Garant

GARANT Master Steel solid carbide high-performance reamer HPC through hole, TiAlN, Nominal ⌀ DC: 19mm

Order data

Order number	164420 19
GTIN	4062406284350
Item class	10P

Description

Version:
The latest generation of **universal** HPC reamers. Extra-short teeth for increased cutting performance values. Optimised cooling strategy with radially arranged coolant outlets aligned directly to the teeth. **For uncompromising applications in steel and stainless steel.** Reliable machining of high-tensile steels **up to 60 HRC. Version suitable for NC** with straight shank ⌀ for standard arbors especially in **hydraulic chucks** or **high precision collet chucks.**
Very high concentricity and process reliability due to unequal spacing.
Tolerance specifications:
Configurable: Reamers finish ground to match your specification.
H7: Version for H7 bore tolerance.
0/0.005 mm: Manufacturing or cutting tolerance of nominal ⌀ D_C.
Application:
Special version for through holes.

Technical description

⌀ range	18.201 - 19.2 mm
Tolerance	Configurable
Nominal ⌀ D_C	19 mm
Overall length L	150 mm
Series	Master Steel
Shank ⌀ D_s	20 mm
Feed f in stainless steel < 900 N/mm^2	0.6 mm/rev.

Feed f in steel < 1100 N/mm²	2 mm/rev.
Flute length L_c	15 mm
Overhang L_1	100 mm
Number of cutting edges Z	6
Reaming oversize in diameter	0.2 mm
Coating	TiAlN
Tool material	Solid carbide
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 through holes
Colour ring	green
Type of product	Phillips bit

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm²	suitable only under restricted conditions	180 m/min	P
Steel < 750 N/mm²	suitable	180 m/min	P
Steel < 900 N/mm²	suitable	180 m/min	P
Steel < 1100 N/mm²	suitable	150 m/min	P
Steel < 1400 N/mm²	Suitable	100 m/min	P
Steel < 55 HRC	Suitable	12 m/min	H
Steel < 60 HRC	Suitable only under restricted conditions	8 m/min	H
INOX < 900 N/mm²	suitable	50 m/min	M
INOX > 900 N/mm²	suitable	30 m/min	M
GG	suitable	110 m/min	K

GGG	suitable	90 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		