

**Garant**
**HSS high-performance reamer HPC blind hole, TiAlN, Nominal  $\varnothing$  DC: 33mm**

**Order data**

Order number	164359 33
GTIN	4045197770080
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**

Flute length $L_c$	25 mm
Overhang $L_1$	139 mm
Number of cutting edges $Z$	8
$\varnothing$ range	32.21 - 33.2 mm
Nominal $\varnothing$ $D_c$	33 mm
Feed $f$ in steel < 1100 N/mm <sup>2</sup>	0.45 mm/rev.
Shank $\varnothing$ $D_s$	25 mm
Overall length $L$	200 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		