

**Garant**
**NC reamer H7, uncoated, Nominal Ø DC mm or inch: 1,5**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 162900 1,5    |
| GTIN         | 4045197089519 |
| Item class   | 110           |

**Description**
**Version:**

**Version suitable for NC** similar to DIN 212 **with straight shank Ø** for **standard chucking** especially in **hydraulic chucks** or **high precision collet chucks**. For **highest concentricity** and **process reliability**. **No need to order special collets**.

With long flutes and left-hand helix.

≤ Ø size 1.7 with 3 teeth; ≥ Ø size 1.8 even number of teeth and irregular spacing. ≤ Ø size 3.7 both ends with centre points; ≥ Ø size 3.8 both ends with centre holes.

Reamer manufacturing tolerance to DIN 1420 for H7 hole tolerance.

**Note:**

For reamers in **1/100 sizes** see **No. 162902**.

For reamers with **diameters and fits to specification** see **No. 162951**

Application for type of drilling: for through holes

Tolerance: H7

Number of cutting edges Z: 3

Tolerance: H7

Flute length  $L_c$ : 8 mm

Overhang  $L_1$ : 18 mm

Overall length L: 40 mm

Number of cutting edges Z: 3

Shank Ø  $D_s$ : 2 mm

**Technical description**

|   |             |
|---|-------------|
| Nominal Ø $D_c$                         | 1.5 mm      |
| Overhang $L_1$                          | 18 mm       |
| Feed f in steel < 750 N/mm <sup>2</sup> | 0.1 mm/rev. |

|                                  |                         |
|----------------------------------|-------------------------|
| Shank tolerance                  | h6                      |
| Shank $\varnothing D_s$          | 2 mm                    |
| Overall length L                 | 40 mm                   |
| Flute length $L_c$               | 8 mm                    |
| Number of cutting edges Z        | 3                       |
| Tolerance                        | H7                      |
| Reaming oversize in diameter     | 0.05 - 0.1 mm           |
| Coating                          | uncoated                |
| Tool material                    | HSS E                   |
| Standard                         | Manufacturer's standard |
| Through-coolant                  | no                      |
| Shank                            | DIN 1835 A to 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                                  | 20 m/min | N        |
| Aluminium (short chipping)     | suitable                                  | 20 m/min | N        |
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 15 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 10 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 7 m/min  | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 5 m/min  | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable only under restricted conditions | 4 m/min  | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 5 m/min  | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 5 m/min  | M        |

|                            |   |          |   |
|----------------------------|---|----------|---|
| Ti > 850 N/mm <sup>2</sup> | suitable only under restricted conditions | 5 m/min  | S |
| GG(G)                      | suitable only under restricted conditions | 5 m/min  | K |
| CuZn                       | suitable only under restricted conditions | 13 m/min | N |
| Uni                        | suitable                                  |          |   |
| Oil                        | suitable                                  |          |   |
| wet maximum                | suitable                                  |          |   |