

**Garant**
**GARANT Diabolo solid carbide deburrer, spiral flutes 90°, TiAlN, Ø h6 DC: 6Mmm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 208158 6M     |
| GTIN         | 4062406378899 |
| 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**. 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**

|                               |                   |
|-------------------------------|-------------------|
| No. of teeth Z                | 6                 |
| Cutting edge Ø D <sub>c</sub> | 6 mm              |
| Overall length L              | 100 mm            |
| Shank Ø D <sub>s</sub>        | 6 mm              |
| Shank                         | DIN 6535 HA to h6 |
| large Ø D <sub>2</sub>        | 6 mm              |
| Corner chamfer angle          | 45 degrees        |
| Series                        | Diabolo           |

|                                 |                         |
|---------------------------------|-------------------------|
| small $\varnothing D_3$         | 3 mm                    |
| Dimension S                     | 2.1 mm                  |
| Chamfer mill                    | 45 degrees              |
| Feed $f_z$ in steel < 60 HRC    | 0.02 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  
**Services**

suitable

Shank grinding Type HB

129100 HB