

**Garant**
**Solid carbide forward / reverse deburring tool, TiAlN, Ø DC: 9,8mm**

**Order data**

Order number	208185 9,8
GTIN	4062406131371
Item class	11X

**Description**
**Version:**
**Extra long shank.**

Double ground head **with 45° angle.**

**Application:**

For **universal application** in virtually all materials. The newly developed coating **effectively prevents formation of built-up edges** – even in aluminium and stainless steel.

For **forward** and **reverse deburring** and **chamfering** even where access is difficult.

Particularly suitable for **contouring applications.**

**Technical description**

$L_4 +0.5$	31 mm
Shank Ø $D_s$	10 mm
Overall length L	100 mm
Shape	flat
Cutting edge Ø $D_c$	9.8 mm
$L_2 +0.5$	4 mm
Corner chamfer angle	45 degrees
Ø $D_1 +0.05$	6 mm
Feed $f_z$ for side milling in steel < 900 N/mm <sup>2</sup>	0.014 mm
No. of teeth Z	5
Chamfer mill	backwards and forwards 45

Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Tolerance nominal $\varnothing$	$\pm 0.05$
Countersink tip angle	90 degrees
Cutting width $a_e$ for milling operation	0.25xL2 for side milling
Shank	DIN 6535 HA to h6
Through-coolant	no
Shank tolerance	h6
Colour ring	green
Type of product	Deburrers

## User data

	Suitability	$V_c$	ISO code
Aluminium (short chipping)	suitable	125 m/min	N
Alu > 10% Si	suitable	75 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	70 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	70 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	45 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	40 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	35 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	30 m/min	M
GG(G)	suitable	45 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		

dry	suitable
Air	suitable
<b>Services</b>	

Shank grinding Type HB	129100 HB
------------------------	-----------