

Garant

GARANT Master Steel solid carbide high-performance reamer HPC blind hole, TiAlN, Nominal \varnothing DC: 4mm



Order data

Order number	164425 4
GTIN	4062406284374
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 \varnothing 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 \varnothing D_c.

Application:

Special version for blind holes.

Technical description

Flute length L _c	8 mm
Feed f in steel < 1100 N/mm ²	0.6 mm/rev.
Number of cutting edges Z	4
Feed f in stainless steel < 900 N/mm ²	0.2 mm/rev.
Nominal \varnothing D _c	4 mm
Overhang L ₁	39 mm

Tolerance	Configurable
Overall length L	75 mm
Series	Master Steel
Ø range	3.701 - 4.2 mm
Shank Ø D _s	6 mm
Reaming oversize in diameter	0.1 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		