

Garant**Solid carbide NC machine reamer Configurable, uncoated, Nominal Ø DC: 8,5mm****Order data**

Order number	164345 8,5
GTIN	4045197328328
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

Overhang L_1	79 mm
Nominal Ø D_c	8.5 mm
Feed f in steel $< 1100 \text{ N/mm}^2$	0.15 mm/rev.
Shank tolerance	h6
Shank Ø D_s	8 mm
Overall length L	117 mm
Flute length L_c	33 mm

Ø range	8.1 - 8.6 mm
Number of cutting edges Z	6
Reaming oversize in diameter	0.1 - 0.2 mm
Configurable qualities	5
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Configurable qualities	12
Configurable qualities	13
Configurable tolerances	EF
Configurable tolerances	D
Configurable tolerances	M
Configurable tolerances	H
Configurable tolerances	S
Configurable tolerances	G
Configurable tolerances	F
Configurable tolerances	P
Configurable tolerances	O
Configurable tolerances	CD
Configurable tolerances	R
Configurable tolerances	V
Configurable tolerances	E
Configurable tolerances	J
Configurable tolerances	T
Configurable tolerances	FG
Configurable tolerances	JS

Data sheet

Configurable tolerances	N
Configurable tolerances	C
Configurable tolerances	U
Configurable tolerances	X
Coating	uncoated
Tool material	Solid carbide
Standard	DIN 8093
Through-coolant	no
Shank	DIN 6535 HA with h6
Application for type of drilling	for through holes
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
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
INOX > 900 N/mm ²	suitable only under restricted conditions	8 m/min	M
Ti > 850 N/mm ²	suitable	8 m/min	S
GG(G)	suitable	8 m/min	K
CuZn	suitable	20 m/min	N

Data sheet

Uni	suitable
wet maximum	suitable