Garant

Solid carbide reamers HPC through hole, TiAlN, Nominal Ø DC: 4,02mm

Order data

Order number	164362 4,02
GTIN	4045197362278
Item class	10N

Description

Version:
Version suitable for NC with straight shank Ø for standard arbors especially in **hydraulic chucks** or **high precision collet chucks.** For **highest concentricity** and **process reliability**. No need to procure special collets. With internal coolant supply for **HPC applications** to reduce manufacturing costs.
Reamer manufacturing tolerances:
whole number sizes and Ø 0.5: H7 to DIN 1420
1/100 sizes Ø 3.97 – 12.03: +0.004/0
With short flutes and left-hand helix.
Application:
For **HPC/HSM reaming** of **through holes.**
Note:
NEW GENERATION AVAILABLE!
Recommended successor product is No. 164420.
Application for type of drilling: for through holes
Bore Ø tolerance: 0 / 0.004
Number of cutting edges Z: 4
Bore Ø tolerance: 0 / 0.004
Flute length L_c: 12 mm
Overhang L_1: 34 mm
Overall length L: 75 mm
Number of cutting edges Z: 4
Shank Ø D_s: 6 mm

Technical description

Feed f in steel < 1100 N/mm^2	0.3 mm/rev.

Shank tolerance	h6
Nominal ∅ D_C	4.02 mm
Overhang L_1	34 mm
Shank ∅ D_s	6 mm
Overall length L	75 mm
Flute length L_c	12 mm
Number of cutting edges Z	4
recommended drill ∅ in steel < 1100 N/mm^2	3.9 mm
Bore ∅ tolerance	0 / 0.004
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer’s standard
Through-coolant	yes
Shank	DIN 6535 HA with h6
Machining strategy	HPC
Application for type of drilling	for through holes
Colour ring	green
Type of product	Phillips bit

User data

	Suitability	**V_c**	**ISO code**
Steel < 750 N/mm^2	suitable	150 m/min	P
Steel < 900 N/mm^2	suitable	120 m/min	P
Steel < 1100 N/mm^2	suitable	120 m/min	P
GG	suitable	80 m/min	K
GGG	suitable	60 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		