

Garant

GARANT Diabolo solid carbide deburrer, spiral flutes 90°, TiAlN, Ø h6 DC: 12Mmm



Order data

Order number	208158 12M
GTIN	4062406380311
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

Dimension S	4.2 mm
Shank	DIN 6535 HA to h6
Shank Ø D _s	12 mm
small Ø D ₃	6 mm
Feed f _z in steel < 60 HRC	0.045 mm
Series	Diabolo
Corner chamfer angle	45 degrees
Chamfer mill	45 degrees

Cutting edge $\varnothing D_c$	12 mm
Overall length L	120 mm
No. of teeth Z	6
large $\varnothing D_2$	12 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 ²	suitable only under restricted conditions	140 m/min	P
Steel < 1400 N/mm ²	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