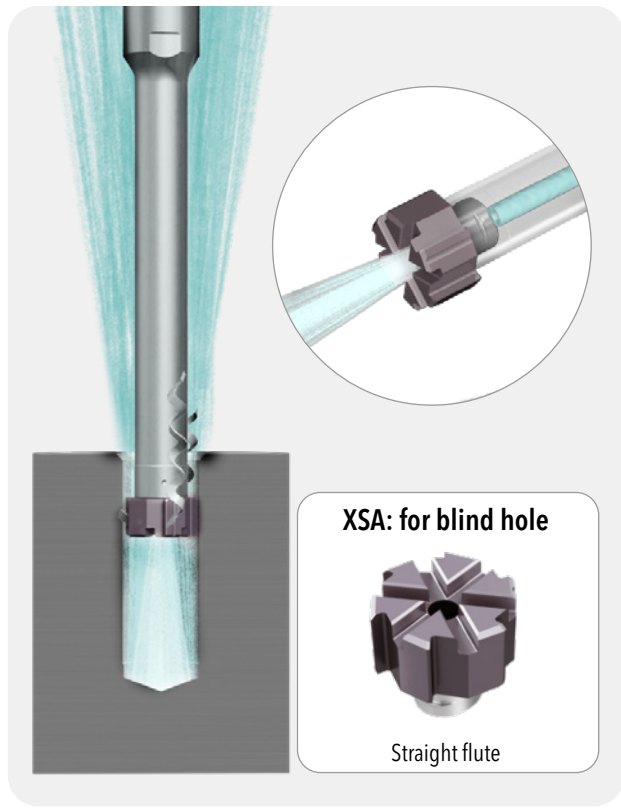


Head Exchangeable Reamer Line

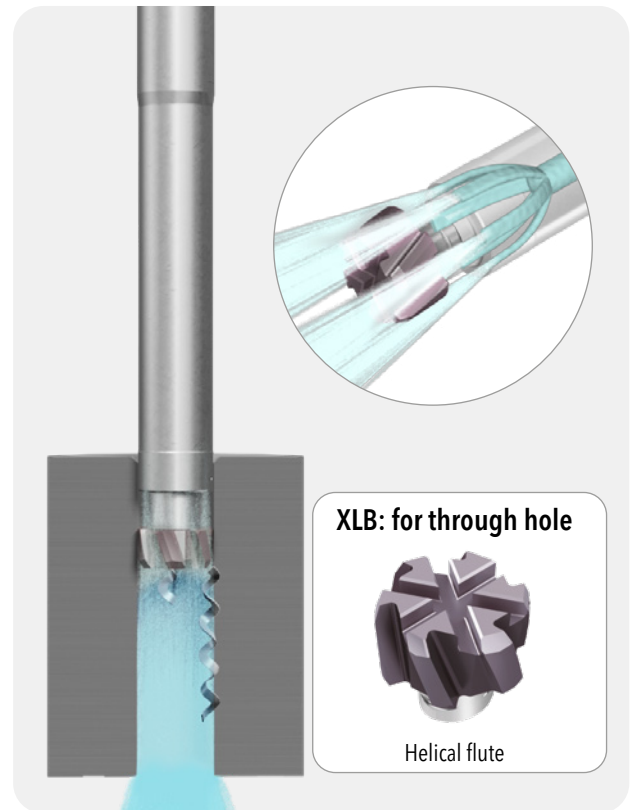
QWIKREAM ^S Ø8-12 mm		QWIKREAM Ø11.5-32 mm	
 <p>XSA...R71 for blind hole</p>	 <p>XLB...R71 for through hole</p>	 <p>XSA...R71 for blind hole</p>	 <p>XLB...R71 for through hole</p>

Two Types of Head and Coolant Flow

• For blind hole (XSA)

