

## Garant

### Solid carbide deburrer, spiral flutes 90°, TiSiN, Ø h6 DC: 3mm



## Order data

Order number	208156 3
GTIN	4062406774905
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

Feed $f_z$ in steel < 900 N/mm <sup>2</sup>	0.03 mm
Overall length L	50 mm
Chamfer mill	45 degrees
No. of teeth Z	4
Dimension S	2.1 mm
Shank Ø D <sub>s</sub>	3 mm
Cutting edge Ø D <sub>c</sub>	3 mm
Shank	DIN 6535 HA to h6
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 <sup>2</sup>	suitable	130 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	115 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	110 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 1400 N/mm <sup>2</sup>	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 <sup>2</sup>	suitable	90 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	70 m/min	M
Ti > 850 N/mm <sup>2</sup>	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