

Garant

Cermet reaming head HPC H7 steel Through hole, uncoated, Nominal Ø D: 15mm



Order data

Order number	239710 15
GTIN	4062406114077
Item class	23A

Description

Version:

Interchangeable head reamer system **finish ground for fit IT7**. Cutter geometry matched to the application.

System concentricity $\leq 5 \mu\text{m}$ (depending on the head and holder) when mounted.

With short flutes and left-hand helix.

Application:

For through holes.

For HPC/HSC reaming.

Note:

Total usable length = L_1 (arbor No. 239740 / 239745) + l (interchangeable head No. 239710 to 239720).

Suitable assembly wrench No. 219987. Insert for torque wrench No. 219986.

Further sizes available on request.

Technical description

Number of cutting edges Z	6
Arbor size	12 mm
Feed f in steel < 1100 N/mm ²	0.6 mm/rev.
Cutter length l_1	8 mm

Head length l	22 mm
Nominal Ø D	15 mm
Width across flats	10 mm
Series	TopCut
Coating	uncoated
Tool material	Cermet
Standard	Manufacturer's standard
Hole tolerance	H7
Application for type of drilling	for through hole
Machining strategy	HPC
Through-coolant	yes
Semi-Standard	yes
suitable arbor	GARANT TopCut
Type of product	Cutter insert for reaming

User data

	Suitability	V _c	ISO code
Steel < 500 N/mm ²	suitable	140 m/min	P
Steel < 750 N/mm ²	suitable	140 m/min	P
Steel < 900 N/mm ²	suitable	140 m/min	P
Steel < 1100 N/mm ²	suitable	120 m/min	P
GG	suitable only under restricted conditions	160 m/min	K
GGG	suitable only under restricted conditions	140 m/min	K
Oil	suitable		
wet maximum	suitable		