

Garant

Solid carbide forward / reverse deburring tool, TiAlN, Ø DC: 4mm



Order data

Order number	208180 4
GTIN	4045197198365
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

Shape	pointed
$L_4 +0.5$	13 mm
Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.01 mm
No. of teeth Z	4
$\varnothing D_1 +0.05$	2.9 mm
Cutting edge $\varnothing D_c$	4 mm
$L_2 +0.5$	2.7 mm
Shank $\varnothing D_s$	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	± 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 ²	suitable	65 m/min	P
Steel < 750 N/mm ²	suitable	65 m/min	P
Steel < 900 N/mm ²	suitable	40 m/min	P
Steel < 1100 N/mm ²	suitable	35 m/min	P
INOX < 900 N/mm ²	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		

