

Garant
Drill thread milling cutter 1.5×D, TiAlN, M: M4

Order data

Order number	139510 M4
GTIN	4045197081667
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: 0.7 mm

Hole $\varnothing D_c$: 3.24 mm

Cutter length l_c : 6.8 mm

Shank length L_s : 36 mm

Overall length L : 47 mm

Shank $\varnothing D_s$: 6 mm

Technical description

Programming value for countersink l_1	7.3 mm
Feed f_z in cast aluminium	0.03 mm
Hole $\varnothing D_c$	3.24 mm
Width of groove e_1	0.7 mm
Thread pitch	0.7 mm
Number of clamping slots	2

maximum countersink $\varnothing D_1$	4.3 mm
Shank $\varnothing D_s$	6 mm
Overall length L	47 mm
Shank length L_s	36 mm
Thread depth	6
Thread size	M4
Cutter length l_c	6.8 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 1.5xD 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