

Garant**Carbide machine reamer H7, uncoated, Nominal \varnothing DC: 15mm****Order data**

Order number	164500 15
GTIN	4045197252135
Item class	110

Description**Version:**

Long flutes, left-hand helix.

Extremely irregular spacing (EU) from size 2.

This ensures that the reamed bore is absolutely round and free from chatter marks.

Application:

On stable, low vibration machines. Longer tool life and better dimensional accuracy than HSS reamers.

Tool material:

Sizes 1 – 13 **solid carbide**.

Sizes 14 – 16 with **carbide inserts**, supported by hard nitrided steel guidel chamfers.

Technical description

Overhang L_1	111 mm
Nominal $\varnothing D_c$	15 mm
Shank tolerance	h9
Feed f in steel < 1100 N/mm ²	0.18 mm/rev.
Shank $\varnothing D_s$	12.5 mm
Overall length L	162 mm
Flute length L_c	50 mm
Number of cutting edges Z	6
Tolerance	H7
Reaming oversize in diameter	0.2 mm

Coating	uncoated
Tool material	Carbide K10
Standard	DIN 8093
Through-coolant	no
Shank	Parallel shank to h6
Application for type of drilling	for through holes
Colour ring	without
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
CuZn	suitable	20 m/min	N
Oil	suitable		
wet maximum	suitable		