

Garant
Cermet reaming head HPC H7 steel Through hole, uncoated, Nominal Ø D: 22mm

Order data

Order number	239710 22
GTIN	4062406115241
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
Head length l	26 mm
Feed f in steel $< 1100 \text{ N/mm}^2$	0.6 mm/rev.
Nominal Ø D	22 mm

Arbor size	20 mm
Cutter length l_1	12 mm
Width across flats	16 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		