

**Garant**
**NC reamer H7, uncoated, Nominal Ø DC mm or inch: 1,2**

**Order data**

Order number	162900 1,2
GTIN	4062406146641
Item class	110

**Description**
**Version:**

**Version suitable for NC** similar to DIN 212 with straight shank Ø for **standard chucking** especially in **hydraulic chucks** or **high precision collet chucks**. For **highest concentricity** and **process reliability**. **No need to order special collets.**

With long flutes and left-hand helix.

≤ Ø size 1.7 with 3 teeth; ≥ Ø size 1.8 even number of teeth and irregular spacing. ≤ Ø size 3.7 both ends with centre points; ≥ Ø size 3.8 both ends with centre holes.

Reamer manufacturing tolerance to DIN 1420 for H7 hole tolerance.

**Note:**

For reamers in **1/100 sizes** see **No. 162902**.

For reamers with **diameters and fits to specification** see **No. 162951**

Application for type of drilling: for through holes

Tolerance: H7

Number of cutting edges Z: 3

Tolerance: H7

Flute length  $L_c$ : 7.5 mm

Overhang  $L_1$ : 13 mm

Overall length L: 38 mm

Number of cutting edges Z: 3

Shank Ø  $D_s$ : 2 mm

**Technical description**

Shank tolerance	h6
Overhang $L_1$	13 mm
Overall length L	38 mm

Nominal $\varnothing D_c$	1.2 mm
Shank $\varnothing D_s$	2 mm
Feed $f$ in steel $< 750 \text{ N/mm}^2$	0.1 mm/rev.
Tolerance	H7
Number of cutting edges $Z$	3
Flute length $L_c$	7.5 mm
Reaming oversize in diameter	0.05 - 0.1 mm
Coating	uncoated
Tool material	HSS E
Standard	Manufacturer's standard
Through-coolant	no
Shank	DIN 1835 A to h6
Application for type of drilling	for through holes
Colour ring	green
Type of product	Phillips bit

## User data

	Suitability	$V_c$	ISO code
Aluminium	suitable	20 m/min	N
Aluminium (short chipping)	suitable	20 m/min	N
Steel $< 500 \text{ N/mm}^2$	suitable	15 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	10 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	7 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	5 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable only under restricted conditions	4 m/min	P
INOX $< 900 \text{ N/mm}^2$	suitable	5 m/min	M
INOX $> 900 \text{ N/mm}^2$	suitable only under restricted conditions	5 m/min	M

Ti > 850 N/mm <sup>2</sup>	suitable only under restricted conditions	5 m/min	S
GG(G)	suitable only under restricted conditions	5 m/min	K
CuZn	suitable only under restricted conditions	13 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		