

## Garant

### GARANT Master Alu solid carbide high-performance reamer HPC blind hole, DLC, Nominal Ø DC: 18mm



#### Order data

Order number	164405 18
GTIN	4062406284091
Item class	10P

#### Description

##### Version:

**Special** HPC reamers of the latest generation, **for machining aluminium**, with improved tooth geometry and further developed carbide substrate. Extra-short teeth for increased cutting performance values. Optimised cooling strategy with radially arranged coolant outlets aligned directly to the teeth. **Version suitable for NC** with straight shank Ø for standard arbors especially in **hydraulic chucks** or **high precision collet chucks**. Very high concentricity and process reliability due to unequal spacing of the teeth and special profile of the round chamfer width.

Version with DLC sp<sup>2</sup> coating.

##### Tolerance specifications:

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

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

##### Application:

Special version for blind holes.

#### Technical description

Overhang L <sub>1</sub>	102 mm
Ø range	17.201 - 18.2 mm
Number of cutting edges Z	6
Overall length L	150 mm
Feed f in cast alu	2.4 mm/rev.
Flute length L <sub>c</sub>	15 mm

Shank $\varnothing D_s$	18 mm
Tolerance	configurable
Series	Master Alu
Nominal $\varnothing D_c$	18 mm
Reaming oversize in diameter	0.2 mm
Coating	DLC
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
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	yellow
Type of product	Phillips bit

## User data

	Suitability	$V_c$	ISO code
Aluminium	suitable	250 m/min	N
Aluminium (short chipping)	suitable	250 m/min	N
Alu > 10% Si	suitable	250 m/min	N
wet maximum	suitable		
wet minimum	suitable		