

## Garant

### Solid carbide deburrer, spiral flutes 90°, TiSiN, Ø h6 DC: 6Mmm



#### Order data

Order number	208156 6M
GTIN	4062406378868
Item class	11X

#### Description

##### Version:

Deburrer for **universal application** on virtually all materials. The newly developed coating effectively prevents built-up edges, even in aluminium or stainless steel.

Tolerance: **Dimension S = +/- 0.2 mm.**

**Point angle = +/- 5 arc minutes.**

**Outstanding surface qualities** thanks to the 35° **helix angle**. Extra-long deburrers for outstanding deburring results on particularly difficult-to-access contours. Tools without tip.

##### Application:

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

#### Technical description

Cutting edge Ø D <sub>c</sub>	6 mm
small Ø D <sub>3</sub>	3 mm
Dimension S	2.1 mm
Shank	DIN 6535 HA to h6
Chamfer mill	45 degrees
Corner chamfer angle	45 degrees
No. of teeth Z	4
large Ø D <sub>2</sub>	6 mm
Shank Ø D <sub>s</sub>	6 mm

Overall length L	100 mm
Feed $f_z$ in steel < 900 N/mm <sup>2</sup>	0.03 mm
Coating	TiSiN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
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	green
Type of product	Deburrers

## User data

	Suitability	$V_c$	ISO code
Alu plastics	suitable only under restricted conditions	180 m/min	N
Aluminium (short chipping)	suitable	300 m/min	N
Alu > 10% Si	suitable	220 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	130 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	115 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	110 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 1400 N/mm <sup>2</sup>	Suitable only under restricted conditions	65 m/min	P
Steel < 55 HRC	Suitable only under restricted conditions	35 m/min	H

INOX < 900 N/mm <sup>2</sup>	suitable	90 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	70 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	50 m/min	S
GG(G)	suitable	100 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	Suitable only under restricted conditions		
Air	Suitable only under restricted conditions		

### Services

Shank grinding Type HB

129100 HB