Garant

Solid carbide forward / reverse deburring tool with helix angle, TiSiN, ⌀ DC: 3,8mm

Order data

Order number	208181 3,8
GTIN	4067263107415
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

Overall length L	75 mm
Chamfer mill	backwards and forwards 45
L_2 +0.5	2.7 mm
Feed f_z for side milling in steel < 900 N/mm^2	0.03 mm
Cutting edge ⌀ D_C	3.8 mm
Shank ⌀ D_s	4 mm
⌀ D_1 +0.05	2.9 mm
No. of teeth Z	4

Corner chamfer angle	45 degrees
L_4 +0.5	13 mm
Shape	Pointed
Helix angle	5 degrees
Coating	TiSiN
Tool material	Solid carbide
Standard	Works standard
Type	N
Tolerance nominal ∅	±0.05
Countersink tip angle	90 degrees
Cutting width a_e for milling operation	0.25×L2 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/mm²	suitable	75 m/min	P
Steel < 750 N/mm²	suitable	75 m/min	P
Steel < 900 N/mm²	suitable	50 m/min	P
Steel < 1100 N/mm²	suitable	45 m/min	P
INOX < 900 N/mm²	suitable	40 m/min	M
INOX > 900 N/mm²	suitable only under restricted conditions	30 m/min	M

Ti > 850 N/mm²	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		