High-performance reamers, H7 series

Article no. **4195**



VHM | a | HR 500 Short S | WN | H7 | R | HA

for cutting data see page 53

P	M	K	N	S	H
●	●	○	○	●	●

H7 series in accordance with DIN 1420 • extremely unequal flute spacing • central internal coolant supply, outlet on the face • intermediate dimensions of Ø 1.95-20.1 mm possible • for clamping in hydraulic and shrink fit chucks

High-performance reamers, H7 series

Article no. **4196**

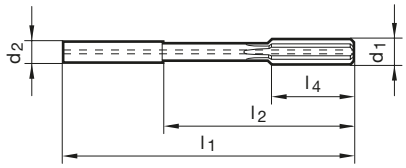


VHM | a | HR 500 Short D | WN | H7 | R | HA

for cutting data see page 53

P	M	K	N	S	H
●	●	○	○	●	●

H7 series in accordance with DIN 1420 • extremely unequal flute spacing • central internal coolant supply, outlet via oil grooves on shank • intermediate dimensions of Ø 1.95-20.1 mm possible • for clamping in hydraulic and shrink fit chucks



d1 mm	d2 h6 mm	l1 mm	l2 mm	l4 mm	Z	Article no. 4195	Article no. 4196
3.00	4.00	50.0	22.0	10.0	4	4195 3.000	4196 3.000
3.50	4.00	50.0	22.0	10.0	4	4195 3.500	4196 3.500
4.00	4.00	50.0	22.0	10.0	4	4195 4.000	4196 4.000
4.50	6.00	58.0	22.0	10.0	4	4195 4.500	4196 4.500
5.00	6.00	58.0	22.0	10.0	4	4195 5.000	4196 5.000
5.50	6.00	58.0	22.0	10.0	4	4195 5.500	4196 5.500
6.00	6.00	58.0	22.0	10.0	4	4195 6.000	4196 6.000
6.50	8.00	76.0	40.0	16.0	6	4195 6.500	4196 6.500
7.00	8.00	76.0	40.0	16.0	6	4195 7.000	4196 7.000
7.50	8.00	76.0	40.0	16.0	6	4195 7.500	4196 7.500
8.00	8.00	76.0	40.0	16.0	6	4195 8.000	4196 8.000
8.50	10.00	76.0	36.0	19.0	6	4195 8.500	4196 8.500
9.00	10.00	76.0	36.0	19.0	6	4195 9.000	4196 9.000
9.50	10.00	76.0	36.0	19.0	6	4195 9.500	4196 9.500
10.00	10.00	76.0	36.0	19.0	6	4195 10.000	4196 10.000
10.50	12.00	80.0	35.0	19.0	6	4195 10.500	4196 10.500
11.00	12.00	80.0	35.0	19.0	6	4195 11.000	4196 11.000
11.50	12.00	80.0	35.0	19.0	6	4195 11.500	4196 11.500
12.00	12.00	80.0	35.0	19.0	6	4195 12.000	4196 12.000
13.00	14.00	90.0	45.0	22.0	6	4195 13.000	4196 13.000
14.00	14.00	90.0	45.0	22.0	6	4195 14.000	4196 14.000

