

**Garant**
**Drill thread milling cutter 2×D, TiAlN, M: M8**

**Order data**

Order number	139516 M8
GTIN	4062406393212
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**

Thread depth	16
Shank $\varnothing D_s$	10 mm
Width of groove $e_1$	1.25 mm
Cutter length $l_c$	17.3 mm
Thread pitch	1.25 mm
Overall length L	74 mm
Number of clamping slots	2
Feed $f_z$ in cast aluminium	0.065 mm

Thread size	M8
Shank length $L_s$	40 mm
Cutting edge $\varnothing D_c$	6.45 mm
Programming value for countersink $L_1$	18.5 mm
Neck $\varnothing D_1$	9 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 2×D for blind holes
Application for type of drilling	up to 2×D 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		
<b>Services</b>			
Shank grinding Type HB		129100 HB	
Shank grinding Type HE		129100 HE	