

**Garant**
**Plain shank thread mill 1.5×D, TiAlN, M: M8**

**Order data**

Order number	139652 M8
GTIN	4045197199669
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**

Feed $f_z$ in steel < 60 HRC	0.015 mm
Number of clamping slots	4
Thread pitch	1.25 mm
No. of teeth Z	4
Shank $\varnothing D_s$	10 mm
Overall length L	70 mm
Shank length $L_s$	40 mm
Through-coolant	no
Thread depth	13.24 mm
Thread size	M8
Nominal $\varnothing D_c$	6.22 mm
Flute length $L_c$	13.24 mm

Programming value for countersink L <sub>1</sub>	14.1 mm
Neck Ø D <sub>1</sub>	9 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 <sub>c</sub>	ISO code
Steel < 1400 N/mm <sup>2</sup>	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		

