

Garant
Plain shank thread mill 1.5×D, TiAlN, M: M16

Order data

Order number	139652 M16
GTIN	4045197200006
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!

Through-coolant: no

No. of teeth Z: 5

Thread pitch: 2 mm

Nominal $\varnothing D_C$: 12.82 mm

Flute length L_C : 25.27 mm

Shank length L_S : 48 mm

Overall length L: 94 mm

Shank $\varnothing D_S$: 18 mm

Technical description

Feed f_z in steel < 60 HRC	0.02 mm
Thread pitch	2 mm
Number of clamping slots	5
No. of teeth Z	5
Shank $\varnothing D_S$	18 mm
Overall length L	94 mm

Shank length L_s	48 mm
Through-coolant	no
Thread depth	24 mm
Thread size	M16
Nominal $\varnothing D_c$	12.82 mm
Flute length L_c	25.27 mm
Programming value for countersink L_1	26.5 mm
Neck $\varnothing D_1$	17.5 mm
Coating	TiAlN
Thread type	M-LH
Thread type	M
Flank angle	60°
Tool material	Solid carbide
Thread standard	DIN 13
Shank	DIN 6535 HA with h6
Application for type of drilling	up to 1.5xD for through holes
Countersink angle	90°
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		