

Garant

Single tooth thread mill 3×D, TiAlN, M: M1



Order data

Order number	139615 M1
GTIN	4045197585783
Item class	11J

Description

Version:

Corrected thread profile for milling **exact internal threads**, (ensure stable clamping conditions). Very sturdy **single-tooth** thread mills, **highly suitable especially for GRP, CRP and graphite**. Also suitable for **Ti-based and Ni-based alloys** and **hardened steels up to 58 HRC**.

Advantage:

Significantly less radial pressure than with multi-tooth thread mills.

Note:

Single-tooth thread mill **exclusively** for **milling internal threads**. **The tapping hole (and where necessary the countersinking) has to be prepared beforehand!**

Because of the tooth profile only the thread nominal \varnothing (= size) with the corresponding thread pitch (see table) may be generated.

Through-coolant: no

No. of teeth Z: 1

Thread pitch: 0.25 mm

Nominal $\varnothing D_c$: 0.7 mm

Shank length L_s : 28 mm

Overhang L_1 : 3 mm

Overall length L: 39 mm

Shank $\varnothing D_s$: 3 mm

Technical description

Number of clamping slots	1
maximum insertion depth L_c	3 mm
Feed f_z in steel < 1400 N/mm ²	0.01 mm

Thread pitch	0.25 mm
No. of teeth Z	1
Shank $\varnothing D_s$	3 mm
Overall length L	39 mm
Feed f_z in CRP	0.02 mm
Shank length L_s	28 mm
Through-coolant	no
Thread depth	3 mm
Thread size	M1
Nominal $\varnothing D_c$	0.7 mm
Overhang L_1	3 mm
Coating	TiAlN
Thread type	M
Thread type	M-LH
Flank angle	60°
Tool material	Solid carbide
Thread standard	DIN 13
Shank	DIN 6535 HA with h6
Application for type of drilling	up to 3×D for blind holes
Application for type of drilling	up to 3×D for through holes
Shank tolerance	h6
Colour ring	green
Internal/external application	Internal
Type of product	thread milling cutter

User data

	Suitability	V_c	ISO code
Alu plastics	suitable	300 m/min	N

Aluminium (short chipping)	suitable	300 m/min	N
Alu > 10% Si	suitable	200 m/min	N
Steel < 500 N/mm ²	suitable	200 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	80 m/min	P
Steel < 1400 N/mm ²	suitable	60 m/min	P
Steel < 55 HRC	suitable	50 m/min	H
Steel < 60 HRC	suitable only under restricted conditions	30 m/min	H
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	50 m/min	S
GRP	suitable	100 m/min	N
CRP	suitable	100 m/min	N
Graphite	suitable	150 m/min	N
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		
dry	suitable		
Air	suitable		