Garant

Solid carbide NC machine reamer Configurable, uncoated, Nominal ∅ DC: 8,5mm

Order data

Order number	164345 8,5
GTIN	4045197328328
Item class	10N

Description

Version:
Version suitable for NC DIN 8093-2 **with straight shank** ∅ 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

Overhang L_1	79 mm
Nominal ∅ D_C	8.5 mm
Feed f in steel < 1100 N/mm^2	0.15 mm/rev.
Shank tolerance	h6
Shank ∅ D_s	8 mm
Overall length L	117 mm
Flute length L_c	33 mm

∅ range	8.1 - 8.6 mm
Number of cutting edges Z	6
Reaming oversize in diameter	0.1 - 0.2 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/mm²	suitable	20 m/min	P
Steel < 750 N/mm²	suitable	13 m/min	P
Steel < 900 N/mm²	suitable	10 m/min	P
Steel < 1100 N/mm²	suitable	8 m/min	P
Steel < 1400 N/mm²	suitable	6 m/min	P
INOX < 900 N/mm²	suitable only under restricted conditions	10 m/min	M
INOX > 900 N/mm²	suitable only under restricted conditions	8 m/min	M
Ti > 850 N/mm²	suitable	8 m/min	S
GG(G)	suitable	8 m/min	K
CuZn	suitable	20 m/min	N
Uni	suitable		

wet maximum	suitable