

## Garant

### Solid carbide NC machine reamer Configurable, TiAlN, Nominal Ø DC: 1,2mm



#### Order data

Order number	164344 1,2
GTIN	4045197854087
Item class	10N

#### Description

##### Version:

**Version suitable for NC DIN 8093-2 with straight shank** Ø for **standard chucking** especially in **hydraulic chucks** or **high precision collet chucks**. This ensures **very high concentricity** and **process reliability**,

**The use of GARANT-NC reamers eliminates the need to procure special collets.** With long flutes and left-hand helix.

**Rearers finish ground to match your specification.**

##### Application:

For reaming through holes, as the chips are evacuated in the cutting direction. Lead taper is suitable also for blind holes.

##### Note:

For H7 fit see No. 164340 and 164341.

#### Technical description

Number of cutting edges Z	3
Feed f in steel < 1100 N/mm <sup>2</sup>	0.08 mm/rev.
Overhang L <sub>1</sub>	19 mm
Shank tolerance	h6
Ø range	1.19 - 1.32 mm
Flute length L <sub>c</sub>	9 mm
Overall length L	50 mm
Shank Ø D <sub>s</sub>	4 mm

Nominal $\varnothing D_c$	1.2 mm
Reaming oversize in diameter	0.05 - 0.1 mm
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 8093
Through-coolant	no
Shank	DIN 6535 HA to h6
Application for type of drilling	for through hole
Colour ring	green
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
Alu > 10% Si	suitable only under restricted conditions	25 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	30 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	25 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	20 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	15 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	10 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	15 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	12 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable only under restricted conditions	10 m/min	S
GG(G)	suitable	10 m/min	K
CuZn	suitable	25 m/min	N
Uni	suitable		

wet maximum

suitable