

## Garant

### GARANT Master Alu FEED solid carbide drill, plain shank DIN 6535 HA, DLC, Ø DC h7: 6,4mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 122595 6,4    |
| GTIN         | 4062406719630 |
| Item class   | 11E           |

#### Description

##### Version:

**With DLC coating** – for longer tool lives, especially with aluminium with a higher Si content.

**Coating on order – no return.** Delivery time approx. 3 weeks if the basic item is available ex stock. **Please note the minimum order quantity.**

**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 shanks are available at the same price as HA.

For **HB**: use order **No. 122596**.

#### Technical description

|  |         |
|--|---------|
| Tolerance nominal Ø                      | h7      |
| recommended maximum drilling depth $L_2$ | 43.4 mm |
| Number of cutting edges Z                | 3       |
| Overall length L                         | 91 mm   |

|                                    |                   |
|------------------------------------|-------------------|
| Standard                           | DIN 6537          |
| Nominal $\varnothing D_c$          | 6.4 mm            |
| Shank $\varnothing D_s$            | 8 mm              |
| Feed f in aluminium short-chipping | 0.76 mm/rev.      |
| Flute length $L_c$                 | 53 mm             |
| Series                             | Master Alu        |
| Coating                            | DLC               |
| 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    |           |          |

