

**Garant**
**GARANT Diabolo solid carbide deburrer, spiral flutes 60°, TiAlN, Ø h6 DC: 6mm**

**Order data**

Order number	208167 6
GTIN	4062406380403
Item class	11X

**Description**
**Version:**

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

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.**

**Application:**

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

**Technical description**

Feed $f_z$ in steel < 60 HRC	0.03 mm
No. of teeth Z	6
Cutting edge Ø $D_c$	6 mm
Corner chamfer angle	60 degrees
Overall length L	57 mm
Dimension S	5.9 mm
Shank Ø $D_s$	6 mm
Series	Diabolo
Shank	DIN 6535 HA to h6

Chamfer mill	30 degrees
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	60 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 only under restricted conditions	35 m/min	H
wet minimum	Suitable only under restricted conditions		
dry	suitable		
Air	suitable		

