

Front/back deburrer - Metric



Tool material

Solid Carbide

Surface finish

nano-A™

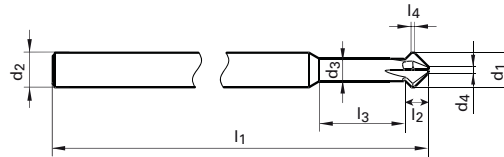
Series

495

Application group	Material examples	Ideal for
P	Steel	●
M	Stainless steel	●
K	Cast iron	●
N	Aluminum	●
S	Ni / Ti alloys	○
H	Hardened steel	○

●=Optimal ○=Secondary

Speed and Feed data shown below



This tool is capable of chamfering on both front and backside of tool.

d1	d2 h6	d3	d5	l1	l4	l3	l2	No. of Flutes	Code no.	EDP Number
mm	mm	mm	mm	mm	mm	mm	mm			
3.000	4.000	2.200	0.600	75.00	0.50	9.3	5.0	4	3.000	9004950030000
4.000	4.000	2.900	0.800	75.00	0.50	12.3	6.0	4	4.000	9004950040000
5.000	5.000	3.900	1.000	75.00	0.50	15.0	7.0	4	5.000	9004950050000
6.000	6.000	3.900	1.200	100.00	0.50	14.3	8.0	4	6.000	9004950060000
8.000	6.000	6.000	1.600	100.00	0.50		12.0	4	8.000	9004950080000
10.000	6.000	6.000	2.000	100.00	0.50		12.0	4	10.000	9004950100000
12.000	6.000	6.000	2.400	100.00	0.50		13.0	4	12.000	9004950120000

Speeds & Feeds - Chamfering milling cutters

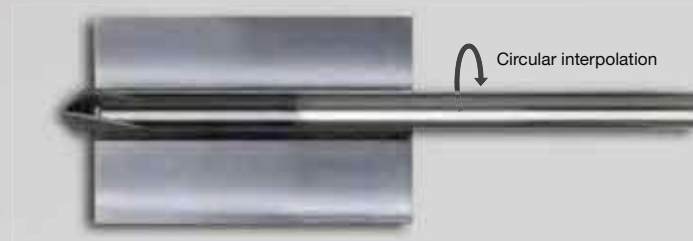
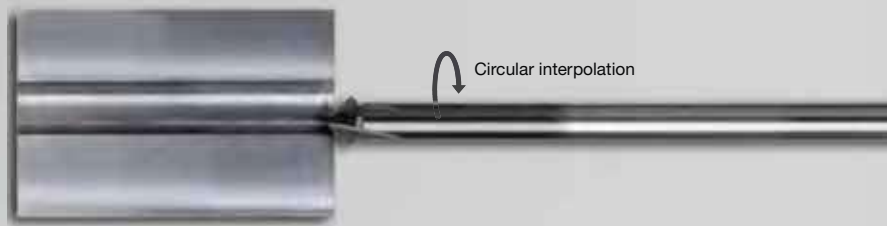
ISO	Hardness	SFM	Feed Rate IPT per Ø in (mm)						
			3	6	8	10	12	16	20
P	≤ 850 N/mm²	590	0.0031	0.0047	0.0079	0.0079	0.0098	0.0098	0.0098
	≥ 850 N/mm²	490	0.0024	0.0039	0.0059	0.0059	0.0079	0.0079	0.0079
M	≤ 750 N/mm²	330	0.0024	0.0039	0.0059	0.0059	0.0079	0.0079	0.0079
	≥ 750 N/mm²	260	0.0020	0.0031	0.0047	0.0047	0.0059	0.0059	0.0059
K	≤ 350 HB	395	0.0031	0.0047	0.0079	0.0079	0.0098	0.0098	0.0098
N	≤ 3% Si	655	0.0039	0.0059	0.0098	0.0098	0.0118	0.0118	0.0118
	> 3% Si	490	0.0031	0.0047	0.0079	0.0079	0.0098	0.0098	0.0098
S	≤ 850 N/mm²	195	0.0020	0.0031	0.0047	0.0047	0.0059	0.0059	0.0059
	≤ 1400 N/mm²	130	0.0016	0.0024	0.0039	0.0039	0.0047	0.0047	0.0047
H	< 55 HRC	330	0.0024	0.0039	0.0059	0.0059	0.0079	0.0079	0.0079
	≤ 63 HRC	130	0.0016	0.0020	0.0024	0.0024	0.0031	0.0031	0.0031

EW 100 VR Front/back deburring mill

Guhring's standard solid carbide EW 100 VR front/back deburring mill with TiAlN coating can be utilized for both deburring and chamfering the entry and exit of a hole with a 90° angle. The EW 100 VR is a milling cutter with cutting edges on the front and back face. To deburr or chamfer a part the tool performs a circular interpolation along the edge or contour of the hole or part profile.



EW 100 VR with 90° cutting edges at the front and rear



EW 100 VR