

**Garant**
**Solid carbide NC machine reamer Configurable, TiAlN, Nominal Ø DC: 3mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 164344 3      |
| GTIN         | 4045197854476 |
| 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.

**Ramers 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**

|  |              |
|--|--------------|
| Shank tolerance                          | h6           |
| Overall length L                         | 65 mm        |
| Flute length L <sub>c</sub>              | 17 mm        |
| Ø range                                  | 2.81 - 3 mm  |
| Shank Ø D <sub>s</sub>                   | 4 mm         |
| Feed f in steel < 1100 N/mm <sup>2</sup> | 0.12 mm/rev. |
| Nominal Ø D <sub>c</sub>                 | 3 mm         |
| Overhang L <sub>1</sub>                  | 33 mm        |

|                                  |                   |
|----------------------------------|-------------------|
| Number of cutting edges Z        | 6                 |
| 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 <sub>c</sub> | 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