



KOMET REAMAX® TS reaming head H7 Carbide ASG3000, TiN, Nominal Ø D: 22 mm



Order data

Order number	239826 22
GTIN	4047109229280
Item class	27E

Description

Version:

Reaming heads **finish ground for fit H7**.

Cutter geometry matched to the application. Adjustable down to the μm range for wear compensation and for very tight basic tolerances down to IT4. For use in through holes up to $5 \times D$.

For interrupted machining.

In geometry **ASG3000** with lead angle 45° and additional chip flute for positive chip clearance along the cutting edge. For **blind and through holes**.

Note:

- **Other sizes available on request on short lead times.**
- **See No. 239880 – 239940 for suitable holders.**
- **Application data apply to through holes.**

Through-coolant: yes

for holders No. 239880 – 239940: 22 – 26.99

Cutter length l_1 : 6 mm

Head length l : 20 mm

Number of cutting edges Z : 6

Feed f in steel $< 750 \text{ N/mm}^2$: 0.8 mm/rev.

Technical description

for holders No. 239880 – 239940	22 – 26.99
Head length l	20 mm
Feed f in steel < 750 N/mm ²	0.8 mm/rev.
Number of cutting edges Z	6
Cutter length l ₁	6 mm
Nominal Ø D	22 mm
Coating	TiN
Hole tolerance	H7
Application for type of drilling	for blind holes and through holes
Through-coolant	yes
Type of product	Cutter insert for reaming

User data

	Suitability	V _c	ISO code
Steel < 500 N/mm ²	suitable only under restricted conditions	120 m/min	P
Steel < 750 N/mm ²	suitable only under restricted conditions	100 m/min	P
Steel < 900 N/mm ²	suitable only under restricted conditions	80 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	70 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	25 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	15 m/min	M
CuZn	suitable	100 m/min	N
wet maximum	suitable		