

## Garant

**GARANT Master Alu FEED solid carbide drill, Weldon shank DIN 6535 HB, uncoated, Ø DC h7: 6,4mm**



### Order data

|              |               |
|--------------|---------------|
| Order number | 122591 6,4    |
| GTIN         | 4062406724542 |
| 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

|  |              |
|--|--------------|
| Flute length $L_c$                       | 53 mm        |
| Overall length $L$                       | 91 mm        |
| Shank $\varnothing D_s$                  | 8 mm         |
| Tolerance nominal $\varnothing$          | h7           |
| recommended maximum drilling depth $L_2$ | 43.4 mm      |
| Feed $f$ in aluminium short-chipping     | 0.76 mm/rev. |
| Number of cutting edges $Z$              | 3            |

|                           |                   |
|---------------------------|-------------------|
| Nominal $\varnothing D_c$ | 6.4 mm            |
| Standard                  | DIN 6537          |
| 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 |           |          |