

**Garant**
**Carbide machine reamer H7, uncoated, Nominal  $\varnothing$  DC: 9mm**

**Order data**

Order number	164500 9
GTIN	4045197252067
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 $L_1$	80 mm
Feed $f$ in steel $< 1100 \text{ N/mm}^2$	0.15 mm/rev.
Nominal $\varnothing D_c$	9 mm
Shank tolerance	h9
Shank $\varnothing D_s$	9 mm
Overall length $L$	125 mm
Flute length $L_c$	36 mm
Number of cutting edges $Z$	6
Tolerance	H7
Reaming oversize in diameter	0.1 - 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 <sub>c</sub>	ISO code
Aluminium	suitable	35 m/min	N
Aluminium (short chipping)	suitable	30 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	20 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	13 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	10 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	8 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	6 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	10 m/min	M
CuZn	suitable	20 m/min	N
Oil	suitable		
wet maximum	suitable		