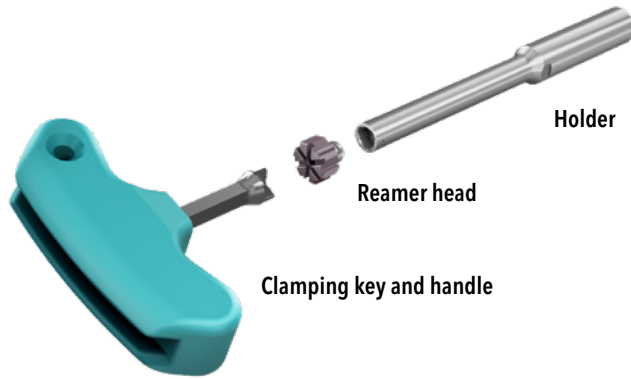


• For through hole (XLB)

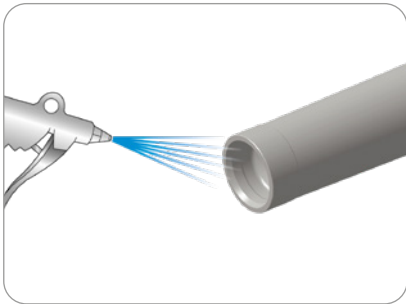


Mounting of Reamer Head

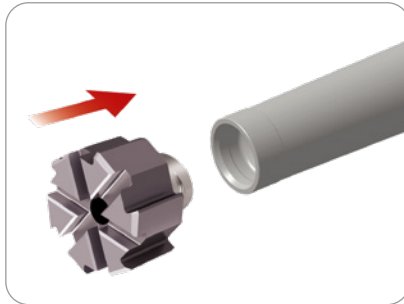
Components



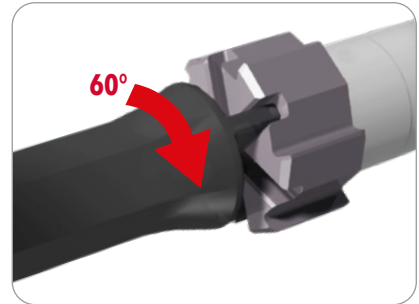
Reamer Head Mounting Procedure



1.) Clean the reamer holder pocket prior to assembling the head.

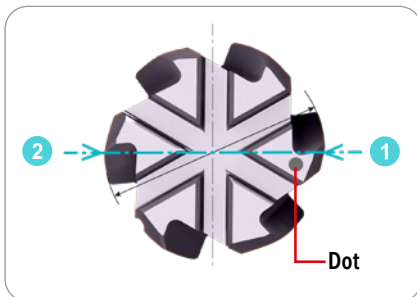


2.) Apply the reamer head to the holder.



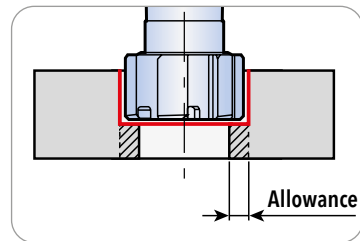
3.) Using the dedicated key, rotate clockwise to firmly apply the head.

How to check reamer diameter



Measure the dot side edge 1 and opposite side edge 2.

Reaming allowance



Material	Diameter	
	< Ø10	Ø10-12
steel & cast iron	0.07-0.10	0.07-0.15
aluminum & brass	0.07-0.10	0.10-0.15

* Based on diameter

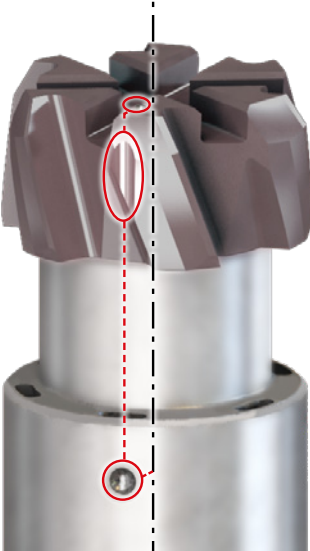
for example:
Ø9.85-9.93 mm pre-hole is recommended for Ø10H7 reaming in cast iron.

