

**Garant**
**Cermet reaming head HPC H7 steel Through hole, uncoated, Nominal Ø D: 42mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 239710 42     |
| GTIN         | 4062406115364 |
| 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**

|   |             |
|---|-------------|
| Cutter length $l_1$                       | 12 mm       |
| Head length $l$                           | 30 mm       |
| Feed $f$ in steel $< 1100 \text{ N/mm}^2$ | 0.8 mm/rev. |
| Nominal Ø D                               | 42 mm       |

|                                  |                           |
|----------------------------------|---------------------------|
| Arbor size                       | 29 mm                     |
| Number of cutting edges Z        | 8                         |
| Width across flats               | 24 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 <sub>c</sub> | ISO code |
|--------------------------------|---|----------------|----------|
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 140 m/min      | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 140 m/min      | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 140 m/min      | P        |
| Steel < 1100 N/mm <sup>2</sup> | 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                                  |                |          |