

Garant
Drill thread milling cutter 2×D, TiAlN, M: M4

Order data

Order number	139516 M4
GTIN	4062406393182
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 shank: order with No. **139516 + 12900 HB.**

HE shank: order with No. **139516 + 12900 HE.**

HB and HE shanks are available at the same price as HA.

Technical description

Shank $\varnothing D_s$	6 mm
Thread depth	8
Cutter length l_c	8.9 mm
Width of groove e_1	0.7 mm
Thread pitch	0.7 mm
Thread size	M4
Feed f_z in cast aluminium	0.03 mm
Overall length L	54 mm

Number of clamping slots	2
Shank length L_s	40 mm
Cutting edge $\varnothing D_c$	3.24 mm
Programming value for countersink L_1	9.5 mm
Neck $\varnothing D_1$	4.5 mm
Through-coolant	yes
Coating	TiAlN
Thread type	M
Thread type	M-LH
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 2xD for blind holes
Application for type of drilling	up to 2xD for through 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
Shank grinding Type HB	129100 HB