Garant

Single tooth thread mill 2×D, TiAlN, M: M1,6

Order data

Order number	139610 M1,6
GTIN	4045197533876
Item class	11J

Description

Version:
Corrected thread profile for milling **exact internal threads** (ensure stable clamping conditions). Very sturdy **single-tooth** thread mill, **highly suitable especially for GRP, CRP, and graphite**. Also suitable for **Ti-based and Ni-based alloys** and **hardened steels up to 63 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!**

Technical description

No. of teeth Z	4
Feed f_z in steel < 1400 N/mm^2	0.01 mm
Thread pitch	0.35 mm
Number of clamping slots	4
maximum insertion depth L_C	4 mm
Shank ∅ D_s	3 mm
Overall length L	32 mm
Feed f_z in CRP	0.02 mm
Shank length L_s	18 mm
Through-coolant	no

Thread depth	3.2 mm
Thread size	M1.6
Nominal ∅ D_C	1.2 mm
Flute length L_c	0.35 mm
Overhang L_1	4 mm
Coating	TiAlN
Thread type	M
Thread type	M-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
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/mm²	suitable	300 m/min	P
Steel < 750 N/mm²	suitable	250 m/min	P
Steel < 900 N/mm²	suitable	200 m/min	P
Steel < 1100 N/mm²	suitable	100 m/min	P

Steel < 1400 N/mm²	suitable	80 m/min	P
Steel < 55 HRC	suitable	60 m/min	H
Steel < 60 HRC	suitable	40 m/min	H
Steel < 67 HRC	suitable only under restricted conditions	30 m/min	H
INOX < 900 N/mm²	suitable	100 m/min	M
INOX > 900 N/mm²	suitable	80 m/min	M
Ti > 850 N/mm²	suitable	60 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		