Garant

Solid carbide NC machine reamer, uncoated, Nominal ⌀ DC: 20mm

Order data

Order number	164340 20
GTIN	4062406136772
Item class	11P

Description

Version:
Version suitable for NC similar to DIN 8093 **with straight shank ⌀** 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	60 mm
Overall length L	195 mm
Tolerance	H7
Overhang L_1	136 mm
Feed f in steel < 1100 N/mm^2	0.2 mm/rev.
Nominal ⌀ D_C	20 mm

Number of cutting edges Z	8
Shank ⌀ D_s	20 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/mm²	suitable	20 m/min	P
Steel < 750 N/mm²	suitable	13 m/min	P
Steel < 900 N/mm²	suitable	10 m/min	P
Steel < 1100 N/mm²	suitable	8 m/min	P
Steel < 1400 N/mm²	suitable	6 m/min	P
INOX < 900 N/mm²	suitable only under restricted conditions	10 m/min	M
INOX > 900 N/mm²	suitable only under restricted conditions	8 m/min	M
Ti > 850 N/mm²	suitable	8 m/min	S
GG(G)	suitable	8 m/min	K
CuZn	suitable	20 m/min	N
Uni	suitable		

wet maximum	suitable