

**Garant**
**Solid carbide deburrer 90°, TiAlN, Ø h6 DC: 4mm**

**Order data**

Order number	208105 4
GTIN	4045197858733
Item class	11X

**Description**
**Version:**

Tolerance: **Dimension S = ±0.1 mm, point angle ±10 arc minutes.**

With special flute geometry for smooth cutting.

**Application:**

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

**Technical description**

No. of teeth Z	4
Feed $f_z$ in steel < 900 N/mm <sup>2</sup>	0.02 mm
Overall length L	54 mm
Dimension S	2.8 mm
Shank Ø $D_s$	4 mm
Cutting edge Ø $D_c$	4 mm
Shank	DIN 6535 HA with h6
Corner chamfer angle	45 degrees
Chamfer mill	45 degrees
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard

Type	N
Tolerance nominal $\varnothing$	h6
Direction of infeed	horizontal and oblique
Countersink tip angle	90 degrees
Through-coolant	no
Shank tolerance	h6
Colour ring	without
Type of product	Deburrers

### User data

	Suitability	$V_c$	ISO code
Aluminium (short chipping)	suitable	280 m/min	N
Alu > 10% Si	suitable	200 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	120 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	105 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	100 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	70 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	60 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	35 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	80 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	60 m/min	M
GG(G)	suitable	90 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