

**Garant**
**NC reamer H7, uncoated, Nominal Ø DC mm or inch: 9/32**

**Order data**

Order number	162900 9/32
GTIN	4062406146740
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: 6

Inch nominal Ø corresponds to: 7.14 mm

Tolerance: H7

Flute length  $L_c$ : 31 mm

Overhang  $L_1$ : 72 mm

Overall length L: 109 mm

Number of cutting edges Z: 6

**Technical description**

Number of cutting edges Z	6
Flute length $L_c$	31 mm
Shank Ø $D_s$	8 mm

Feed f in steel < 750 N/mm <sup>2</sup>	0.2 mm/rev.
Overhang L <sub>1</sub>	72 mm
Overall length L	109 mm
Shank tolerance	h6
Tolerance	H7
Inch nominal Ø corresponds to	7.14 mm
Reaming oversize in diameter	0.1 - 0.2 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 <sub>c</sub>	ISO code
Aluminium	suitable	20 m/min	N
Aluminium (short chipping)	suitable	20 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	15 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	10 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	7 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	5 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	4 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	5 m/min	M
INOX > 900 N/mm <sup>2</sup>	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		