



Plain shank thread mill 2×D, TiAlN, M: M4



Order data

Order number	139651 M4
GTIN	4045197777324
Item class	12J

Description

Version:

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

Technical description

Shank $\varnothing D_s$	6 mm
No. of teeth Z	3
Shank length L_s	36 mm
Overall length L	55 mm
Number of clamping slots	3
Thread pitch	0.7 mm
Feed f_z in steel < 900 N/mm ²	0.012 mm
Through-coolant	no
Thread depth	8.75 mm
Thread size	M4
Nominal $\varnothing D_c$	3.15 mm
Flute length L_c	8.75 mm
Coating	TiAlN
Thread type	M

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 2×D for blind holes
Application for type of drilling	up to 2×D 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		

Services

Shank grinding Type HE	129100 HE
Shank grinding Type HB	129100 HB