

Garant
Solid carbide deburrer, spiral flutes 90°, uncoated, Ø h6 DC: 6Mmm

Order data

Order number	208154 6M
GTIN	4062406774790
Item class	11X

Description
Version:

Deburrer with **polished flutes** and **sharp cutting edges** especially for machining aluminium and plastic.

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

No. of teeth Z	4
Shank Ø D _s	6 mm
Chamfer mill	45 degrees
large Ø D ₂	6 mm
Cutting edge Ø D _c	6 mm
Dimension S	2.1 mm
Shank	DIN 6535 HA to h6
small Ø D ₃	3 mm
Overall length L	100 mm

Feed f_z in short-chipping aluminium	0.045 mm
Feed f_z in PMMA acrylic	0.045 mm
Coating	uncoated
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
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	yellow
Type of product	Deburrers

User data

	Suitability	V_c	ISO code
Alu plastics	suitable	480 m/min	N
Aluminium (short chipping)	suitable	440 m/min	N
Alu > 10% Si	suitable	400 m/min	N
PMMA acrylic	suitable	210 m/min	N
PEEK	suitable	150 m/min	N
PVDF GF20	suitable	150 m/min	N
POM GF25	suitable	150 m/min	N
PA 66 GF30	suitable	150 m/min	N
PEEK GF30	suitable	130 m/min	N
PTFE CF25	suitable	160 m/min	N
Honeycomb sandwich	suitable	300 m/min	N

Cu	suitable	160 m/min	N
CuZn	suitable	200 m/min	N
wet maximum	suitable		

Services

Shank grinding Type HB	129100 HB
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