

## Garant

### Solid carbide NC machine reamer, uncoated, Nominal $\varnothing$ DC: 7,5mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 164340 7,5    |
| GTIN         | 4045197093776 |
| 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

|  |              |
|--|--------------|
| Nominal $\varnothing$ D <sub>c</sub>     | 7.5 mm       |
| Overhang L <sub>1</sub>                  | 67 mm        |
| Feed f in steel < 1100 N/mm <sup>2</sup> | 0.14 mm/rev. |
| Shank tolerance                          | h6           |
| Shank $\varnothing$ D <sub>s</sub>       | 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                    | 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 <sup>2</sup>  | suitable                                  | 20 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 13 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 10 m/min | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 8 m/min  | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 6 m/min  | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 10 m/min | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 8 m/min  | M        |
| Ti > 850 N/mm <sup>2</sup>     | suitable                                  | 8 m/min  | S        |
| GG(G)                          | suitable                                  | 8 m/min  | K        |
| CuZn                           | suitable                                  | 20 m/min | N        |

|             |          |
|-------------|----------|
| Uni         | suitable |
| wet maximum | suitable |