

**Value pack solid carbide deburrer 90°****Order data**

Order number	GG8107 4
GTIN	4062406199609
Item class	GGN

Description**Version:**

Tolerance: **Dimension S** = ± 0.1 mm.

Same as No. 208107.

Application:

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

Technical description

No. of teeth Z	4
Corner chamfer angle	45 degrees
Cutting edge $\varnothing D_c$	4 mm
Feed f_z in steel < 900 N/mm ²	0.02 mm
Shank $\varnothing D_s$	4 mm
Dimension S	2.8 mm
Shank	DIN 6535 HA with h6
Overall length L	50 mm
Contents	5

Data sheet

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	90 degrees
Through-coolant	no
Shank tolerance	h6
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 ²	suitable	120 m/min	P
Steel < 750 N/mm ²	suitable	105 m/min	P
Steel < 900 N/mm ²	suitable	100 m/min	P
Steel < 1100 N/mm ²	suitable	70 m/min	P
Steel < 1400 N/mm ²	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 ²	suitable	80 m/min	M
INOX > 900 N/mm ²	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	Suitable only under restricted conditions

Suitable products

<https://www.hoffmann-group.com/GB/en/hom/p/GG8107-4>