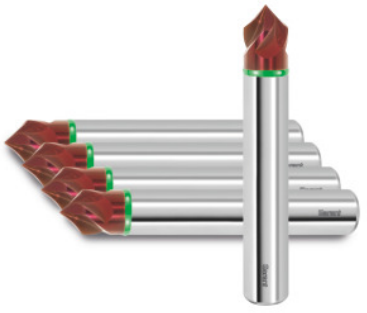
Garant

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



Order data

Order number	GG8156 4
GTIN	4067263091172
Item class	GGN

Description

Version:
Same as No. 208156.
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
Dimension S	2.8 mm
No. of teeth Z	4
Shank ⌀ D_s	4 mm
Feed f_z in steel < 900 N/mm^2	0.04 mm

Overall length L	50 mm
Chamfer mill	45 degrees
Contents	5
Cutting edge ⌀ D_C	4 mm
Coating	TiSiN
Tool material	Solid carbide
Standard	Works standard
Type	N
Tolerance nominal ⌀	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	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/mm²	suitable	130 m/min	P
Steel < 750 N/mm²	suitable	115 m/min	P
Steel < 900 N/mm²	suitable	110 m/min	P
Steel < 1100 N/mm²	suitable	80 m/min	P
Steel < 1400 N/mm²	suitable only under restricted conditions	65 m/min	P

Steel < 55 HRC	suitable only under restricted conditions	35 m/min	H
INOX < 900 N/mm²	suitable	90 m/min	M
INOX > 900 N/mm²	suitable	70 m/min	M
Ti > 850 N/mm²	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		

Accessories

Solid carbide deburrer, spiral flutes90° ∅ h6 DC 4 mm	208156 4