



## Machine taper pin reamer, uncoated, Nominal $\varnothing$ DC: 4mm



### Order data

Order number	161600 4
GTIN	4045197089045
Item class	120

### Description

#### Version:

With 45° **left hand helix**, evacuates swarf in cutting direction.

#### Application:

**On machines** for tapered through holes. The peeling twist requires removal of a thick chip (pre-drilled hole must not be too large). For taper pins to ISO 2339, 8736, 8737 (DIN 1, 7977, 7978), DIN 258 and 1447.

#### Recommendation:

The pre-drilled hole is best produced using a straight shank taper pin drill No. 116310.

### Technical description

small $\varnothing$ D <sub>3</sub>	3.9 mm
large $\varnothing$ D <sub>2</sub>	5.26 mm
Feed f in steel < 500 N/mm <sup>2</sup>	0.1 mm/rev.
Nominal $\varnothing$ D <sub>c</sub>	4 mm
Overall length L	112 mm
Flute length L <sub>c</sub>	68 mm
Shank $\varnothing$ D <sub>s</sub>	5 mm
Coating	uncoated
Tool material	HSS E
Standard	DIN 2179
Helix angle	45 degrees

Taper ratio	1:50
Through-coolant	no
Shank	Parallel shank to h9
Colour ring	without
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 <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 only under restricted conditions	7 m/min	P
Oil	suitable		
wet maximum	suitable		