

Garant

GARANT Diabolo solid carbide end cutting thread mill 2xD, TiAlN, G: G1/4



Order data

Order number	139527 G1/4
GTIN	4067263118107
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 63 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!**

HB and HE shanks are available at the same price as HA.

Order **HB** shank: with **No. 139527 + 129100 HB**.

Order **HE** shank: with **No. 139527 + 129100 HE**.

Technical description

Through-coolant	yes
Threads per inch	19
Shank $\varnothing D_s$	10 mm
Number of clamping slots	4
Cutting edge $\varnothing D_c$	9.8 mm
Feed f_z in steel < 65 HRC	0.01 mm

Neck $\varnothing D_1$	7.74 mm
Cutter length l_c	4.5 mm
Shank length L_s	40.5 mm
Thread depth	30
Thread size	G1/4
Programming radius	4.9 mm
Thread pitch	1.337 mm
Overhang L_1	30 mm
Overall length L	72 mm
Coating	TiAlN
Thread type	BSP
Thread type	G
Flank angle	55 degrees
Tool material	Solid carbide
Shank	DIN 6535 HA with h6
Number of cutting edges Z	4
Application for type of drilling	up to $2 \times D$ for through holes
Application for type of drilling	up to $2 \times D$ for blind holes
Countersink angle	90 degrees
Cutting direction	left-hand
Shank tolerance	h6
Internal/external application	Internal
Type of product	Drill thread milling cutters

User data

	Suitability	V_c	ISO code
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 only under restricted conditions	35 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