

Garant**Solid carbide NC machine reamer, uncoated, Nominal \varnothing DC: 19mm****Order data**

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| Order number | 164340 19 |
| GTIN | 4062406136765 |
| Item class | 11P |

Description**Version:**

Version suitable for NC similar to DIN 8093 **with straight shank \varnothing** for **standard chucking** especially in **hydraulic chucks** or **high precision collet chucks**. This ensures **the highest concentricity**.

Tolerance specifications:

Size 0.6 – 0.9: Manufacturing or cutting edge tolerance **0/+0.004 mm**.

Size 0.98 – 20: Reamer manufacturing or cutting edge tolerance to DIN1420 for **H7 bore tolerance**.

No need to procure special collets when using GARANT-NC reamers. With long flutes and left-hand helix.

Application:

For reaming through holes, as the chips are evacuated in the cutting direction. Lead taper is suitable also for blind holes.

Note:

For reamers like No. 164340 and 164341 but with other diameters and fits see No. 164344 and 164345.

Technical description

| | |
|-----------------------------|--------|
| Flute length L_c | 58 mm |
| Shank $\varnothing D_s$ | 20 mm |
| Overall length L | 189 mm |
| Number of cutting edges Z | 8 |
| Tolerance | H7 |
| Nominal $\varnothing D_c$ | 19 mm |

| | |
|--|-------------------------|
| Feed f in steel < 1100 N/mm ² | 0.2 mm/rev. |
| Overhang L ₁ | 131 mm |
| Reaming oversize in diameter | 0.2 - 0.3 mm |
| Coating | uncoated |
| Tool material | Solid carbide |
| Standard | Manufacturer's standard |
| Through-coolant | no |
| Shank | DIN 6535 HA with 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 | 35 m/min | N |
| Aluminium (short chipping) | suitable | 30 m/min | N |
| Steel < 500 N/mm ² | suitable | 20 m/min | P |
| Steel < 750 N/mm ² | suitable | 13 m/min | P |
| Steel < 900 N/mm ² | suitable | 10 m/min | P |
| Steel < 1100 N/mm ² | suitable | 8 m/min | P |
| Steel < 1400 N/mm ² | suitable | 6 m/min | P |
| INOX < 900 N/mm ² | suitable only under restricted conditions | 10 m/min | M |
| INOX > 900 N/mm ² | suitable only under restricted conditions | 8 m/min | M |
| Ti > 850 N/mm ² | suitable | 8 m/min | S |
| GG(G) | suitable | 8 m/min | K |
| CuZn | suitable | 20 m/min | N |
| Uni | suitable | | |

wet maximum

suitable