

**Garant**
**End cutting thread mill 2xD, TiAlN, G: G1/4**

**Order data**

Order number	139523 G1/4
GTIN	4062406653743
Item class	11J

**Description**
**Version:**

Tool for **combined production** of bore, chamfer and thread **in a single work step**. Pre-drilling is no longer required. The innovative centre cutting edge geometry makes this tool a specialist in thread production in **hardened and hard-to-machine materials**. The **TiAlN high-performance coating** ensures the longest possible **tool life**, especially in hardened steels **up to 67 HRC**. All tools have left-hand cutting and are suitable for **right-hand and left-hand threads**.

**Application:**

For **Whitworth parallel pipe threads** DIN-ISO 228/1 (threads that do not form a seal within the connections).

**Note:**

**Always use with cooling lubricant emulsion.** (Fat content min 8%). In the case of steels **>45 HRC** can only be used with **compressed air!**

Through-coolant: yes

Thread pitch: 1.337 mm

Threads per inch: 19

Cutting edge  $\varnothing D_c$ : 9.8 mm

Cutter length  $l_c$ : 4.5 mm

Overhang  $L_1$ : 30 mm

Shank length  $L_s$ : 40.5 mm

**Technical description**

Thread pitch	1.337 mm
Shank length $L_s$	40.5 mm
Feed $f_z$ in steel < 65 HRC	0.01 mm

Overhang $L_1$	30 mm
Thread depth	30
Thread size	G1/4
Cutter length $l_c$	4.5 mm
Shank $\varnothing D_s$	10 mm
Overall length L	72 mm
Programming radius	4.9 mm
Number of clamping slots	4
Neck $\varnothing D_1$	7.74 mm
Cutting edge $\varnothing D_c$	9.8 mm
Threads per inch	19
Through-coolant	yes
Coating	TiAlN
Thread type	G
Thread type	BSP
Flank angle	55 °
Tool material	Solid carbide
Shank	DIN 6535 HA with h6
Number of cutting edges Z	4
Application for type of drilling	up to 2×D for through holes
Application for type of drilling	up to 2×D for blind holes
Countersink angle	90 °
Cutting direction	left-hand
Shank tolerance	h6
Internal/external application	Internal
Type of product	Combination drill / thread mill

## User data

	Suitability	$V_c$	ISO code
--	-------------	-------	----------

Steel < 1100 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 55 HRC	suitable	45 m/min	H
Steel < 60 HRC	suitable	40 m/min	H
Steel < 65 HRC	suitable	35 m/min	H
Steel < 67 HRC	suitable	30 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	60 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	60 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	45 m/min	S
wet maximum	suitable		
Air	suitable		

### Services

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