

**Garant**
**GARANT Diabolo solid carbide deburrer, spiral flutes 90°, TiAlN, Ø h6 DC: 8mm**

**Order data**

Order number	208158 8
GTIN	4062406288242
Item class	11X

**Description**
**Version:**

Deburrer specially developed for **hard machining**. The further development of the Diabolo coating permits even longer tool life and improved surface quality.

Tolerance: **Dimension S = ± 0.2 mm.**

**Point angle = ±5 arc minutes.**

**Outstanding surface qualities** thanks to the 35° **helix angle**.

**Application:**

Perfectly suitable for **chamfering** and **deburring** component edges and for **contouring applications**.

**Technical description**

Series	Diabolo
Shank Ø D <sub>s</sub>	8 mm
No. of teeth Z	6
Cutting edge Ø D <sub>c</sub>	8 mm
Overall length L	63 mm
Shank	DIN 6535 HA to h6
Dimension S	5.6 mm
Chamfer mill	45 degrees
Corner chamfer angle	45 degrees

Feed $f_z$ in steel < 60 HRC	0.04 mm
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Tolerance nominal $\varnothing$	h6
Helix angle	35 degrees
Direction of infeed	horizontal and oblique
Countersink tip angle	90 degrees
Through-coolant	no
Shank tolerance	h6
Colour ring	red
Type of product	Deburrers

## User data

	Suitability	$V_c$	ISO code
Steel < 1100 N/mm <sup>2</sup>	suitable only under restricted conditions	140 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	120 m/min	P
Steel < 55 HRC	suitable	100 m/min	H
Steel < 60 HRC	suitable	90 m/min	H
Steel < 65 HRC	suitable	60 m/min	H
Steel < 67 HRC	suitable	35 m/min	H
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		

## Services

Shank grinding Type HB	129100 HB
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