GARANT Master Alu FEED solid carbide drill, plain shank DIN 6535 HA, DLC, Ø DC h7: 9,8mm

Order data

Order number	122595 9,8
GTIN	4062406719807
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

recommended maximum drilling depth L_2	46.3 mm
Number of cutting edges Z	3
Standard	DIN 6537
Overall length L	103 mm

Shank ⌀ D_s	10 mm
Feed f in aluminium short-chipping	1.03 mm/rev.
Flute length L_c	61 mm
Tolerance nominal ⌀	h7
Nominal ⌀ D_C	9.8 mm
Series	Master Alu
Coating	DLC
Tool material	solid carbide
Version	6×D
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		