

**Garant**

**GARANT Master Alu FEED solid carbide drill, Weldon shank DIN 6535 HB, uncoated, Ø DC h7: 12mm**


**Order data**

Order number	122591 12
GTIN	4062406724788
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**

Standard	DIN 6537
recommended maximum drilling depth $L_2$	53 mm
Overall length $L$	118 mm
Flute length $L_c$	71 mm
Number of cutting edges $Z$	3
Shank $\varnothing D_s$	12 mm
Nominal $\varnothing D_c$	12 mm

Feed f in aluminium short-chipping	1.18 mm/rev.
Tolerance nominal Ø	h7
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 <sub>c</sub>	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		