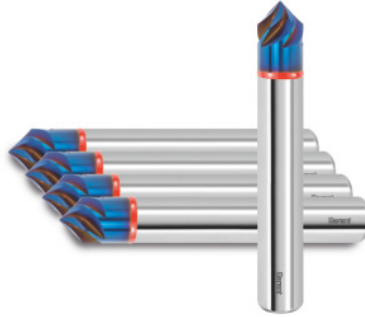


## Garant

### GARANT Diabolo solid carbide deburrer, spiral flutes 90°, TiAlN, Ø h6 DC: 6Mmm



#### Order data

Order number	GG8158 6M
GTIN	4067263091370
Item class	GGN

#### Description

##### Version:

**Same as No. 208158.**

Deburrer specially developed for **hard machining**. The further development of the Diabolo coating permits even longer tool life and improved surface quality.

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

Contents	5
Overall length L	100 mm
small Ø D <sub>3</sub>	3 mm

Cutting edge $\varnothing D_c$	6 mm
large $\varnothing D_2$	6 mm
Shank $\varnothing D_s$	6 mm
Series	Diabolo
Shank	DIN 6535 HA to h6
Feed $f_z$ in steel < 60 HRC	0.02 mm
Corner chamfer angle	45 degrees
Chamfer mill	45 degrees
Dimension S	2.1 mm
No. of teeth Z	6
Coating	TiAlN
Tool material	Solid carbide
Standard	Works standard
Type	H
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
Steel < 1100 N/mm <sup>2</sup>	suitable only under restricted conditions	140 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	120 m/min	P
Steel < 55 HRC	suitable	100 m/min	H

Steel < 60 HRC	suitable	90 m/min	H
Steel < 65 HRC	suitable	60 m/min	H
Steel < 67 HRC	suitable	35 m/min	H
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		

## Accessories

GARANT Diabolo solid carbide deburrer, spiral flutes 90° Ø  
h6 DC 6M mm

208158 6M