Garant

GARANT Master Alu FEED solid carbide drill, Weldon shank DIN 6535 HB, uncoated, ∅ DC h7: 4,0-Xmm

Order data

Order number	122591 4,0-X
GTIN	4062406754105
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 $L_c = L_2 + 1.5 \times D_c$. 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

Flute length L_c	36 mm
Feed f in aluminium short-chipping	0.53 mm/rev.
Tolerance nominal ∅	h7
Standard	DIN 6537

Number of cutting edges Z	3
Shank Ø D$_s$	6 mm
Overall length L	74 mm
Ø range	4 - 4.7 mm
Series	Master Alu
Coating	uncoated
Tool material	solid carbide
Version	6×D
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		