

## Garant

### Solid carbide forward / reverse deburring tool, TiAlN, Ø DC: 3,8mm



#### Order data

Order number	208180 3,8
GTIN	4045197465450
Item class	11X

#### Description

##### Version:

##### Extra long shank.

Double ground head **with 45° angle.**

##### Application:

For **forward** and **reverse deburring** and **chamfering** even where access is difficult.

Particularly suitable for **contouring applications.**

#### Technical description

Feed $f_z$ for side milling in steel $< 900 \text{ N/mm}^2$	0.01 mm
Shape	pointed
Cutting edge Ø $D_c$	3.8 mm
Ø $D_1 + 0.05$	2.9 mm
No. of teeth Z	4
$L_2 + 0.5$	2.7 mm
$L_4 + 0.5$	13 mm
Shank Ø $D_s$	4 mm
Overall length L	75 mm
Corner chamfer angle	45 degrees
Chamfer mill	backwards and forwards 45
Coating	TiAlN
Tool material	Solid carbide

Standard	Manufacturer's standard
Type	N
Tolerance nominal $\varnothing$	$\pm 0.05$
Countersink tip angle	90 degrees
Cutting width $a_e$ for milling operation	$0.25 \times L_2$ for side milling
Shank	DIN 6535 HA to h6
Shank tolerance	h6
Colour ring	without
Type of product	Deburrers

### User data

	Suitability	$V_c$	ISO code
Aluminium (short chipping)	suitable	115 m/min	N
Alu > 10% Si	suitable	70 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	65 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	65 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	40 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	35 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	35 m/min	M
GG(G)	suitable	40 m/min	K
Uni	suitable only under restricted conditions		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		

