

Garant

GARANT Master Steel solid carbide high-performance reamer HPC blind hole, TiAlN, Nominal Ø DC: 18mm



Order data

Order number	164425 18
GTIN	4062406284596
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 Ø 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 Ø D_c.

Application:

Special version for blind holes.

Technical description

Number of cutting edges Z	6
Feed f in stainless steel < 900 N/mm ²	0.6 mm/rev.
Tolerance	Configurable
Flute length L _c	15 mm
Overall length L	150 mm
Ø range	17.201 - 18.2 mm

Series	Master Steel
Shank $\varnothing D_s$	18 mm
Overhang L_1	102 mm
Feed f in steel < 1100 N/mm ²	2 mm/rev.
Nominal $\varnothing D_c$	18 mm
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 blind holes
Colour ring	green
Type of product	Phillips bit

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable only under restricted conditions	180 m/min	P
Steel < 750 N/mm ²	suitable	180 m/min	P
Steel < 900 N/mm ²	suitable	180 m/min	P
Steel < 1100 N/mm ²	suitable	150 m/min	P
Steel < 1400 N/mm ²	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/mm ²	suitable	50 m/min	M
INOX > 900 N/mm ²	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		