Head Alignment

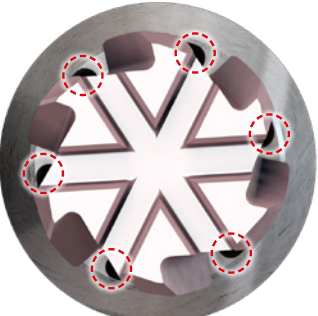
Caution

- To ensure smooth coolant flow, the dot and slot orientation of the head must be aligned as illustrated.


right



Dot orientation match
between head and holder




Coolant hole slightly visible
through flutes




Smooth coolant flow


wrong



Dot orientation mismatch
between head and holder



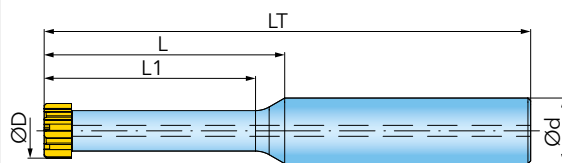
Coolant hole is
hidden by the flute





Reduced coolant flow

QWIKREAM^S HOLDER FOR EXCHANGEABLE REAMING HEADS S - 3D / 5D (RB1)

ADAPTION ACC. TO DIN 6535 HA



Designation	D min.	D max.	d	LT	L	L1	XT		
XS0080028T1RB1	8,000	8,999	10	81,0	3xD	28,0	XT0	✓	0,033
XS1090032T1RB1	9,000	9,999	10	85,5	3xD	31,5	XT1	✓	0,036
XS2100035T2RB1	10,000	10,999	12	89,0	3xD	35,0	XT2	✓	0,051
XS3110039T2RB1	11,000	11,999	12	92,5	3xD	38,5	XT3	✓	0,054
XS4120042T2RB1	12,000	12,999	12	96,0	3xD	42,0	XT4	✓	0,057
XS0080044T1RB1	8,000	8,999	10	97,0	5xD	44,0	XT0	✓	0,036
XS1090050T1RB1	9,000	9,999	10	103,5	5xD	49,5	XT1	✓	0,041
XS2100055T2RB1	10,000	10,999	12	109,0	5xD	55,0	XT2	✓	0,058
XS3110061T2RB1	11,000	11,999	12	114,5	5xD	60,5	XT3	✓	0,063
XS4120066T2RB1	12,000	12,999	12	120,0	5xD	66,0	XT4	✓	0,067

SPARE PARTS

①



②



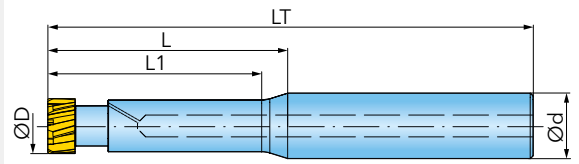
Diameter range

8,000 - 9,999	WXR D08-KEY	SW6-T-SH
10,000 - 11,999	WXR D10-KEY	SW6-T-SH
12,000 - 12,999	WXR D12-KEY	SW6-T-SH

① = bit ② = handle

QWIKREAM^S HOLDER FOR EXCHANGEABLE REAMING HEADS S - 3D / 5D (RT1)

ADAPTION ACC. TO DIN 6535 HA



Designation	D min.	D max.	d	LT	L	L1	XT	IK	kg
XS0080028T1RT1	8,000	8,999	10	81,0	3xD	28,5	XT0	✓	0,033
XS1090032T1RT1	9,000	9,999	10	85,5	3xD	31,5	XT1	✓	0,035
XS2100035T2RT1	10,000	10,999	12	89,0	3xD	35,0	XT2	✓	0,053
XS3110039T2RT1	11,000	11,999	12	92,5	3xD	38,5	XT3	✓	0,058
XS4120042T2RT1	12,000	12,999	12	95,0	3xD	42,0	XT4	✓	0,065
XS0080044T1RT1	8,000	8,999	10	97,0	5xD	44,0	XT0	✓	0,037
XS1090050T1RT1	9,000	9,999	10	103,5	5xD	49,5	XT1	✓	0,042
XS2100055T2RT1	10,000	10,999	12	109,0	5xD	55,0	XT2	✓	0,062
XS3110061T2RT1	11,000	11,999	12	114,5	5xD	60,5	XT3	✓	0,071
XS4120066T2RT1	12,000	12,999	12	120,0	5xD	66,0	XT4	✓	0,082

