

Garant
Solid carbide deburrer, spiral flutes 90°, uncoated, Ø h6 DC: 4mm

Order data

Order number	208154 4
GTIN	4062406774776
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

Shank	DIN 6535 HA to h6
Chamfer mill	45 degrees
Dimension S	2.8 mm
Overall length L	50 mm
No. of teeth Z	4
Cutting edge Ø D _c	4 mm
Shank Ø D _s	4 mm
Feed f _z in short-chipping aluminium	0.03 mm
Feed f _z in PMMA acrylic	0.03 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		

