

Garant
Solid carbide reamers HPC through hole, TiAlN, Nominal Ø DC: 3,97mm

Order data

Order number	164362 3,97
GTIN	4045197362230
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

Overhang L_1	34 mm
----------------	-------

Feed f in steel < 1100 N/mm ²	0.3 mm/rev.
Nominal Ø D _c	3.97 mm
Shank tolerance	h6
Shank Ø D _s	6 mm
Overall length L	75 mm
Flute length L _c	12 mm
Number of cutting edges Z	4
recommended drill Ø in steel < 1100 N/mm ²	3.9 mm
Bore Ø 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		

