

Garant
Carbide machine reamer H7, uncoated, Nominal \varnothing DC: 1mm

Order data

Order number	164500 1
GTIN	4045197251879
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. With centring tip.

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

Feed f in steel $< 1100 \text{ N/mm}^2$	0.12 mm/rev.
Overhang L_1	14 mm
Shank tolerance	h9
Nominal $\varnothing D_c$	1 mm
Shank $\varnothing D_s$	1 mm
Overall length L	34 mm
Flute length L_c	5.5 mm
Number of cutting edges Z	3
Tolerance	H7

Reaming oversize in diameter	0.05 - 0.1 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		