

Garant
Solid carbide forward / reverse deburring tool with helix angle, TiSiN, Ø DC: 9,8mm

Order data

Order number	208181 9,8
GTIN	4067263107491
Item class	11X

Description
Version:
Extra-long shank.

Double ground head with **45° angle**.

The **helix angle ground into the head on both sides** produces a **much softer cut** and thus an **excellent surface quality**. For **universal application** in virtually all materials. The newly developed coating **effectively prevents the formation of built-up edges** – even in aluminium and corrosion-resistant steels (INOX). Flat version

Application:

For **forward** and **reverse deburring** and **chamfering** even where access is difficult.

Particularly suitable for **contouring applications**.

Note:

Successor product to No. 208180.

Technical description

Ø D ₁ +0.05	6 mm
Shape	Flat
Overall length L	100 mm
Corner chamfer angle	45 degrees
No. of teeth Z	5
L ₄ +0.5	96 mm
Shank Ø D _s	6 mm

Feed f_z for side milling in steel < 900 N/mm ²	0.05 mm
Chamfer mill	backwards and forwards 45
$L_2 +0.5$	4 mm
Cutting edge $\varnothing D_c$	9.8 mm
Helix angle	5 degrees
Coating	TiSiN
Tool material	Solid carbide
Standard	Works standard
Type	N
Tolerance nominal \varnothing	± 0.05
Countersink tip angle	90 degrees
Cutting width a_e for milling operation	0.25xL2 for side milling
Shank	DIN 6535 HA to h6
Through-coolant	no
Shank tolerance	h6
Colour ring	without
Type of product	Deburrers

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable	130 m/min	N
Alu > 10% Si	suitable	80 m/min	N
Steel < 500 N/mm ²	suitable	75 m/min	P
Steel < 750 N/mm ²	suitable	75 m/min	P
Steel < 900 N/mm ²	suitable	50 m/min	P
Steel < 1100 N/mm ²	suitable	45 m/min	P
INOX < 900 N/mm ²	suitable	40 m/min	M

INOX > 900 N/mm ²	suitable only under restricted conditions	30 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	20 m/min	S
GG(G)	suitable	50 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air Services	suitable		
Shank grinding Type HB			129100 HB