

**Garant**
**Drill thread milling cutter 2×D, TiAlN, M: M8**

**Order data**

Order number	139515 M8
GTIN	4045197081759
Item class	11J

**Description**
**Version:**

**Corrected thread profile** for milling **exact internal threads** (be sure to provide stable clamping conditions).

**Incorporating** a countersink profile for a 90° countersink.

A stronger core diameter, two narrow geometrically optimised chip flutes and a special drill point result in good chip formation and low cutting pressure.

**Advantage:**

**Drilling, countersinking and thread milling all with a single tool!**

Thread pitch: 1.25 mm

Hole  $\varnothing D_c$ : 6.45 mm

Cutter length  $l_c$ : 17.2 mm

Shank length  $L_s$ : 40 mm

Overall length L: 74 mm

Shank  $\varnothing D_s$ : 10 mm

**Technical description**

maximum countersink $\varnothing D_1$	8.3 mm
Number of clamping slots	2
Width of groove $e_1$	1.25 mm
Thread pitch	1.25 mm
Hole $\varnothing D_c$	6.45 mm
Programming value for countersink $l_1$	18.2 mm

Feed $f_z$ in cast aluminium	0.065 mm
Shank $\varnothing D_s$	10 mm
Overall length L	74 mm
Shank length $L_s$	40 mm
Thread depth	12
Thread size	M8
Cutter length $l_c$	17.2 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
Number of cutting edges Z	2
Through-coolant	yes
Application for type of drilling	up to 2xD for blind holes and through holes
Countersink angle	90 degrees
Shank tolerance	h6
Colour ring	without
Internal/external application	Internal
Type of product	thread milling cutter