

Garant

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



Order data

| | |
|--------------|---------------|
| Order number | 208156 4 |
| GTIN | 4062406774912 |
| Item class | 11X |

Description

Version:

Deburrer for **universal application** on virtually all materials. The newly developed coating effectively prevents built-up edges, even in aluminium or stainless steel.

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 |
| Feed f_z in steel < 900 N/mm ² | 0.04 mm |
| Shank Ø D_s | 4 mm |
| Cutting edge Ø D_c | 4 mm |
| Overall length L | 50 mm |
| Dimension S | 2.8 mm |
| No. of teeth Z | 4 |
| Chamfer mill | 45 degrees |
| Coating | TiSiN |
| 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 | green |
| Type of product | Deburrers |

User data

| | Suitability | V_c | ISO code |
|--------------------------------|---|-----------|----------|
| Alu plastics | suitable only under restricted conditions | 180 m/min | N |
| Aluminium (short chipping) | suitable | 300 m/min | N |
| Alu > 10% Si | suitable | 220 m/min | N |
| Steel < 500 N/mm ² | suitable | 130 m/min | P |
| Steel < 750 N/mm ² | suitable | 115 m/min | P |
| Steel < 900 N/mm ² | suitable | 110 m/min | P |
| Steel < 1100 N/mm ² | suitable | 80 m/min | P |
| Steel < 1400 N/mm ² | Suitable only under restricted conditions | 65 m/min | P |
| Steel < 55 HRC | Suitable only under restricted conditions | 35 m/min | H |
| INOX < 900 N/mm ² | suitable | 90 m/min | M |
| INOX > 900 N/mm ² | suitable | 70 m/min | M |
| Ti > 850 N/mm ² | suitable | 50 m/min | S |
| GG(G) | suitable | 100 m/min | K |

| | |
|-------------|---|
| Uni | suitable |
| wet maximum | suitable |
| wet minimum | suitable only under restricted conditions |
| dry | Suitable only under restricted conditions |
| Air | Suitable only under restricted conditions |