Garant

Drill thread milling cutter 2×D, TiAlN, M: M6

Order data

Order number	139516 M6
GTIN	4062406393205
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 size	M6
Cutter length l_c	13.7 mm
Thread pitch	1 mm
Shank length L_s	40 mm
Feed f_z in cast aluminium	0.05 mm
Overall length L	62 mm
Width of groove e_1	1 mm
Number of clamping slots	2

Thread depth	12
Shank ⌀ D_s	8 mm
Cutting edge ⌀ D_C	4.85 mm
Programming value for countersink L_1	14.6 mm
Neck ⌀ D_1	6.6 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		

Services

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