

## Garant

### GARANT Master Alu FEED solid carbide drill, Weldon shank DIN 6535 HB, DLC, Ø DC h7: 6,9mm



#### Order data

Order number	122596 6,9
GTIN	4062406725099
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

Feed f in aluminium short-chipping	0.8 mm/rev.
Nominal Ø $D_c$	6.9 mm
Tolerance nominal Ø	h7
recommended maximum drilling depth $L_2$	42.7 mm
Number of cutting edges Z	3

Standard	DIN 6537
Shank $\varnothing D_s$	8 mm
Overall length L	91 mm
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 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		