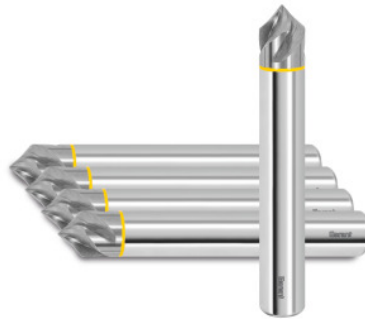


Garant**Solid carbide deburrer, spiral flutes 90°, uncoated, Ø h6 DC: 12mm****Order data**

| | |
|--------------|---------------|
| Order number | GG8154 12 |
| GTIN | 4067263090991 |
| Item class | GGN |

Description**Version:****Same as No. 208154.**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**

| | |
|--|-------------------|
| Chamfer mill | 45 degrees |
| Feed f_z in PMMA acrylic | 0.085 mm |
| Shank | DIN 6535 HA to h6 |
| Dimension S | 8.5 mm |
| Feed f_z in short-chipping aluminium | 0.085 mm |

| | |
|---------------------------------|----------------------------------|
| No. of teeth Z | 4 |
| Shank $\varnothing D_s$ | 12 mm |
| Contents | 5 |
| Overall length L | 83 mm |
| Cutting edge $\varnothing D_c$ | 12 mm |
| Coating | uncoated |
| Tool material | Solid carbide |
| Standard | Works standard |
| Type | N |
| Tolerance nominal \varnothing | h6 |
| Helix angle | 35 degrees |
| Direction of infeed | horizontal, oblique and vertical |
| Countersink tip angle | 90 degrees |
| Through-coolant | no |
| Shank tolerance | h6 |
| Colour ring | red |
| 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 | | |

Accessories

Solid carbide deburrer, spiral flutes 90° Ø h6 DC 12 mm

208154 12