

Garant
Plain shank thread mill 1.5×D, TiAlN, M: M10

Order data

Order number	139652 M10
GTIN	4045197199676
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	0.017 mm
Thread pitch	1.5 mm
Number of clamping slots	5
No. of teeth Z	5
Shank $\varnothing D_s$	12 mm
Overall length L	74 mm
Shank length L_s	45 mm
Through-coolant	no
Thread depth	15.91 mm
Thread size	M10
Nominal $\varnothing D_c$	7.79 mm
Flute length L_c	15.91 mm

Programming value for countersink L ₁	16.9 mm
Neck Ø D ₁	11 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		