SPARE PARTS



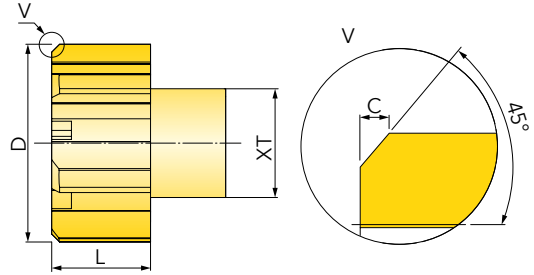
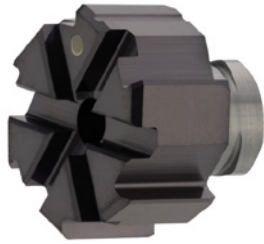
Diameter range

8,000 - 9,999	WXR D08-KEY	SW6-T-SH
10,000 - 11,999	WXR D10-KEY	SW6-T-SH
12,000 - 12,999	WXR D12-KEY	SW6-T-SH

① = bit ② = handle

QWIKREAM^S REAMING HEAD XSA_ Ø 8,0 - 12,0 MM

FOR EXCHANGEABLE HEAD SYSTEM



Grade	P	M	K	N _(K)	S _(M)	H _(PK)
IN2005	+	+	+		+	

+ Preferred choice ○ Second choice

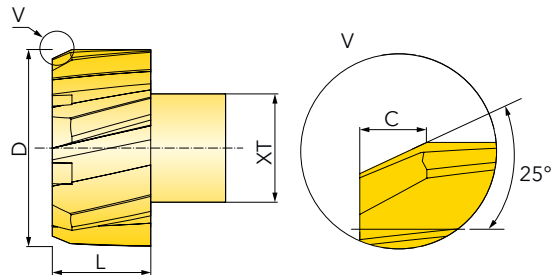
Designation	D	LT	L	C	Z	XT	kg	^①
XSA08000R71	8,000	7,5	4,0	0,5	6	XT0	0,003	W XR D08-KEY
XSA09000R71	9,000	8,2	4,5	0,5	6	XT1	0,004	W XR D08-KEY
XSA10000R71	10,000	8,8	5,0	0,5	6	XT2	0,005	W XR D10-KEY
XSA11000R71	11,000	9,7	5,5	0,5	6	XT3	0,007	W XR D10-KEY
XSA12000R72	12,000	10,5	6,0	0,5	6	XT4	0,008	W XR D12-KEY

Listed heads are designed for H7 bores. Intermediate dimensions on request!

① = bit

QWIKREAM^S REAMING HEAD XLB_ Ø 8,0 - 12,0 MM

FOR EXCHANGEABLE HEAD SYSTEM



Grade	P	M	K	N _(K)	S _(M)	H _(PK)
IN2005	+	+	+		+	

+ Preferred choice ○ Second choice

Designation	D	LT	L	C	Z	XT	kg	^①
XLB08000R71	8,000	7,5	4,0	1,07	6	XT0	0,003	W XR D08-KEY
XLB09000R71	9,000	8,2	4,5	1,07	6	XT1	0,004	W XR D08-KEY
XLB10000R71	10,000	8,8	5,0	1,07	6	XT2	0,005	W XR D10-KEY
XLB11000R71	11,000	9,7	5,5	1,07	6	XT3	0,007	W XR D10-KEY
XLB12000R72	12,000	10,5	6,0	1,07	6	XT4	0,008	W XR D12-KEY

Listed heads are designed for H7 bores. Intermediate dimensions on request!

