



## Plain shank thread mill 2×D, TiAlN, M: M6



### Order data

Order number	139651 M6
GTIN	4045197777348
Item class	12J

### Description

#### Version:

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

### Technical description

Number of clamping slots	3
No. of teeth Z	3
Shank $\varnothing D_s$	6 mm
Shank length $L_s$	36 mm
Thread pitch	1 mm
Overall length L	55 mm
Feed $f_z$ in steel < 900 N/mm <sup>2</sup>	0.02 mm
Through-coolant	no
Thread depth	12.5 mm
Thread size	M6
Nominal $\varnothing D_c$	4.8 mm
Flute length $L_c$	12.5 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 <sub>c</sub>	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 <sup>2</sup>	suitable	170 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	150 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	120 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable only under restricted conditions	80 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	80 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	60 m/min	M
Ti > 850 N/mm <sup>2</sup>	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 HB	129100 HB
Shank grinding Type HE	129100 HE