

Garant
End cutting thread mill 2xD, TiAlN, G: G1/16

Order data

Order number	139523 G1/16
GTIN	4062406653729
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: 0.91 mm

Threads per inch: 28

Cutting edge $\varnothing D_c$: 5.8 mm

Cutter length l_c : 3.2 mm

Overhang L_1 : 18 mm

Shank length L_s : 37.8 mm

Technical description

Programming radius	2.9 mm
Shank length L_s	37.8 mm
Cutting edge $\varnothing D_c$	5.8 mm

Overall length L	57 mm
Neck $\varnothing D_1$	4.39 mm
Feed f_z in steel < 65 HRC	0.01 mm
Number of clamping slots	4
Thread depth	18
Thread pitch	0.91 mm
Overhang L_1	18 mm
Shank $\varnothing D_s$	6 mm
Thread size	G1/16
Cutter length l_c	3.2 mm
Threads per inch	28
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
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Steel < 1100 N/mm ²	suitable	90 m/min	P
Steel < 1400 N/mm ²	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 ²	suitable	60 m/min	M
INOX > 900 N/mm ²	suitable	60 m/min	M
Ti > 850 N/mm ²	suitable	45 m/min	S
wet maximum	suitable		
Air	suitable		

Services

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