



## Plain shank thread mill 2xD, TiAlN, MF: 12X1



### Order data

Order number	139680 12X1
GTIN	4045197778284
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

Number of clamping slots	4
Shank length $L_s$	40 mm
Thread pitch	1 mm
Shank $\varnothing D_s$	10 mm
Overall length $L$	75 mm
No. of teeth $Z$	4
Feed $f_z$ in steel $< 900 \text{ N/mm}^2$	0.04 mm
Through-coolant	yes
Thread depth	26.5 mm
Thread size	M12x1
Nominal $\varnothing D_c$	7.95 mm

Flute length $L_c$	26.5 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 <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		
<b>Services</b>			
Shank grinding Type HB			129100 HB
Shank grinding Type HE			129100 HE