



Plain shank thread mill 2xD, TiAlN, MF: 6X0,75



Order data

Order number	139680 6X0,75
GTIN	4045197778246
Item class	12J

Description

Version:

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

Technical description

Thread pitch	0.75 mm
Overall length L	55 mm
No. of teeth Z	3
Number of clamping slots	3
Shank length L_s	36 mm
Shank $\varnothing D_s$	6 mm
Feed f_z in steel $< 900 \text{ N/mm}^2$	0.02 mm
Through-coolant	no
Thread depth	12.38 mm
Thread size	M6x0.75
Nominal $\varnothing D_c$	4.8 mm
Flute length L_c	12.38 mm
Coating	TiAlN
Thread type	MF

Thread type	MF-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		

Services

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