

## Garant

**GARANT Master Alu FEED solid carbide drill, plain shank DIN 6535 HA, uncoated, Ø DC h7: 4mm**



### Order data

Order number	122590 4
GTIN	4062406710873
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  $L_c = L_2 + 1.5 \times D_c$ .

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**.

Standard: DIN 6537

Tolerance nominal Ø: h7

Number of cutting edges Z: 3

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 30 mm

Overall length L: 74 mm

Shank Ø  $D_s$ : 6 mm

Feed f in aluminium short-chipping: 0.53 mm/rev.

### Technical description

Shank $\varnothing D_s$	6 mm
Standard	DIN 6537
Nominal $\varnothing D_c$	4 mm
Overall length L	74 mm
Feed f in aluminium short-chipping	0.53 mm/rev.
Tolerance nominal $\varnothing$	h7
Number of cutting edges Z	3
Flute length $L_c$	36 mm
recommended maximum drilling depth $L_2$	30 mm
Series	Master Alu
Coating	uncoated
Tool material	solid carbide
Version	6xD
Type	W
Point angle	130°
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
<b>Services</b>	
Shank grinding Type HE	129100 HE