



Plain shank thread mill 2xD, TiAlN, MF: 12X1,5



Order data

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| Order number | 139680 12X1,5 |
| GTIN | 4045197778291 |
| 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

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|--|---------|
| Number of clamping slots | 4 |
| Overall length L | 75 mm |
| Thread pitch | 1.5 mm |
| Shank length L _s | 40 mm |
| Shank Ø D _s | 10 mm |
| No. of teeth Z | 4 |
| Feed f _z in steel < 900 N/mm ² | 0.04 mm |
| Through-coolant | yes |
| Thread depth | 26.2 mm |
| Thread size | M12×1.5 |
| Nominal Ø D _c | 9.9 mm |

| | |
|----------------------------------|-----------------------------|
| Flute length L_c | 26.2 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 |