

Garant
Plain shank thread mill 1.5×D, TiAlN, M: M6

Order data

Order number	139652 M6
GTIN	4045197199652
Item class	11J

Description
Version:

Corrected thread profile for milling **exact internal threads** (ensure stable clamping conditions).

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

Advantage:

Countersinking and thread milling in one operation!

Technical description

No. of teeth Z	4
Feed f_z in steel < 60 HRC	0.012 mm
Number of clamping slots	4
Thread pitch	1 mm
Shank $\varnothing D_s$	8 mm
Overall length L	59 mm
Shank length L_s	36 mm
Through-coolant	no
Thread depth	9.56 mm
Thread size	M6
Nominal $\varnothing D_c$	4.68 mm
Flute length L_c	9.56 mm

Programming value for countersink L ₁	10.2 mm
Neck Ø D ₁	6.6 mm
Coating	TiAlN
Thread type	M-LH
Thread type	M
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 1.5×D for through holes
Application for type of drilling	up to 1.5×D for blind holes
Countersink angle	90 degrees
Shank tolerance	h6
Colour ring	red
Internal/external application	Internal
Type of product	thread milling cutter

User data

	Suitability	V _c	ISO code
Steel < 1400 N/mm ²	suitable only under restricted conditions	30 m/min	P
Steel < 55 HRC	suitable	35 m/min	H
Steel < 60 HRC	suitable	30 m/min	H
Steel < 65 HRC	suitable only under restricted conditions	27 m/min	H
Steel < 67 HRC	suitable only under restricted conditions	25 m/min	H
dry	suitable		

