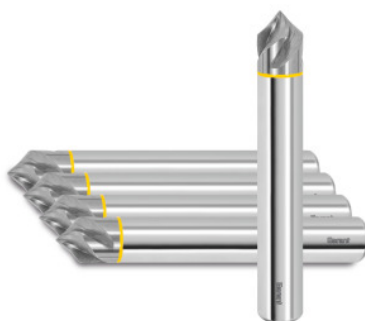


Garant**Value pack solid carbide deburrer spiral flutes 90°****Order data**

Order number	GG8154 4
GTIN	4067263090939
Item class	GGN

Description**Version:****Same as No. 208154.**

Deburrer with **polished flutes** and **sharp cutting edges** especially for machining aluminium and plastic.

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**.

Technical description

Overall length L	50 mm
Shank	DIN 6535 HA to h6
Dimension S	2.8 mm
No. of teeth Z	4
Feed f_z in PMMA acrylic	0.03 mm

Data sheet

Chamfer mill	45 degrees
Contents	5
Shank $\varnothing D_s$	4 mm
Feed f_z in short-chipping aluminium	0.03 mm
Cutting edge $\varnothing D_c$	4 mm
Coating	uncoated
Tool material	Solid carbide
Standard	Works standard
Type	N
Tolerance nominal $\varnothing$	h6
Helix angle	35 degrees
Direction of infeed	horizontal, oblique and vertical
Countersink tip angle	90 degrees
Through-coolant	no
Shank tolerance	h6
Colour ring	red
Type of product	Deburrers

User data

	Suitability	V_c	ISO code
Alu plastics	suitable	480 m/min	N
Aluminium (short chipping)	suitable	440 m/min	N
Alu > 10% Si	suitable	400 m/min	N
PMMA acrylic	suitable	210 m/min	N
PEEK	suitable	150 m/min	N
PVDF GF20	suitable	150 m/min	N
POM GF25	suitable	150 m/min	N
PA 66 GF30	suitable	150 m/min	N

Data sheet

PEEK GF30	suitable	130 m/min	N
PTFE CF25	suitable	160 m/min	N
Honeycomb sandwich	suitable	300 m/min	N
Cu	suitable	160 m/min	N
CuZn	suitable	200 m/min	N
wet maximum	suitable		

Suitable products

<https://www.hoffmann-group.com/GB/en/hom/p/GG8154-4>