

## Garant

### Solid carbide NC machine reamer Configurable, TiAlN, Nominal Ø DC: 6mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 164344 6      |
| GTIN         | 4045197854544 |
| 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.

**Reamers 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 Ø D <sub>s</sub>                   | 6 mm           |
| Feed f in steel < 1100 N/mm <sup>2</sup> | 0.14 mm/rev.   |
| Shank tolerance                          | h6             |
| Ø range                                  | 5.61 - 6.03 mm |
| Overhang L <sub>1</sub>                  | 55 mm          |
| Nominal Ø D <sub>c</sub>                 | 6 mm           |
| Flute length L <sub>c</sub>              | 26 mm          |
| Number of cutting edges Z                | 6              |

|                                  |                   |
|----------------------------------|-------------------|
| Overall length L                 | 93 mm             |
| Reaming oversize in diameter     | 0.1 - 0.2 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