

Garant

GARANT Master Alu FEED solid carbide drill, Weldon shank DIN 6535 HB, uncoated, Ø DC h7: 8,5mm



Order data

Order number	122591 8,5
GTIN	4062406724672
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 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

recommended maximum drilling depth L_2	48.3 mm
Flute length L_c	61 mm
Standard	DIN 6537
Overall length L	103 mm
Feed f in aluminium short-chipping	0.93 mm/rev.
Tolerance nominal \varnothing	h7
Nominal $\varnothing D_c$	8.5 mm

Number of cutting edges Z	3
Shank $\varnothing D_s$	10 mm
Series	Master Alu
Coating	uncoated
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 only under restricted conditions		