

**Garant**
**Drill thread milling cutter 2×D, TiAlN, M: M10**

**Order data**

Order number	139516 M10
GTIN	4062406393229
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 length $L_s$	45 mm
Feed $f_z$ in cast aluminium	0.065 mm
Width of groove $e_1$	1.5 mm
Number of clamping slots	2
Thread depth	20
Cutter length $l_c$	22.15 mm
Thread size	M10
Thread pitch	1.5 mm

Overall length L	80 mm
Shank $\varnothing D_s$	12 mm
Cutting edge $\varnothing D_c$	8.08 mm
Programming value for countersink $L_1$	23.68 mm
Neck $\varnothing D_1$	11 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		
<b>Services</b>			
Shank grinding Type HE		129100 HE	
Shank grinding Type HB		129100 HB	