

## Garant

### Solid carbide forward / reverse deburring tool, TiAlN, Ø DC: 9,8mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 208185 9,8    |
| GTIN         | 4062406131371 |
| Item class   | 11X           |

#### Description

##### Version:

##### Extra long shank.

Double ground head **with 45° angle.**

##### Application:

For **universal application** in virtually all materials. The newly developed coating **effectively prevents formation of built-up edges** – even in aluminium and stainless steel.

For **forward** and **reverse deburring** and **chamfering** even where access is difficult.

Particularly suitable for **contouring applications.**

#### Technical description

|  |                           |
|--|---------------------------|
| $L_4 +0.5$   | 31 mm                     |
| Shank Ø $D_s$  | 10 mm                     |
| Overall length L   | 100 mm                    |
| Shape  | flat                      |
| Cutting edge Ø $D_c$   | 9.8 mm                    |
| $L_2 +0.5$   | 4 mm                      |
| Corner chamfer angle   | 45 degrees                |
| Ø $D_1 +0.05$  | 6 mm                      |
| Feed $f_z$ for side milling in steel < 900 N/mm <sup>2</sup> | 0.014 mm                  |
| No. of teeth Z   | 5                         |
| Chamfer mill   | backwards and forwards 45 |

|   |                          |
|---|--------------------------|
| Coating                                   | TiAlN                    |
| Tool material                             | Solid carbide            |
| Standard                                  | Manufacturer's standard  |
| Type                                      | N                        |
| Tolerance nominal $\varnothing$           | $\pm 0.05$               |
| Countersink tip angle                     | 90 degrees               |
| Cutting width $a_e$ for milling operation | 0.25xL2 for side milling |
| Shank                                     | DIN 6535 HA to h6        |
| Through-coolant                           | no                       |
| Shank tolerance                           | h6                       |
| Colour ring                               | green                    |
| Type of product                           | Deburrers                |

## User data

|                                | Suitability                               | $V_c$     | ISO code |
|--------------------------------|---|-----------|----------|
| Aluminium (short chipping)     | suitable                                  | 125 m/min | N        |
| Alu > 10% Si                   | suitable                                  | 75 m/min  | N        |
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 70 m/min  | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 70 m/min  | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 45 m/min  | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 40 m/min  | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 35 m/min  | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 30 m/min  | M        |
| GG(G)                          | suitable                                  | 45 m/min  | K        |
| Uni                            | suitable                                  |           |          |
| wet maximum                    | suitable                                  |           |          |
| wet minimum                    | suitable only under restricted conditions |           |          |

|                 |          |
|-----------------|----------|
| dry             | suitable |
| Air             | suitable |
| <b>Services</b> |          |

|                        |           |
|------------------------|-----------|
| Shank grinding Type HB | 129100 HB |
|------------------------|-----------|