HR 500 Short



Machining group	a	f (mm/rev) with nom. Ø									
	v_c (m/min)	2	3	4	6	8	10	12	14	16	20
P1.1.1 Unalloyed steel, annealed, 0.15 % C, Rm 420 N/mm², 125 HB	180	0.30	0.50	0.65	1.20	1.55	1.90	2.05	2.15	2.30	2.50
P1.1.2 Unalloyed steel, heat-treated, 0.15 % C, Rm 420 N/mm², 125 HB	180	0.30	0.50	0.65	1.20	1.55	1.90	2.05	2.15	2.30	2.50
P1.1.3 Unalloyed steel, annealed, 0.45 % C, Rm 640 N/mm², 190 HB	180	0.30	0.50	0.65	1.20	1.55	1.90	2.05	2.15	2.30	2.50
P1.1.4 Unalloyed steel, heat-treated, 0.45 % C, Rm 640 N/mm², 190 HB	180	0.30	0.50	0.65	1.20	1.55	1.90	2.05	2.15	2.30	2.50
P1.1.5 Unalloyed steel, heat-treated, 0.45 % C, Rm 850 N/mm², 250 HB	162	0.30	0.50	0.65	1.20	1.55	1.90	2.05	2.15	2.30	2.50
P1.1.6 Unalloyed steel, annealed, 0.75 % C, Rm 915 N/mm², 270 HB	162	0.30	0.50	0.65	1.20	1.55	1.90	2.05	2.15	2.30	2.50
P1.1.7 Unalloyed steel, heat-treated, 0.75 % C, Rm 1020 N/mm², 300 HB	144	0.30	0.50	0.65	1.20	1.55	1.90	2.05	2.15	2.30	2.50
P2.1.1 Low-alloy steel, annealed, Rm 610 N/mm², 180 HB	180	0.30	0.45	0.60	1.15	1.45	1.75	1.90	2.05	2.15	2.35
P2.1.2 Low-alloy steel, heat-treated, Rm 930 N/mm², 275 HB	180	0.30	0.45	0.60	1.15	1.45	1.75	1.90	2.05	2.15	2.35
P2.1.3 Low-alloy steel, heat-treated, Rm 1020 N/mm², 300 HB	180	0.30	0.45	0.60	1.15	1.45	1.75	1.90	2.05	2.15	2.35
P2.1.4 Low-alloy steel, heat-treated, Rm 1190 N/mm², 350 HB	121	0.30	0.45	0.60	1.15	1.45	1.75	1.90	2.05	2.15	2.35
P3.1.1 High-alloy steel and tool steel, annealed, Rm 680 N/mm², 200 HB	180	0.25	0.40	0.60	1.05	1.35	1.65	1.80	1.90	2.00	2.20
P3.1.2 High-alloy steel and tool steel, hardened and tempered, Rm 1100 N/mm², 325 HB	121	0.25	0.40	0.60	1.05	1.35	1.65	1.80	1.90	2.00	2.20
M1.1.1 Stainless steel, ferritic/martensitic, with machining additives	80	0.10	0.20	0.25	0.45	0.60	0.70	0.75	0.80	0.85	0.95
M1.1.2 Stainless steel, ferritic/martensitic, annealed, Rm 680 N/mm², 200 HB	62	0.10	0.20	0.25	0.45	0.60	0.70	0.75	0.80	0.85	0.95
M1.1.3 Stainless steel, ferritic/martensitic, heat-treated, Rm 810 N/mm², 240 HB	62	0.10	0.20	0.25	0.45	0.60	0.70	0.75	0.80	0.85	0.95
M2.1.1 Stainless steel, austenitic, quenched, 180 HB	80	0.10	0.20	0.25	0.45	0.60	0.70	0.75	0.80	0.85	0.95
M2.2.1 Duplex steel, high-strength stainless steels	50	0.10	0.20	0.25	0.45	0.60	0.70	0.75	0.80	0.85	0.95
K1.1.1 Grey cast iron, pearlitic/ferritic, 180 HB	80	0.25	0.35	0.50	0.90	1.15	1.40	1.55	1.65	1.70	1.90
K1.1.2 Grey cast iron, pearlitic/martensitic, 260 HB	72	0.25	0.35	0.50	0.90	1.15	1.40	1.55	1.65	1.70	1.90
K1.2.1 Cast iron with spheroidal graphite, ferritic, 160 HB	96	0.25	0.35	0.50	0.90	1.15	1.40	1.55	1.65	1.70	1.90
K1.2.2 Cast iron with spheroidal graphite, pearlitic, 250 HB	96	0.25	0.35	0.50	0.90	1.15	1.40	1.55	1.65	1.70	1.90
