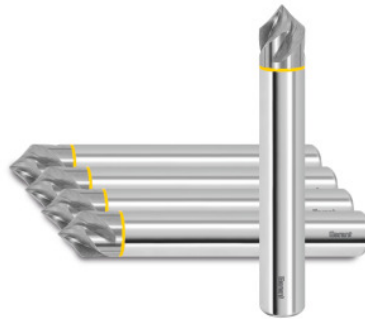


## Garant

**Solid carbide deburrer, spiral flutes 90°, uncoated, Ø h6 DC: 12Mmm**



### Order data

Order number	GG8154 12M
GTIN	4067263091103
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**. Extra-long deburrers for outstanding deburring results on particularly difficult-to-access contours. Tools without tip.

**Application:**

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

### Technical description

Feed $f_z$ in short-chipping aluminium	0.085 mm
Feed $f_z$ in PMMA acrylic	0.085 mm
Cutting edge $\varnothing D_c$	12 mm
Overall length L	120 mm

Shank $\varnothing D_s$	12 mm
Chamfer mill	45 degrees
small $\varnothing D_3$	6 mm
Contents	5
Shank	DIN 6535 HA to h6
large $\varnothing D_2$	12 mm
No. of teeth Z	4
Dimension S	4.2 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 12M mm

208154 12M