



Plain shank thread mill 2xD, TiAlN, MF: 8X1



Order data

Order number	139680 8X1
GTIN	4045197778253
Item class	12J

Description

Version:

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

Note:

HB and HE shanks are available at the same price as HA.

Order **HB** shank: with **No. 139680 + 129100 HB.**

Order **HE** shank: with **No. 139680 + 129100 HE.**

Technical description

Shank $\varnothing D_s$	6 mm
No. of teeth Z	3
Thread pitch	1 mm
Overall length L	60 mm
Number of clamping slots	3
Shank length L_s	36 mm
Feed f_z in steel $< 900 \text{ N/mm}^2$	0.035 mm
Through-coolant	yes
Thread depth	16.5 mm
Thread size	M8x1
Nominal $\varnothing D_c$	5.95 mm

Flute length L_c	16.5 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 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 HB			129100 HB
Shank grinding Type HE			129100 HE