

## Garant

**GARANT Master Alu FEED solid carbide drill, plain shank DIN 6535 HA, uncoated, Ø DC h7: 8,4mm**



### Order data

Order number	122590 8,4
GTIN	4062406711764
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 $L_c$	61 mm
Nominal Ø $D_c$	8.4 mm
Tolerance nominal Ø	h7
Shank Ø $D_s$	10 mm
Standard	DIN 6537

recommended maximum drilling depth $L_2$	48.4 mm
Feed $f$ in aluminium short-chipping	0.92 mm/rev.
Number of cutting edges $Z$	3
Overall length $L$	103 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
------------------------	-----------

