



3M Science.
Applied to Life.™

3M Precision Grinding & Finishing

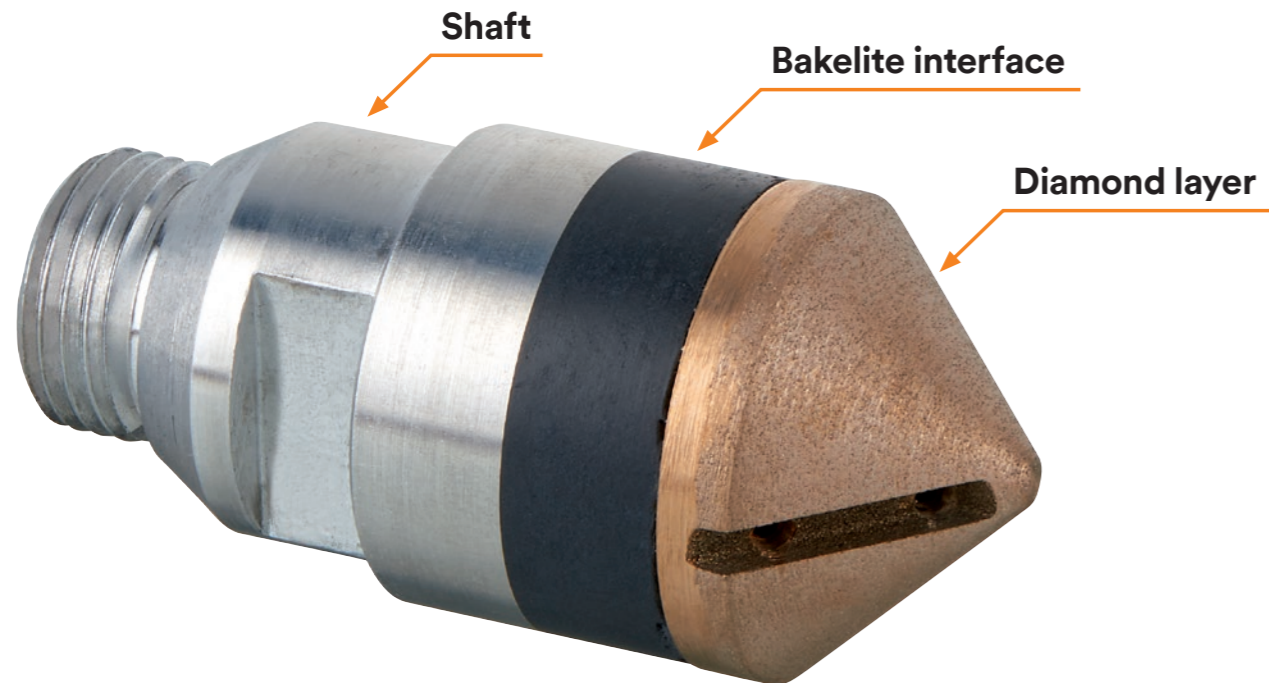
3M™ Spider Reamers TR120 D

**When countersinking glass
is not an issue anymore!**

Countersinking glass. Wide and/or deep chamfer.

3M™ Spider Reamers TR 120 D: Our unique and patented technology

The Spider reamers have a Bakelite interface in between the shaft connected to the machine and the active diamond layer. Thanks to its specific material damping properties, it does absorb shocks and minimizes vibrations during chamfering.



Benefits

- Suitable for both: NC and manual machines
- Best in quality for deep chamfering
- Extremely long lifetime
- Improved chamfering operation cycle time
- Short ramp-up time

Available standards and advised working parameters

Available diameters (D/D1):

- 2 mm to 65 mm

Standard lengths (L):

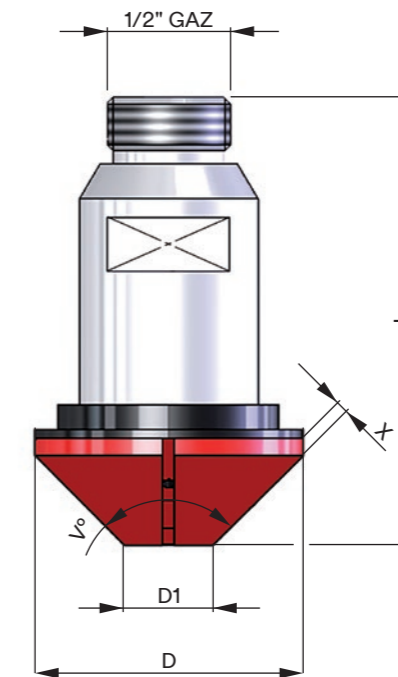
- L75: for Benteler, Schraml, Busetti, Knopp ...
- L95: for Forvet, Bottero ...

Standard angle (V):

- V = 90°, default

Standard fitting:

- R1/2" GAZ



| Item # | DIMENSIONS | | | | | |
|------------|------------|-------|------|------|-----|---------|
| | D mm | D1 mm | X mm | L mm | V | Fitting |
| L91XB50530 | 20 | 2 | 2 | 75 | 90° | R1/2" |
| L91XB50532 | 35 | 4 | 3 | 75 | 90° | R1/2" |
| L91XB50538 | 50 | 5 | 3 | 75 | 90° | R1/2" |
| L91XB50533 | 50 | 15 | 3 | 75 | 90° | R1/2" |
| L91XB50529 | 65 | 30 | 3 | 75 | 90° | R1/2" |
| L91XB50531 | 20 | 2 | 2 | 95 | 90° | R1/2" |
| L91XB50517 | 35 | 4 | 3 | 95 | 90° | R1/2" |
| L91XB50539 | 50 | 5 | 3 | 95 | 90° | R1/2" |
| L91XB50534 | 50 | 15 | 3 | 95 | 90° | R1/2" |
| L91XB50535 | 65 | 30 | 3 | 95 | 90° | R1/2" |

Advised working parameters

Rotation speed:

Optimum rotation speed is between 2,500 and 3,000 RPM

Feed rate:

Optimum feed rate is between 0.4 and 0.8 mm/s

Our drilling solutions for the glass industry.



3M™ Dark Drills Straight drills, our smart program

- Available for automated NC process and manual machines
- Extended lifetime and stable performances
- Rust free core



3M™ Spider Reamers TR 120 D When countersinking glass is not an issue anymore

- Your only solution for wide and/or deep chamfers
- Extremely high quality
- Patented – unique 3M technology



Combis Drilling and chamfering glass

- Extended lifetime and constant performances
- The best in class quality for chamfered holes



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