

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

**Order data**

Order number	208154 6
GTIN	4062406774783
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.**

**Application:**

Perfectly suitable for **chamfering** and **deburring** component edges and for **contouring applications.**

**Technical description**

Cutting edge Ø D <sub>c</sub>	6 mm
Dimension S	4.2 mm
Shank	DIN 6535 HA to h6
Shank Ø D <sub>s</sub>	6 mm
No. of teeth Z	4
Overall length L	57 mm
Chamfer mill	45 degrees
Feed f <sub>z</sub> in PMMA acrylic	0.045 mm
Feed f <sub>z</sub> in short-chipping aluminium	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