

## Garant

**GARANT Master Alu FEED solid carbide drill, plain shank DIN 6535 HA, uncoated, Ø DC h7: 7,8mm**



### Order data

|              |               |
|--------------|---------------|
| Order number | 122590 7,8    |
| GTIN         | 4062406711733 |
| Item class   | 11E           |

### Description

#### Version:

**3-cutter tool**, specially developed for use at **very high feed rates** in aluminium. Outstandingly suitable for machines with **high power consumption** and stable machining conditions.

- **Specially developed cutter geometry, designed for very high feed rates, reduced cutting pressure and controlled chip breaking.**
- **Precision flute profile for reliable evacuation of chips.**
- **Achieve outstanding feed rates and tool life thanks to the third cutting edge.**

The sector-leading technology of the drill point for the tool guarantees optimum self-centring behaviour and permits spot drilling on irregular surfaces. 3 guide chamfers guarantee a stable exit from the hole and an exact roundness of the hole.

#### Note:

Flute length  $L_c = L_2 + 1.5 \times D_c$ .

HB and HE shanks are available at the same price as HA.

For **HB**: use order **No. 122591**.

For **HE**: use order **No. 122590 + 129100HE**.

### Technical description

|                                    |              |
|------------------------------------|--------------|
| Flute length $L_c$                 | 53 mm        |
| Standard                           | DIN 6537     |
| Nominal Ø $D_c$                    | 7.8 mm       |
| Overall length L                   | 91 mm        |
| Feed f in aluminium short-chipping | 0.88 mm/rev. |

|  |                   |
|--|-------------------|
| Number of cutting edges Z                | 3                 |
| Tolerance nominal $\varnothing$          | h7                |
| Shank $\varnothing D_s$                  | 8 mm              |
| recommended maximum drilling depth $L_2$ | 41.3 mm           |
| Series                                   | Master Alu        |
| Coating                                  | uncoated          |
| Tool material                            | solid carbide     |
| Version                                  | 6xD               |
| Type                                     | W                 |
| Point angle                              | 130 degrees       |
| Shank                                    | DIN 6535 HA to h6 |
| Through-coolant                          | yes, with 25 bar  |
| Machining strategy                       | HPC               |
| Semi-Standard                            | yes               |
| Colour ring                              | yellow            |
| Type of product                          | Jobber drill      |

## User data

|                            | Suitability                               | $V_c$     | ISO code |
|----------------------------|---|-----------|----------|
| Alu plastics               | suitable                                  | 300 m/min | N        |
| Aluminium (short chipping) | suitable                                  | 250 m/min | N        |
| Alu > 10% Si               | suitable                                  | 200 m/min | N        |
| CuZn                       | suitable                                  | 200 m/min | N        |
| wet maximum                | suitable                                  |           |          |
| wet minimum                | suitable only under restricted conditions |           |          |

## Services

|                        |           |
|------------------------|-----------|
| Shank grinding Type HE | 129100 HE |
|------------------------|-----------|