① = Bit

Recommended Cutting Conditions

ISO	Material		Condition	Tensile strength (N/mm ²)	Hardness HB	Vc m/min	Feed per tooth fz (mm) vs. reamer diameter			
							Ø8-9,99	Ø10-11,99	Ø12-12,99	
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	50-150	0,04 - 0,08	0,05 - 0,10	0,06 - 0,13	
		≥0.25%C	Annealed	650	190	50-150	0,04 - 0,08	0,05 - 0,10	0,06 - 0,13	
		<0.55%C	Quenched and tempered	850	250	50-150	0,04 - 0,08	0,05 - 0,10	0,06 - 0,13	
		≥0.55%C	Annealed	750	220	50-150	0,04 - 0,08	0,05 - 0,10	0,06 - 0,13	
			Quenched and tempered	1000	300	50-150	0,04 - 0,08	0,05 - 0,10	0,06 - 0,13	
	Low alloy steel and cast steel (less than 5% of alloying elements)			Annealed	600	200	50-150	0,04 - 0,08	0,05 - 0,10	0,06 - 0,13
				Quenched and tempered	930	275	50-150	0,04 - 0,08	0,05 - 0,10	0,06 - 0,13
					1000	300	50-150	0,04 - 0,08	0,05 - 0,10	0,06 - 0,13
					1200	350	50-150	0,04 - 0,08	0,05 - 0,10	0,06 - 0,13
	High alloy steel, cast steel and tool steel			Annealed	680	200	20-60	0,04 - 0,07	0,05 - 0,09	0,06 - 0,10
Quenched and tempered				1100	325	20-60	0,04 - 0,07	0,05 - 0,09	0,06 - 0,10	
M	Stainless steel and cast steel	Ferritic / martensitic		680	200	20-40	0,04 - 0,07	0,05 - 0,09	0,06 - 0,10	
		Martensitic		820	240	20-40	0,04 - 0,07	0,05 - 0,09	0,06 - 0,10	
		Austenitic		600	180	20-40	0,04 - 0,07	0,05 - 0,09	0,06 - 0,10	
K	Gray cast iron (GG)	Ferritic		-	160	50-200	0,05 - 0,10	0,06 - 0,13	0,07 - 0,16	
		Pearlitic		-	250	50-200	0,05 - 0,10	0,06 - 0,13	0,07 - 0,16	
	Cast iron nodular (GGG)	Ferritic		-	180	50-200	0,05 - 0,10	0,06 - 0,13	0,07 - 0,16	
		Pearlitic		-	260	50-200	0,05 - 0,10	0,06 - 0,13	0,07 - 0,16	
	Malleable cast iron	Ferritic		-	130	50-200	0,05 - 0,10	0,06 - 0,13	0,07 - 0,16	
		Pearlitic		-	230	50-200	0,05 - 0,10	0,06 - 0,13	0,07 - 0,16	
N	Aluminum - wrought alloy	Not cureable		-	60	100-250	0,05 - 0,10	0,06 - 0,13	0,07 - 0,16	
		Cured		-	100	100-250	0,05 - 0,10	0,06 - 0,13	0,07 - 0,16	
	Aluminum-cast, alloyed	≤12% Si	Not cureable		-	75	100-250	0,05 - 0,10	0,06 - 0,13	0,07 - 0,16
			Cured		-	90	100-250	0,05 - 0,10	0,06 - 0,13	0,07 - 0,16
		>12% Si	High temp.		-	130	100-250	0,05 - 0,10	0,06 - 0,13	0,07 - 0,16
	Copper alloys	>1% Pb	Free cutting		-	110	100-250	0,05 - 0,10	0,06 - 0,13	0,07 - 0,16
			Brass		-	90	100-250	0,05 - 0,10	0,06 - 0,13	0,07 - 0,16
		Electrolitic copper		-	100	100-250	0,05 - 0,10	0,06 - 0,13	0,07 - 0,16	
						-	100	100-250	0,05 - 0,10	0,06 - 0,13

■ Steel
 ■ Stainless steel
 ■ Cast iron
 ■ Nonferrous

Ingersoll Cutting Tools

Marketing & Technology

Germany / Allemagne

Ingersoll Werkzeuge GmbH

Kalteiche-Ring 21-25

35708 Haiger, Germany

Phone: +49 2773 742-0

Email: info@ingersoll-imc.de

Internet: www.ingersoll-imc.de

France

Ingersoll France

22, rue Albert Einstein

F-77420 CHAMPS-sur-MARNE

Téléphone: +33 164684536

E-Mail: info@ingersoll-imc.fr

Site web: www.ingersoll-imc.fr



www.ingersoll-imc.de

QWIKREAM^S