

Garant
NC reamer H7, uncoated, Nominal Ø DC mm or inch: 8,4


Order data

Order number	162900 8,4
GTIN	4045197090652
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

Tolerance: H7

Flute length L_c: 33 mm

Overhang L₁: 80 mm

Overall length L: 117 mm

Number of cutting edges Z: 6

Shank Ø D_s: 8 mm

Technical description

Nominal Ø D _c	8.4 mm
Overhang L ₁	80 mm
Feed f in steel < 750 N/mm ²	0.25 mm/rev.

Shank tolerance	h6
Shank Ø D _s	8 mm
Overall length L	117 mm
Flute length L _c	33 mm
Number of cutting edges Z	6
Tolerance	H7
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 _c	ISO code
Aluminium	suitable	20 m/min	N
Aluminium (short chipping)	suitable	20 m/min	N
Steel < 500 N/mm ²	suitable	15 m/min	P
Steel < 750 N/mm ²	suitable	10 m/min	P
Steel < 900 N/mm ²	suitable	7 m/min	P
Steel < 1100 N/mm ²	suitable	5 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	4 m/min	P
INOX < 900 N/mm ²	suitable	5 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	5 m/min	M

Ti > 850 N/mm ²	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		