Garant

Drill thread milling cutter 1.5×D, TiAlN, M: M5

Order data

Order number	139511 M5
GTIN	4062406393120
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. A stronger core diameter, two narrow geometrically optimised chip flutes and a special drill point result in good chip formation and low cutting pressure. **Internal coolant feed.**
Advantage:
Drilling, countersinking and thread milling all with a single tool!
Note:
HB and HE shanks are available at the same price as HA.
HB shank: order with No. **139511**+ **12900 HB**.
HE shank: order with No. **139511**+ **12900 HE**.

Technical description

Thread depth	7.5
Thread pitch	0.8 mm
Overall length L	54 mm
Feed f_z in cast aluminium	0.04 mm
Shank ∅ D_s	6 mm
Thread size	M5
Cutter length l_c	8.6 mm
Number of clamping slots	2

Width of groove e_1	0.8 mm
Shank length L_s	36 mm
Cutting edge ∅ D_C	4.1 mm
Programming value for countersink L_1	9.35 mm
Neck ∅ D_1	5.5 mm
Through-coolant	yes
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
Number of cutting edges Z	2
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	without
Internal/external application	Internal
Type of product	Combination drill / thread mill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable	220 m/min	N
Alu > 10% Si	suitable	220 m/min	N
GG(G)	suitable only under restricted conditions	120 m/min	K

CuZn	suitable	330 m/min	N
wet maximum	suitable		

Services

Shank grinding Type HB	129100 HB
Shank grinding Type HE	129100 HE