

Garant
Drill thread milling cutter 1.5×D, TiAlN, M: M12

Order data

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|--------------|---------------|
| Order number | 139511 M12 |
| GTIN | 4062406393168 |
| 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

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|------------------------------|---------|
| Width of groove e_1 | 1.75 mm |
| Overall length L | 90 mm |
| Feed f_z in cast aluminium | 0.08 mm |
| Number of clamping slots | 2 |
| Thread size | M12 |
| Shank length L_s | 48 mm |
| Thread pitch | 1.75 mm |
| Cutter length l_c | 20.4 mm |

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|---|---------------------------------|
| Shank $\varnothing D_s$ | 14 mm |
| Thread depth | 18 |
| Cutting edge $\varnothing D_c$ | 9.74 mm |
| Programming value for countersink L_1 | 22.26 mm |
| Neck $\varnothing D_1$ | 13.5 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 1.5xD for through holes |
| Application for type of drilling | up to 1.5xD 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 | |