


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

Order data

Order number	208107 4
GTIN	4045197858818
Item class	12X

Description
Version:

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

Application:

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

Technical description

Feed f_z in steel < 900 N/mm ²	0.02 mm
Cutting edge Ø D_c	4 mm
Overall length L	50 mm
Shank	DIN 6535 HA with h6
No. of teeth Z	4
Dimension S	2.8 mm
Shank Ø D_s	4 mm
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 ²	suitable	120 m/min	P
Steel < 750 N/mm ²	suitable	105 m/min	P
Steel < 900 N/mm ²	suitable	100 m/min	P
Steel < 1100 N/mm ²	suitable	70 m/min	P
Steel < 1400 N/mm ²	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 ²	suitable	80 m/min	M
INOX > 900 N/mm ²	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