

Garant
NC reamer H7, uncoated, Nominal Ø DC mm or inch: 6,9

Order data

| | |
|--------------|---------------|
| Order number | 162900 6,9 |
| GTIN | 4045197090447 |
| 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 : 31 mm

Overhang L_1 : 72 mm

Overall length L: 109 mm

Number of cutting edges Z: 6

Shank Ø D_s : 8 mm

Technical description

| | |
|---|-------------|
| Shank tolerance | h6 |
| Nominal Ø D_c | 6.9 mm |
| Feed f in steel < 750 N/mm ² | 0.2 mm/rev. |

| | |
|----------------------------------|-------------------------|
| Overhang L_1 | 72 mm |
| Shank $\varnothing D_s$ | 8 mm |
| Overall length L | 109 mm |
| Flute length L_c | 31 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 | | |