

Garant

Solid carbide forward / reverse deburring tool with helix angle, TiSiN, Ø DC: 4mm



Order data

Order number	208181 4
GTIN	4067263107422
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). Pointed 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

Corner chamfer angle	45 degrees
Overall length L	75 mm
Chamfer mill	backwards and forwards 45
No. of teeth Z	4
$L_2 + 0.5$	2.7 mm
Feed f_z for side milling in steel < 900 N/mm ²	0.03 mm
$\varnothing D_1 + 0.05$	2.9 mm
$L_4 + 0.5$	13 mm

Cutting edge $\varnothing D_c$	4 mm
Shape	Pointed
Shank $\varnothing D_s$	4 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	$0.25 \times L_2$ 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	suitable		