

**Garant**
**Solid carbide deburrer 120°, TiAlN, Ø h6 DC: 6mm**


## Order data

|              |               |
|--------------|---------------|
| Order number | 208092 6      |
| GTIN         | 4045197858504 |
| 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

|   |                         |
|---|-------------------------|
| Overall length L                            | 57 mm                   |
| No. of teeth Z                              | 4                       |
| Dimension S                                 | 3.4 mm                  |
| Feed $f_z$ in steel < 900 N/mm <sup>2</sup> | 0.03 mm                 |
| Cutting edge Ø D <sub>c</sub>               | 6 mm                    |
| Shank                                       | DIN 6535 HA with h6     |
| Shank Ø D <sub>s</sub>                      | 6 mm                    |
| Corner chamfer angle                        | 30 degrees              |
| Chamfer mill                                | 60 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           | 120 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<br><b>Services</b> | Suitable only under restricted conditions |
| Shank grinding Type HB | 129100 HB                                 |