

Garant

GARANT Master Alu FEED solid carbide drill, plain shank DIN 6535 HA, uncoated, Ø DC h7: 12,01-Xmm



Order data

| | |
|--------------|----------------|
| Order number | 122590 12,01-X |
| GTIN | 4062406754082 |
| 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 guide chamfers guarantee a stable exit from the hole and an exact roundness of the hole.

Note:

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

HB and HE shanks are available at the same price as HA.

For **HB**: use order **No. 122591**.

For **HE**: use order **No. 122590 + 129100HE**. Items made to order for a specific customer:

Cancellation only up to a maximum of 3 working days after receipt of order acknowledgement.

Items cannot be returned. We reserve the right to over-deliver or under-deliver by +/-10% (minimum 1 piece).

Delivery time: 10 weeks.

Minimum order quantity: 5 pieces.

Technical description

| | |
|------------------------------------|--------------|
| Feed f in aluminium short-chipping | 1.18 mm/rev. |
| Number of cutting edges Z | 3 |

| | |
|-----------------------------|-------------------|
| Standard | DIN 6537 |
| Ø range | 12.01 - 14 mm |
| Overall length L | 124 mm |
| Tolerance nominal Ø | h7 |
| Flute length L _c | 77 mm |
| Shank Ø D _s | 14 mm |
| Series | Master Alu |
| Coating | uncoated |
| Tool material | solid carbide |
| Version | 6×D |
| Type | W |
| Point angle | 130 degrees |
| Shank | DIN 6535 HA 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 | | |

Services

Shank grinding Type HE

129100 HE