Garant

Solid carbide forward / reverse deburring tool, TiAlN, ∅ DC: 12mm

Order data

Order number	208180 12
GTIN	4045197129451
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

Cutting edge ∅ D_C	12 mm
L_2 +0.5	6 mm
No. of teeth Z	4
Shape	flat
L_4 +0.5	94 mm
Feed f_z for side milling in steel < 900 N/mm^2	0.017 mm
Shank ∅ D_s	6 mm
Overall length L	100 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 ∅	±0.05
Countersink tip angle	90 degrees
Cutting width a_e for milling operation	0.25×L2 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/mm²	suitable	65 m/min	P
Steel < 750 N/mm²	suitable	65 m/min	P
Steel < 900 N/mm²	suitable	40 m/min	P
Steel < 1100 N/mm²	suitable	35 m/min	P
INOX < 900 N/mm²	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		

Services

Shank grinding Type HB	129100 HB