

Garant
Solid carbide forward / reverse deburring tool with helix angle, TiSiN, Ø DC: 10mm

Order data

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|--------------|---------------|
| Order number | 208181 10 |
| GTIN | 4067263107507 |
| 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

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|-------------------------------|--------|
| Ø D ₁ +0.05 | 6 mm |
| Shank Ø D _s | 6 mm |
| Overall length L | 100 mm |
| L ₄ +0.5 | 96 mm |
| L ₂ +0.5 | 4 mm |
| Cutting edge Ø D _c | 10 mm |
| No. of teeth Z | 5 |

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|--|---------------------------|
| Corner chamfer angle | 45 degrees |
| Shape | Flat |
| Feed f_z for side milling in steel < 900 N/mm ² | 0.05 mm |
| Chamfer mill | backwards and forwards 45 |
| 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 |

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|------------------------------|---|----------|-----------|
| 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 |