

Garant**Drill thread milling cutter 1.5×D, TiAlN, M: M3****Order data**

Order number	139511 M3
GTIN	4062406393243
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.

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

Shank Ø D _s	6 mm
Number of clamping slots	2
Thread pitch	0.5 mm
Overall length L	54 mm
Shank length L _s	43 mm
Width of groove e ₁	0.5 mm
Feed f _z in cast aluminium	0.03 mm
Thread size	M3

Cutter length l_c	4.9 mm
Thread depth	4.5
Cutting edge $\varnothing D_c$	2.45 mm
Programming value for countersink L_1	5.36 mm
Neck $\varnothing D_1$	4.5 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 HE		129100 HE	