

Garant
Diabolo solid carbide deburrer, spiral flutes 90°, TiAlN, Ø h6 DC: 8mm

Order data

Order number	208158 8
GTIN	4062406288242
Item class	11X

Description
Version:

Deburrer specially developed for **hard machining**. The further development of the Diabolo coating permits even longer tool life and improved surface quality.

Tolerance: **Dimension S = ± 0.2 mm.**

Point angle = ±5 arc minutes.

Outstanding surface qualities thanks to the 35° **helix angle**.

Application:

Perfectly suitable for **chamfering** and **deburring** component edges and for **contouring applications**.

No. of teeth Z: 6

Shank: DIN 6535 HA to h6

Chamfer mill: 45 °

No. of teeth Z: 6

Dimension S: 5.6 mm

Overall length L: 63 mm

Shank Ø D_s: 8 mm

Feed f_z in steel < 60 HRC: 0.04 mm

Technical description

Series	Diabolo
Shank Ø D _s	8 mm
No. of teeth Z	6
Cutting edge Ø D _c	8 mm

Overall length L	63 mm
Shank	DIN 6535 HA to h6
Dimension S	5.6 mm
Chamfer mill	45 °
Corner chamfer angle	45 °
Feed f_z in steel < 60 HRC	0.04 mm
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Tolerance nominal \varnothing	h6
Helix angle	35 °
Direction of infeed	horizontal and oblique
Countersink tip angle	90 °
Through-coolant	no
Shank tolerance	h6
Colour ring	red
Type of product	Deburrers

User data

	Suitability	V_c	ISO code
Steel < 1100 N/mm ²	suitable only under restricted conditions	140 m/min	P
Steel < 1400 N/mm ²	suitable	120 m/min	P
Steel < 55 HRC	suitable	100 m/min	H
Steel < 60 HRC	suitable	90 m/min	H
Steel < 65 HRC	suitable	60 m/min	H
Steel < 67 HRC	suitable	35 m/min	H

wet minimum	suitable only under restricted conditions
dry	suitable
Air	suitable
Services	
Shank grinding Type HB	129100 HB