

Garant

GARANT Master Alu FEED solid carbide drill, Weldon shank DIN 6535 HB, DLC, Ø DC h7: 5,5mm



Order data

| | |
|--------------|---------------|
| Order number | 122596 5,5 |
| GTIN | 4062406724962 |
| 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 guidance lands guarantee a stable exit from the hole and an exact roundness of the hole.

Note:

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

Technical description

| | |
|--|--------------|
| Number of cutting edges Z | 3 |
| Feed f in aluminium short-chipping | 0.68 mm/rev. |
| Standard | DIN 6537 |
| recommended maximum drilling depth L_2 | 35.8 mm |
| Overall length L | 82 mm |

| | |
|---------------------------------|-------------------|
| Tolerance nominal \varnothing | h7 |
| Flute length L_c | 44 mm |
| Shank $\varnothing D_s$ | 6 mm |
| Nominal $\varnothing D_c$ | 5.5 mm |
| Series | Master Alu |
| Coating | DLC |
| Tool material | solid carbide |
| Version | 6xD |
| Type | W |
| Point angle | 130 degrees |
| Shank | DIN 6535 HB 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 | | |