

**Garant**
**HSS high-performance reamer HPC blind hole, TiAlN, Nominal  $\varnothing$  DC: 28mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 164359 28     |
| GTIN         | 4045197770042 |
| Item class   | 10N           |

**Description**
**Version:**

**Version suitable for NC** with straight shank  $\varnothing$  for the standardised toolholder, specially in **hydraulic chucks** or **high-accuracy chucks**.

This ensures **very high concentricity** and **process reliability**.

It is no longer necessary to procure special arbors.

With internal coolant feed for **HPC use** to reduce production costs.

With short, straight flutes.

**Tolerance specifications:**

**Configurable:**Reamers finish ground to match your specification.

**H7:** Version to DIN1420 for H7 bore tolerance.

**Application:**

For **HPC/HSC reaming** of **blind holes**.

**Technical description**

|  |                 |
|--|-----------------|
| Feed f in steel < 1100 N/mm <sup>2</sup> | 0.4 mm/rev.     |
| Number of cutting edges Z                | 8               |
| $\varnothing$ range                      | 27.21 - 28.2 mm |
| Overhang L <sub>1</sub>                  | 119 mm          |
| Nominal $\varnothing$ D <sub>c</sub>     | 28 mm           |
| Shank $\varnothing$ D <sub>s</sub>       | 25 mm           |
| Flute length L <sub>c</sub>              | 25 mm           |
| Overall length L                         | 180 mm          |

|                                  |                         |
|----------------------------------|-------------------------|
| Tolerance                        | Configurable            |
| Reaming oversize in diameter     | 0.3 mm                  |
| Coating                          | TiAlN                   |
| Tool material                    | HSS                     |
| Standard                         | Manufacturer's standard |
| Through-coolant                  | yes, with 25 bar        |
| Shank                            | DIN 6535 HA with h6     |
| Machining strategy               | HPC                     |
| Application for type of drilling | for blind holes         |
| Colour ring                      | green                   |
| Type of product                  | Phillips bit            |

## User data

|                                | Suitability                               | V <sub>c</sub> | ISO code |
|--------------------------------|---|----------------|----------|
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 45 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 45 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 35 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 35 m/min       | P        |
| GG                             | suitable                                  | 40 m/min       | K        |
| GGG                            | suitable                                  | 30 m/min       | K        |
| Uni                            | suitable                                  |                |          |
| wet maximum                    | suitable                                  |                |          |
| wet minimum                    | suitable only under restricted conditions |                |          |