Solid carbide NC machine reamer Configurable, uncoated, Nominal Ø DC: 1,8mm

Order data

Order number	164345 1,8
GTIN	4045197328151
Item class	10N

Description

Version:
Version suitable for NC DIN 8093-2 **with straight shank** Ø for **standard chucking** especially in **hydraulic chucks** or **high precision collet chucks.** This ensures **very high concentricity** and **process reliability**,
The use of GARANT-NC reamers eliminates the need to procure special collets. With long flutes and left-hand helix.
Reamers finish ground to match your specification.
Application:
For reaming through holes, as the chips are evacuated in the cutting direction. Lead taper is suitable also for blind holes.
Note:
For H7 fit see No. 164340 and 164341.

Technical description

Nominal Ø D_c	1.8 mm
Shank tolerance	h6
Overhang L_1	19 mm
Feed f in steel < 1100 N/mm^2	0.08 mm/rev.
Shank Ø D_s	4 mm
Overall length L	50 mm
Flute length L_c	11 mm
Ø range	1.71 - 1.9 mm

Number of cutting edges Z	4
Reaming oversize in diameter	0.05 - 0.1 mm
Coating	uncoated
Tool material	Solid carbide
Standard	DIN 8093
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^2	suitable	20 m/min	P
Steel < 750 N/mm^2	suitable	13 m/min	P
Steel < 900 N/mm^2	suitable	10 m/min	P
Steel < 1100 N/mm^2	suitable	8 m/min	P
Steel < 1400 N/mm^2	suitable	6 m/min	P
INOX < 900 N/mm^2	suitable only under restricted conditions	10 m/min	M
INOX > 900 N/mm^2	suitable only under restricted conditions	8 m/min	M
Ti > 850 N/mm^2	suitable	8 m/min	S
GG(G)	suitable	8 m/min	K
CuZn	suitable	20 m/min	N
Uni	suitable		
wet maximum	suitable		