K1.3.1 Malleable cast iron, ferritic, 130 HB	80	0.25	0.35	0.50	0.90	1.15	1.40	1.55	1.65	1.70	1.90
K1.3.2 Malleable cast iron, pearlitic, 230 HB	72	0.25	0.35	0.50	0.90	1.15	1.40	1.55	1.65	1.70	1.90
K2.1.1 Vermicular graphite cast iron (GJV)											
K2.2.1 Austenitic-ferritic spheroidal graphite cast iron (ADI)											
N1.1.1 Wrought aluminium alloys, non-hardened, 60 HB											
N1.1.2 Wrought aluminium alloys, hardened, 100 HB											
N2.1.1 Aluminium casting alloys, non-hardened, ≤ 12 % Si, 75 HB											
N2.1.2 Aluminium casting alloys, hardened, ≤ 12 % Si, 90 HB											
N2.1.3 Aluminium casting alloys, non-hardened, > 12 % Si, 130 HB											
N3.1.1 Copper and copper alloys: Free-machining alloy, Pb > 1 %											
N3.1.2 Copper and copper alloys: CuZn, CuSnZn											
N3.1.3 Copper and copper alloys: CuSn, lead-free copper and copper electrolyte											
N4.1.1 Non-metallic materials: Duroplastics, fibre-reinforced plastics	80	0.25	0.35	0.50	0.90	1.15	1.40	1.55	1.65	1.70	1.90
N4.1.2 Non-metallic materials: Hard rubber, wood, etc.	80	0.25	0.35	0.50	0.90	1.15	1.40	1.55	1.65	1.70	1.90
N4.1.3 Non-metallic materials: Graphite	48	0.25	0.35	0.50	0.90	1.15	1.40	1.55	1.65	1.70	1.90
S1.1.1 Heat-resistant alloys, Fe-based, annealed, 200 HB	40	0.10	0.20	0.25	0.45	0.60	0.70	0.75	0.80	0.85	0.95
S1.1.2 Heat-resistant alloys, Fe-based, hardened, 280 HB	40	0.10	0.20	0.25	0.45	0.60	0.70	0.75	0.80	0.85	0.95
S1.1.3 Heat-resistant alloys, Ni- or Co-based, annealed, 250 HB	40	0.10	0.20	0.25	0.45	0.60	0.70	0.75	0.80	0.85	0.95
S1.1.4 Heat-resistant alloys, Ni- or Co-based, hardened, 350 HB	40	0.10	0.20	0.25	0.45	0.60	0.70	0.75	0.80	0.85	0.95
S1.1.5 Heat-resistant alloys, Ni- or Co-based, cast, 320 HB	40	0.10	0.20	0.25	0.45	0.60	0.70	0.75	0.80	0.85	0.95
S2.1.1 Titanium alloys, pure titanium, Rm 400 N/mm²	40	0.10	0.20	0.25	0.45	0.60	0.70	0.75	0.80	0.85	0.95
S2.1.2 Titanium alloys, Alpha and Beta alloys, hardened, Rm 1050 N/mm²	40	0.10	0.20	0.25	0.45	0.60	0.70	0.75	0.80	0.85	0.95
H1.1.1 Hardened steel, hardened and tempered, < 55 HRC	30	0.05	0.10	0.15	0.25	0.30	0.40	0.40	0.45	0.45	0.50
H1.1.2 Hardened steel, hardened and tempered, < 60 HRC	24	0.05	0.10	0.15	0.25	0.30	0.40	0.40	0.45	0.45	0.50
H1.1.3 Hardened steel, hardened and tempered, > 60 HRC	15	0.05	0.10	0.15	0.25	0.30	0.40	0.40	0.45	0.45	0.50
H2.1.1 Chilled cast iron, 400 HB	40	0.10	0.20	0.25	0.45	0.60	0.70	0.75	0.80	0.85	0.95
H2.1.2 Chilled cast iron, hardened and tempered, < 55 HRC	40	0.10	0.20	0.25	0.45	0.60	0.70	0.75	0.80	0.85	0.95

All the values stated are guide values. You can find detailed cutting values online in our Gühring Navigator at webnavigator.guehring.de/en