



Plain shank thread mill 2xD, TiAlN, M: M3



Order data

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|--------------|---------------|
| Order number | 139651 M3 |
| GTIN | 4045197773616 |
| Item class | 12J |

Description

Version:

Corrected thread profile for milling **exact internal threads** (ensure stable clamping conditions).

Technical description

| | |
|--|---------|
| Shank length L_s | 28 mm |
| No. of teeth Z | 2 |
| Thread pitch | 0.5 mm |
| Number of clamping slots | 2 |
| Overall length L | 42 mm |
| Shank $\varnothing D_s$ | 4 mm |
| Feed f_z in steel $< 900 \text{ N/mm}^2$ | 0.01 mm |
| Through-coolant | no |
| Thread depth | 6.25 mm |
| Thread size | M3 |
| Nominal $\varnothing D_c$ | 2.4 mm |
| Flute length L_c | 6.25 mm |
| Coating | TiAlN |
| Thread type | M |

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|----------------------------------|-----------------------------|
| Thread type | M-LH |
| Flank angle | 60 degrees |
| Tool material | Solid carbide |
| Thread standard | DIN 13 |
| Shank | DIN 6535 HA with h6 |
| Application for type of drilling | up to 2xD for blind holes |
| Application for type of drilling | up to 2xD for through holes |
| Colour ring | green |
| Internal/external application | Internal |
| Type of product | thread milling cutter |

User data

| | Suitability | V _c | ISO code |
|--------------------------------|---|----------------|----------|
| Alu plastics | suitable | 220 m/min | N |
| Aluminium (short chipping) | suitable | 220 m/min | N |
| Alu > 10% Si | suitable | 170 m/min | N |
| Steel < 500 N/mm ² | suitable | 170 m/min | P |
| Steel < 750 N/mm ² | suitable | 150 m/min | P |
| Steel < 900 N/mm ² | suitable | 120 m/min | P |
| Steel < 1100 N/mm ² | suitable only under restricted conditions | 80 m/min | P |
| INOX < 900 N/mm ² | suitable | 80 m/min | M |
| INOX > 900 N/mm ² | suitable | 60 m/min | M |
| Ti > 850 N/mm ² | suitable only under restricted conditions | 60 m/min | S |
| GG(G) | suitable | 120 m/min | K |
| CuZn | suitable | 180 m/min | N |
| Uni | suitable | | |
| wet maximum | suitable | | |

