

**Garant**
**Solid carbide deburrer 60°, TiAlN, Ø h6 DC: 3mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 208135 3      |
| GTIN         | 4045197859044 |
| 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**

|  |                         |
|--|-------------------------|
| Shank Ø D <sub>s</sub>                               | 3 mm                    |
| Shank  | DIN 6535 HA with h6     |
| Cutting edge Ø D <sub>c</sub>                        | 3 mm                    |
| Feed f <sub>z</sub> in steel < 900 N/mm <sup>2</sup> | 0.01 mm                 |
| Overall length L                                     | 50 mm                   |
| Dimension S  | 2.9 mm                  |
| No. of teeth Z                                       | 3                       |
| Corner chamfer angle                                 | 60 degrees              |
| Chamfer mill   | 30 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           | 60 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 |