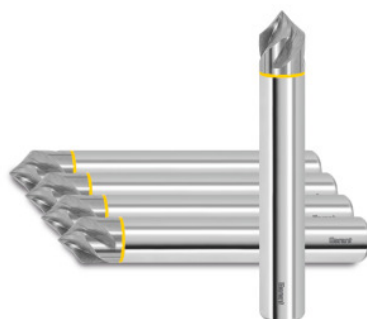


**Garant****Value pack solid carbide deburrer spiral flutes 90°****Order data**

|              |               |
|--------------|---------------|
| Order number | GG8154 0,5    |
| GTIN         | 4067263062189 |
| 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**

|                                                 |            |
|-------------------------------------------------|------------|
| Chamfer mill                                    | 45 degrees |
| Shank Ø D <sub>s</sub>                          | 3 mm       |
| Overall length L                                | 50 mm      |
| Dimension S                                     | 0.3 mm     |
| Feed f <sub>z</sub> in short-chipping aluminium | 0.01 mm    |

## Data sheet

|                                 |                                  |
|---------------------------------|----------------------------------|
| Feed $f_z$ in PMMA acrylic      | 0.01 mm                          |
| Cutting edge $\varnothing D_c$  | 0.5 mm                           |
| Shank                           | DIN 6535 HA to h6                |
| Contents                        | 5                                |
| No. of teeth Z                  | 3                                |
| 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/GG8154-0,5>